

**General description**

VAC-TAC 330 is a very clean spraying adhesive with up to 9 minutes open time, It provides instant, very high, tack yet allows the reinforcement materials to be re-positioned until they are pushed firmly onto the adhesive.

VAC-TAC 330 exhibits a very long tack life and the highest tack level of the other VAC-TAC range. VAC-TAC330 is recommended for the most demanding dry lay-up processes.

Fully compatible with all matrix chemistries (polyester, vinyl ester, epoxy) and fibres (glass, carbon, aramid) in the market.

**Technical characteristics**

Adhesive type: Synthetic polymer based hotmelt  
 Colour: Red  
 Molten tack: Very high

	12mm	15mm	43mm	CT	Bulk
Form			43mm x 43mm		
Sticks per kilo (approx)			18		
Carton quantity			10kg		
Pallet weight:			500kg		
Suggested application temperature			180-195°C		
Brookfield viscosity (POW-12-VISC) spindle 27			2300 cPs		
Ring & ball softening point (ASTM E28)			84°C		
Heat resistance (BS5350 Part H3)			75°C		
Open time			Long		
Low temperature flexibility (tg)			10°C		

*F.D.A. approved. All the constituent parts of this adhesive have been approved by the American F.D.A. under C.F.R. 21.175.105 (adhesives) (subject to limitations).*

VAC-TAC® Reference	Description	12mm	15mm	43mm	CT	Bulk
100	Off white, near invisible. Up to 5 minutes open time, very fast aggressive tack.			●		
101	Off white, near invisible. Up to 5 minutes open time, very fast aggressive tack. Improved spray characteristics			●		
200	Amber. Up to 5 minutes open time. Higher output than VAC-TAC® 100, very aggressive tack.			●		
201	Amber. Up to 5 minutes open time. Higher output than VAC-TAC® 100, very aggressive tack. Improved spray characteristics			●		
342-12-300	Fast setting, instant grab adhesive. Feed and vacuum pipes. Template assembly	●				

## VAC-TAC® Spray adhesive.

VAC-TAC® hotmelt spray adhesives have been specially formulated for use with vacuum infused composites, to position and secure reinforcement materials during lay-up. They are applied to one surface only using our VAC-TAC® spray tools, where, for up to 5 minutes, they provide an instant, very high 'grab' adhesive surface. Once attached, the reinforcement materials can still be easily repositioned if required – only once they have been firmly pushed together is the final adhesive bond made.

An additional benefit when using VAC-TAC® adhesives is that there is no waste. Any unused adhesive left in the tool at the end of the job simply re-melts when the tool is next switched on and can continue to be used in the normal way.

Unlike VOC (volatile organic compound) spray adhesives, VAC-TAC® has an indefinite shelf life and does not require any special packaging, transportation or storage. VAC-TAC® also does not have any of the health and contamination problems normally associated with airborne particles from these other adhesives.

Our VAC-TAC® adhesives are solvent and water-free.

- |                           |                                  |                              |
|---------------------------|----------------------------------|------------------------------|
| ➤ Higher instant tack     | ➤ No waste                       | ➤ No shelf-life              |
| ➤ No storage problems     | ➤ Lower costs                    | ➤ Solvent free               |
| ➤ Better for the operator | ➤ No waste can disposal problems | ➤ Better for the environment |

**Storage** Store in a clean dry place at temperatures between 5°C and 30°C with boxes closed. Do not expose to direct sunlight or localised heat sources such as radiators or hot pipes.

**Removal of glue** Assembled components can be separated by heating assembly to a temperature slightly above the heat resistance figure.

EVA & Polypropylene: Residues of EVA and polypropylene based hotmelts can be removed from components with white spirit.

Polyamide: Residues of polyamide based hotmelt can be removed from components with acetone.

PUR: Prior to cross linking adhesive can be removed with white spirit or ketone. Once fully cross linked the adhesive cannot be easily removed.

**Please note** The information contained on this data sheet is for guidance only. It is the result of careful laboratory evaluations by trained and qualified staff using British Standard or similar test methods. However, no warranty is expressed or implied regarding the accuracy of the data or the suitability of the adhesive for any specific purpose. In every case, we strongly recommend that the user shall make their own test to determine to their own satisfaction the suitability of the adhesive for their particular purpose. Neither the seller nor manufacturer shall be liable for any injury, loss, damage, direct or consequential arising out of the use or inability to use the product. Further information is always available to help solve your adhesive problems. Should you require any further information on our adhesives please contact your nearest distributor.