



**WISDOM ADHESIVES TECHNICAL BULLETIN  
CLEARBOND™ HOT MELT ADHESIVES**

As part of Wisdom Adhesives overall strategic plan to continue on it's path as the leading customer focused adhesive supplier in the industry, Wisdom Adhesives announces the introduction of a new & improved ClearBond™ Hot Melt adhesive technology for the Packaging Industry. Key features of the product line are listed below:



- ClearBond adhesives offer excellent adhesion properties.
- ClearBond adhesives offer excellent thermal & pot-stability – best in adhesive industry.
- Clear / White in color.
- ClearBond adhesives offer increased mileage due to lower density and higher performance – often resulting in a minimum of a 35% reduction to the overall cost vs. standard competitive products.
- Eliminate downtime and maintenance costs.
- Eliminate gels and charring.
- Low to no odor.
- Economical – from an extended mileage, performance and density standpoint. Compares favorably vs. competitive EVA and other olefin based adhesive products. Up to 35% savings!
- Extended runability – excellent pot stability.
- New technology is easy to run and easy to use. Just another reason to convert to Wisdom Adhesives.

**Typical Specifications for ClearBond Adhesives**

Property	H5002 (High Temperature / High Performance Product)	H5001 (High Temperature / Higher Performance Product)	H5008 (High Temperature / Higher Heat Resistant Product)	H5004LT (Low Temperature Application Product)
Type	General Purpose High Heat Resistance	Specialty Adhesive for Enhanced Adhesion	High Heat Resistant Product	General Purpose Freezer Grade
Suggested Application Temperature	325F-350F	350F	350F	250F – 275F
Viscosity	800 cps at 350F	1100 cps at 350F	1100 cps at 350F	800 cps at 275F
Color	White/Clear	White/Clear	White/Clear	White/Clear
Speed of Set	Fast	Fast	Fast	Medium-Fast
Heat Resistance	Excellent	Excellent	Excellent	Moderate
Freezer Resistance	Moderate	Good	Good	Excellent
Density (Specific Gravity)	0.91	0.91	0.91	0.91

Note: Specifications are determined using standard laboratory tests based on ASTM or other similar protocol and are subject to the actual product technical data sheet.

The information given above is based on our best knowledge, and is believed to be true and accurate. No guaranty of accuracy is made. It is the purchaser's responsibility before using any product to verify this data under their own operating conditions and to determine whether the product is suitable for their purposes. Please read the entire product bulletin along with our conditions of sale, which apply to all goods supplied by us. Wisdom Adhesives assumes no responsibility for the use of these statements, recommendations or suggestions, nor do we intend them as a recommendation for any use, which would infringe any patent or copyright.



**Comparison of Hot Melt Adhesives**

Product	Technology	% Solids	Performance Characteristics	Cost Applied	Estimated Cost Savings
<b>H5002 (General Purpose)</b>	<b>ClearBond</b>	100%	Excellent adhesion, Extended Mileage, Very fast set-up, Excellent runability, very low maintenance cost, low odor. Excellent Pot Stability	Up to 35% lower vs. Market Rate Based on Mileage	<b>Up to 25% vs. Market Rate</b>
<b>H5001 (Enhanced Adhesion)</b>	<b>ClearBond</b>	100%	Excellent adhesion, Extended Mileage, Very fast set-up, Excellent runability, very low maintenance cost, low odor. Excellent Pot Stability	Up to 35% lower vs. Market Rate Based on Mileage	<b>Up to 25% vs. Market Rate</b>
<b>H50028 (Enhanced Heat Resistance)</b>	<b>ClearBond</b>	100%	Excellent adhesion, Extended Mileage, Very fast set-up, Excellent runability, very low maintenance cost, low odor. Excellent Pot Stability	Up to 35% lower vs. Market Rate Based on Mileage	<b>Up to 25% vs. Market Rate</b>
<b>H5004LT (Low Temperature Applicable)</b>	<b>ClearBond</b>	100%	Excellent adhesion, Extended Mileage, Very fast set-up, Excellent runability, very low maintenance cost, low odor. Excellent Pot Stability	Up to 35% lower vs. Market Rate Based on Mileage	<b>Up to 25% vs. Market Rate</b>
Competitive Hot Melt Adhesive	Conventional Hot Melt Technology	100%	Good-Excellent adhesion, fast set-up, Moderate-Good runability and clean-up.	Market Rate	Market Rate

Note: The above results are based on actual field information. Results may vary depending on type of finished product being made and process conditions. Cost comparison may vary depending on actual pricing.

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### THERMAL STABILITY

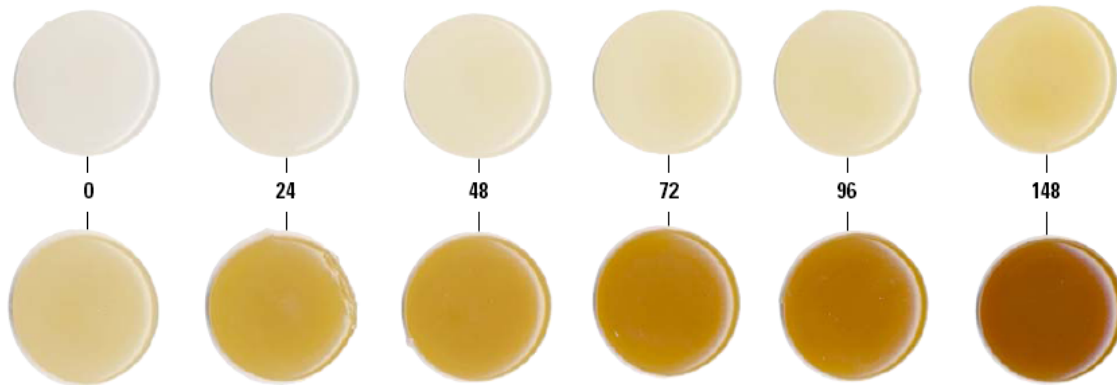
**Improved Mileage:** ClearBond Technology can be expected to save 25-50% advantage in mileage based on superior aggressive adhesion technology (lowering bead size) and lower density not factored above in savings example (0.93 vs. 0.97); both resulting in the use of less adhesive usage vs. EVA based technology.

**Better Thermal Pot Stability:** Please see the images below; indicating the color change of ClearBond type technology vs. EVA based technology when held for hours/days at application temperatures. This better pot stability will result in longer pot-life for less waste, wider service temperature range, reduced downtime and maintenance costs and adherence to a wider range of surfaces. **No downtime!**

#### Comparison of ClearBond Hot Melts – Top vs. Conventional Hot Melts - Bottom

Figure 4: Color change at 350°F (177°C) for 148 Hours

HMA formulated with AFFINITY GA POPs - hours at 350°F (177°C)



HMA formulated with EVA technology - hours at 350°F (177°C)



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