Micronax 250-00 DEV

PRODUCT DESCRIPTION

MICRONAX 250-00 DEV *is a high solids Microsphere adhesive. It is designed for direct coating via Mayer rod, slot-die or gravure methods. AGITATE BEFORE USING AT MODERATE SPEED WITH APPROPRIATE AIR MIXER.*

PHYSICAL PROPERTIES

Polymer Type: *Acrylic*
Protective System: *Surfactant Stabilized*
Viscosity (cps): *350-1650 cps RVF #2/20/77°F*
Percent Solids: *40.5% – 43.3%*
pH: *8.0 – 9.5*
Freeze/Thaw Stability: *Unstable*
Weight Per Gallon: *8.35*
Color: *Off White*
Shelf Life: *3 Months (Unopened)*

PERFORMANCE PROPERTIES

A 0.5 mil dry film of MICRONAX 250-00 DEV cast directly onto 1 mil thickness polyester film will exhibit the following average performance properties when tested on #304 stainless steel, which has a #3 surface finish.

Test	***Typical Values***
180° Peel Adhesion[1]	*100 grams*
Loop Tack[2]	*136 grams*

FDA Compliance: *21CFR 175.105*

1 Franklin International 03QC5002, 30 minute dwell.
2 Franklin International 03QC5004, 1 square inch contact, 1 second dwell.

The data provided in this Technical Data Sheet represents typical physical and/or performance values for the product under a given set of testing conditions. The ranges or values are not specifications. Specifications will be set based on statistical analysis of measurements made by the Quality Control Laboratory on production material and will accurately reflect production capabilities. This data should be used as a guide for product selection only.

Important Notice to Purchaser: Our recommendations, if any, for use of this product are based on tests believed to be reliable. The greatest care is exercised in the selection of our materials and in our manufacturing operations. However, we make no recommendation to use this product in any manner which conflicts with existing laws and/or patents and WE MAKE NO WARRANTIES, EXPRESS OR IMPLIED, REGARDING THIS PRODUCT OR ITS USE, INCLUDING MERCHANTABILITY AND FITNESS FOR PARTICULAR PURPOSE, THE MANUFACTURER IS NOT LIABLE FOR ANY CONSEQUENTIAL, INCIDENTAL OR SPECIAL DAMAGES OF ANY KIND. Revised 03/09/12

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Franklin Adhesives & Polymers

Wood Adhesives
Pressure Sensitive Adhesives
Specialty Polymers

Technical Information Sheet 81507

Pressure Sensitive Adhesives
Determining Developmental Products' Specification Ranges

This Technical Information Sheet reviews how specification ranges are created for new developmental adhesives and polymers (labeled as "DEV") from initial production through commercialization (removal from DEV status).

Franklin utilizes the Stage Gate Process for developing new polymers and adhesive formulations. Customer requirements are entered into the initial stage of the process. During the developmental process, lab and pilot samples are normally created and tested by Franklin technical personnel as well as by the customer for approval. These samples are experimental (EXP) batches and range in quantity from a quart to a 2250 lb. tote.

In order for the EXP product to move to Franklin production, three replicated lab and/or pilot batches are made. From these batches, target ranges are calculated using 3 Sigma limits and are incorporated into Franklin's QC and Production System, creating a DEV product.

Once eight consecutive production batches are made without changes to the formulation or process, the product specifications are set based on these batches, the product is no longer developmental and the DEV designation is removed.

In most cases, target ranges will change from initial production batches through the commercialization process. Often this results in a broadening of the specification ranges. The customer is notified of these changes.

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