

# 3082 Credit Card Adhesive Laminating Adhesive

## Technical Data Sheet

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**Credit Card Adhesive 3082** is an advanced technology, water-based adhesive that is used to overprint on dried offset prints and inks in the manufacture of laminated credit cards.

- Excellent bond even with edge to edge lamination
- Can be used over most offset inks
- Good screen stability
- Fast drying
- May be washed up with water when wet
- Good printing and drying properties

**Substrates:** Credit card PVC

### USER INFORMATION

**Mesh:** 77-120 Mesh/cm monofilament polyester is recommended for most applications.

**Stencil:** Recommended:  
6061-002 Water Resistant Emulsion  
6050-106 Screen Hardener

**Squeegee:** 60-85 durometer hardness polyurethane squeegees.

**Coverage:** 40-45 M<sup>2</sup>/Kilo (120 Mesh/cm) depending upon ink deposit.

**Pre-Production Test:** Always pretest adhesion and application before each production run, as there can often be significant differences between substrates from different manufacturers and even between different batches of substrates. Pretest to determine optimum printing performance for a particular set of ink, substrate, screen press, and drying variables/conditions.

**Printing:** Stir well before every use.  
Thinning: 3082 is supplied ready for use and may be printed at the viscosity supplied. If thinning needed, up to 5% water may be added.

**Offset Inks:**  
Although most Conventional and UV cured offset inks may be successfully over-printed and laminated, printers should ensure complete compatibility before starting a production run. Care should be taken to avoid laminating multiple coats of offset inks, internal weakness in these inks may lead to poor laminated bond strength.

**Drying:** Drying – A dwell time of 15-20 seconds should be allowed when jet drying at 50-60°C. Air drying time is 3-5 minutes.

**Laminating:** Most typical lamination schedules may be successfully used to laminate 3082. The minimum recommended laminating temperature is around 140°C for about 10 minutes @ 1700PSI. Poor bond strength may result if this recommendation is not observed.  
Note: Applying more adhesive does not automatically give better bond strength.

**Wash-up:** Wet adhesive is readily washed up with water. Dried residues may be removed with 4050-003.

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### GENERAL INFORMATION

#### Handling & Storage:

- **Credit Card Adhesive 3082** is formulated free of lead and other heavy metals
- It is recommended to wear suitable protective gear such as glasses and gloves. Take particular care to avoid splashes into the eyes and skin contact. If the ink comes in contact with skin, wash with soap and plenty of water. If ink comes in contact with eyes, wash with plenty of water and consult with a doctor.
- Comprehensive information on the safety and handling of **Smiley 3082** screen inks and thinners is given in the appropriate Smiley Material Safety Data Sheet (MSDS), which are available upon request.
- Store tightly covered at temperatures between (18° - 25°C). Can be stored for 1 year under these conditions.
- Tins should be kept tightly closed when not in use.

#### Environmental Information:

- Do not contain ozone depleting chemicals.
- **Credit Card Ink 3082** should be disposed properly (see MSDS) and in accordance to local regulations to avoid contamination.

#### Recommended Stencil Making Products:

- Screen Preparation
  - Mesh Preparation 6050-300 – for abrasion
  - Mesh Degreaser 6050-200 – for degreasing
- Screen Emulsion
  - Diazo Textile Emulsion 6061-002
  - Screen Hardener 6050-106
- Screen Cleaning
  - Ghost Remover 6070-100
  - Stain Remover 6070-001
- Screen Reclaiming
  - Stripping Powder 6070-200

### PRODUCT OFFERING:

#### Packaging:

**3082 is available in 1 Kilo, 5 Kilos and 20 Kilos containers.**

### ADDITIONAL INFORMATION

For additional product information, please visit our website at <http://www.smiley.co.th>. For further information, please contact SPS personnel at [medhi@smiley.co.th](mailto:medhi@smiley.co.th).

Thank you for choosing **SMILEY**.

Smiley Printing Solution Co., Ltd. (SPS), abides by the quality of this product. The information and recommendations that embody this Technical Data Sheet along with the technical advice are based solely on our knowledge and therefore confident to be precise. This product has been specifically formulated for screen printing. SPS cannot guarantee the precision for other possible application for the reason that manufacturing methods and other materials vary. Any liability amalgamated with the use and application of these products, users are the sole bearer of responsibility for choosing appropriate product for end-users' requirement. This Technical Data Sheet is provided for the technical purpose in the usage of this product and users are expected to follow current recommendation.

20/22 Moo 4 Theparak Rd., Bangpre Yai, Bangpre, Samutprakarn 10540, Thailand.

TEL : 662-757-4769, 662-757-4729 FAX : 662-757-4769

[www.smiley.co.th](http://www.smiley.co.th) ■ Email: [medhi@smiley.co.th](mailto:medhi@smiley.co.th)