

# ADD UNITED

## Addcross 1590

Maleic Anhydride Grafted Polyethylene Adhesive

### Product Description

Addcross 1590 is an anhydride modified polyethylene extrudable adhesive resin. It has been designed to develop a strong chemical bond with fusion bonded primers as well as top coat in three layer PE coating system. It has high thermal stability and good flexibility. It is intended for design temperature -40 to +80

The Addcross 1590 meets applicable requirements given below:

- ISO 21809-1                      - DIN 30670                      - IPS-G-TP-335

General			
Features	• Clean/High Purity	• Good Adhesion	• Excellent Process ability
Uses	• Coating Applications		
Appearance	• Natural		
Forms	• Pellets		
Packaging	• 25 Bags on pallet or 500kg big bags		
Processing Method	• Extrusion		

Physical	Nominal Value	Unit	Test Method
Density	930	kg/m <sup>3</sup>	ISO 1183-Method A
Melt Mass-Flow Rate (190°C/2.16 kg)	1.8 ±0.3	g/10 min	ISO 1133-Method B
Durometer Hardness (Shore D)	54	1s	ISO 868
Moisture	< 0.1	%	ISO 15512

Mechanical	Nominal Value	Unit	Test Method
Tensile Stress at Break (50 mm/min) (23 °C)	> 20.0	MPa	ISO 527
Tensile Stress at Yield (50 mm/min) (23 °C)	>12	%	ISO 527
Tensile Strain at Break (50 mm/min) (23 °C)	> 750	%	ISO 527
Peel strength( 3 layer) (23 °C)	>400	N/cm	DIN 30670

Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	105	°C	ISO 306/A50/10N
Brittleness Temperature	< -70	°C	ASTM D746
Melting point (DSC)	129	°C	ISO 11357-3
Oxidation Induction Time (210°C)	>30	min	ISO 11357-6

### Extrusion

As a guide the following temperature profile is recommended:

Zone 1	Zone 2	Zone 3	Zone 4	Head	Die	Melt Temp
160	170	180	185	190	200	210-220

### Storage & Shelf life

Bags should be stored in dry/closed condition at temperature below 50 °C and protected from UV /direct sunlight

Shelf life at proper storage is at least 18 month from production date, but in case of a long storage time potential moisture pick-up needs to be eliminated by drying before extrusion.

### Note

- Test results have been achieved in lab condition. Miss handling may give different result and sometimes outside of the standard
- The specifications given are the guidelines only.
- Above compound is suitable to run on different machines; however some adjustments may be required on individual machine.
- The customers are advised to check the quality, prior to commercial use. There is no guarantee and/or warrantee what so ever, after processing

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