

## TEST PROCEDURE GUIDELINES

<b>TEST METHODS: ADHESIVE UNIFORMITY</b>
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### *PURPOSE OF PROCEDURE:*

To determine if adhesive coating is uniformly applied to substrate.

*Note:* This *does not* indicate amount of adhesive only the presence thereof.

For adhesive amount, refer to *Applied Adhesive Coating Weight*@procedure.

### *DEFINITION OF TERMS:*

*Adhesive Uniformity:* This term refers to the coverage of adhesive on the substrate, where no areas that are unintentionally void of adhesive are void.

### *EQUIPMENT/MATERIALS NEEDED:*

Paper and Some Films:

1. Water based marker
2. Tissue
3. 10 to 30 Power magnifier

Paper and Film, visual only :

1. UV Black light
2. Dark enclosure for UV light

### *TEST PROCEDURE:*

A. For Solvent Based Adhesive Coatings Applied with Gravure Cylinder

1. Paper and several films
  - a. Position label adhesive side up.
  - b. Using a water soluble marker, mark over the area being inspected.
  - c. Wipe over marked area with tissue, removing excess marker fluid.
  - d. Examine with magnifier.
  - e. Marker will be absorbed where there is no adhesive.
2. Film
  - a. Use 30 Power magnifier to examine surface of film to detect coating.
  - b. Some clear films can be tilted toward a light source in an effort to detect a haziness, which indicates the presence of a coating.

*ADHESIVE UNIFORMITY (cont'd)*

- B. For Applied Adhesive Coatings with Optical Brightener Added to Coating
  - 1. Paper and Film
    - a. Position labels adhesive side up in dark area with UV light on.
    - b. Compare fluorescence of coated side of labels to non-coated piece of same material. Due to the fluorescent nature of many materials the adhesive coating may be brighter than, or not as bright as the substrate.
- C. For Applied Adhesive Coatings with Tinting Added
  - 1. Visual Only, Paper and Film
    - a. Position labels adhesive side up and inspect. Non-tinted areas would indicate no adhesive coverage. Variation in shades of tinting may indicate improper mixing of tint into the coating.

*DOCUMENTATION:*

The allowable tolerance that is agreed upon by the customer should be in written specifications provided by the customer.

The frequency of the test to be performed must also be agreed upon by the customer. That is to say that the customer should provide in his specification how often the test is to be done and by what form of sampling method, (random or non-random). These will be used to record results.

Many customers will require representative samples to be kept in inventory to reference in the event that the customer finds a defect in the provided order. This frequency of these retains should also be specified to ensure compliance.

*REFERENCES:*