



SERICARD CDA

Laminating Adhesives CDA02, CDA10 and CDA20

A range of press ready adhesives used for overprinting or roller-coating offset inks in the manufacture of laminated credit cards. All adhesives achieve excellent bond strength and a secure edge bleed lamination. They can be used over most conventional or UV curing offset inks.

Printing Stocks

CDA02 and CDA10 are waterbased, screenprintable adhesives with good screen stability and self solvency.

CDA20 is a solvent based adhesive, developed for application by a roller coater. The adhesives are specifically designed for use with PVC stocks normally used in credit card production. However, owing to variations in these materials, printers should satisfy themselves that suitable printing, laminating and other performance are obtained before commencing production runs.

All prints must be fully dried before stacking. A cooling unit at the end of the hot air dryer will result in optimal blocking resistance

Laminating

Most typical lamination schedules may be successfully used to laminate CDA02, CDA10 and CDA20.

The minimum recommended laminating temperature is around 140°C for about 10 minutes @ 1700 PSI.

Poor bond strength may result if this recommendation is not observed.

Note: Applying more adhesive does not automatically give better bond strength

Availability

CDA02 and CDA10 Sericard CD Laminating Adhesive.
Available in 5 ltr containers

CDA20 Sericard CD Laminating Adhesive
Available in 15 ltr containers.

Safety and Handling

Sericard CD:

- Is formulated to be free from any (toxic) carcinogenic, mutagenic or reprotoxic chemicals
- Is formulated free from lead and other heavy metals and therefore should comply to the EN71-3:1995 Toy Safety Standard.
- Should be stored away from heat and between 5-30°C.
- Shelf life is up to 12 months.

Comprehensive information on the safety and handling of Sericard CDA Laminating adhesives is given in the appropriate Sericol Safety Data Sheets, available on request.

Environmental Information

Sericard CD:

- Does not contain ozone depleting chemicals as described in the Montreal Convention.
- Are formulated free from aromatic hydrocarbons which are known to have an adverse effect on the environment
- (CDA02 and CDA10) are water-based and therefore considerably reduces any adverse effect on solvents on the environment

Main Characteristics

Finish

Clear, Satin Adhesive

Drying

Jet drying:

@ 50-60°C for 15-20 seconds

Thinning

All products are supplied press-ready.

If necessary CDA02 and CDA10 can be thinned with up to 5% water.

Cleaning

CDA02 and CDA10: Wet adhesive: Water
Dried in residues: Serisolve MC (OA- D54)

Wash-up

Xtend Screenwash and Cleaners

Mesh

77-120PW.

Stencil Recommendation

For printing CDA02 and CDA10, stencils must be resistant to solvent and water

Recommend: Sericol Dirasol 915

Coverage

CDA02 40-45m²/ltr using a 120.34PW Mesh
CDA10 35-40m²/ltr using a 120.34PW Mesh
CDA20 4-6g/m² applied unthinned with a roller coater

Applications

Over dried offset prints for Credit Card manufacture

Colour Range

Transparent Adhesive

IMPORTANT: Stir well before every use

The information and recommendations contained in this Product Information sheet, as well as technical advice otherwise given by representatives of our Company, whether verbally or in writing, are based on our present knowledge and believed to be accurate. However, no guarantee regarding their accuracy is given as we cannot cover or anticipate every possible application of our products and because manufacturing methods, printing stocks and other materials vary. For the same reason our products are sold without warranty and on condition that users shall make their own tests to satisfy themselves that they will meet fully their particular requirements. Our policy of continuous product improvement might make some of the information contained in this Product Information sheet out of date and users are requested to ensure that they follow current recommendations.

SERICOL
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