

Product Specifications

:: LSV1234

AQUASEAL - Heat Seal Overprint Varnish

LSV1234 – Aquaseal heat seal coating overprint varnish is water-based varnish, suggested for evaluation in certain visual carded packaging applications. LSV1234 provides thin coating film to give fiber tearing bonds to rigid vinyl blisters. LSV1234 has been formulated for in-line wet trapping applications over blister grade offset & UV inks.

Technical Information / Typical Properties

Printing process:	Flexographic, roller coating.
Viscosity:	20 - 30 secondes Zahn # 2
Anilox:	Roll coat.
Coating Weight:	0.182 kg - 0.228 kg dry / 93 meter square Wet ink coating weight 0.455 kg - 0.57 kg / 93 meter square
Reducer:	Ready to use. Water if required (start with 1% or 2% only)
Drying:	55°C sheet temp. minimum (with air flow).
Stacking:	Cool below 35°C to stack.
Defoamer:	The use of an additional defoamer is normally not required.
Clean Up:	Warm water with liquid detergent while wet. Toluol or ammoniated water if dry.

Typical dry film properties	
Gloss (using 60° meter)	25% - 30%
(1) Bond interface temp.	
Minimum	60° C
Optimum	130° C
(2) Starting Heat Seal Schedule (indirect)	
Temperature	141 - 151° C
Dwell	3 seconds
Pressure	60 psi
(3) Starting Heat Seal Schedule (direct)	
Temperature	161 - 181° C
Dwell	1.5 seconds
Pressure	60 psi

- (1) **Bond interface temperature** is the temperature required at the sealing area between the blister film and the board stock.
- (2) **These seal conditions** are only suggested as a starting point. Variations in any of the variables may be required. All bonds should be thoroughly tested.

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Outstanding Characteristics

- ◆ Solvent free, water base.
- ◆ Aggressive fiber tearing bonds.
- ◆ Excellent hot tack.
- ◆ Good gloss.
- ◆ Smooth, non-grab finish.
- ◆ Medium temperature seal

Typical Applications

- ◆ **LSV1234 – Aquaseal heat seal coating overprint varnish** is suggested for evaluation as a heat seal coating for blister packaging applications providing a viable alternative to solvent systems, resulting in lower VOC emissions.

Shelf-Life/Storage

- ◆ Avoid storage periods exceeding six (6) months. Store at temperatures above 4°C. Storage below this temperature may cause damage. Best storage temperatures are between 16°C and 20°C. Lower temperatures can cause increased viscosity of a temporary nature. After storage at a low temperatures. Allow product to warm up to room temperature before agitating or using. Stir before use.

Product Safety

- ◆ Read the Material Safety Data Sheet (MSDS) before using this product.

Substrates

- ◆ Paperboard

CAUTION

1) In blister packaging, exact heat sealing conditions will vary according to the type and gauge of plastic film or base stock, depending on whether sealing is direct (through the film) or indirect (through the board). Oriented blister films require rather precise control of temperatures, cycling, etc, to prevent distortion and disruption of the bond. The blister flange should be adequate to provide the needed contact area. Cold formed blisters require additional coating weight. Blister grade board and ink must be used in order to obtain fiber tearing bonds.

2) Many products (specially hot melts, aqueous and reactive systems) degrade rapidly if exposed to copper brass, black iron, or aluminium. Utilize stainless steel application and storage equipment where such sensitivity is noted as a product characteristic.

3) MIX WELL BEFORE USE TO ACHIEVE PROPER PERFORMANCE.

4) Storage of these products for periods exceeding 6 months should be avoided, rotate stock first in-first-out basis.