

**TL 4421** • Low Modulus 2K Solvent-Borne Adhesive

**KEY FEATURES** (*Thermoset with suitable crosslinker*)

- Superior flexibility
- High bond strength and durability
- Low energy cure
- Clear, color stable composition
- Oil, water and solvent resistant

**DESCRIPTION & USES**

A low modulus, two component solvent based adhesive offering the ultimate balance of soft hand and bond durability. Supplied as a medium viscosity solution in fast evaporating solvents, TL 4421 dries readily to an aggressively tacky film finding wide utility in the production of high performance, flexible laminates employing such diverse webs as natural and synthetic fabrics, leather, plastic and elastomeric films, paper and foil.

**PHYSICAL PROPERTIES**

<i>Product as Supplied</i>	
<b>Appearance</b>	Straw-colored liquid
<b>Odor</b>	Ester
<b>Solids content (wt %)</b>	42% ±1%
<b>Viscosity</b>	4000 cps @70°F ±1000
<b>Product Density</b>	7.83 lbs/ gal

<i>As Adhesive System</i> <sup>1</sup>	
<b>Pot life, hours</b> <sup>2</sup>	6+
<b>Cure response @150°F</b>	<10 minutes
<b>MVTR, gm/m<sup>2</sup>/ 24 hour</b> <sup>3</sup>	838 upright cup
<sup>1</sup> TL 4421 + 2.1 pph C63 crosslinking agent solution	
<sup>2</sup> Taken as time required to double initial viscosity	
<sup>3</sup> Free film of approximately 1.0 oz/ yd <sup>2</sup>	

**APPLICATION**

Prior to use, add the desired level of crosslinking agent C 63 to an amount of adhesive sufficient to do the job within the estimated useful pot life (see above). Perform the addition with both components at or below 80° F and blend thoroughly under mild agitation to ensure product uniformity without unnecessary heat build up. We recommend 2.1 weight parts of C 63 Crosslinking agent solution to each 100 weight parts of TL 4421.

Apply the adhesive mixture via reverse roll, knife over roll, direct roll, floating knife, spray or meyer rod methods. Once coated, best results are obtained by driving off the solvent component under sub-cure conditions (i.e. 1 - 2 minutes @ 150° F), followed by “nipping in” the second substrate. The resultant laminate will subsequently cure at ambient conditions within 24 to 48 hours in most cases.

**HANDLING & STORAGE**

Store this product between 40 - 100°F, away from all sources of ignition. For best results, mix well before using. Avoid prolonged or repeated contact with the skin and use with adequate ventilation. Consult the SDS supplied with this product before handling.

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