~~We claim:~~CLAIMS

1. A solvent-based pressure sensitive adhesive formulation comprising:

a polymer ~~comprising~~ having a glass transition temperature from -40°C to -10°C and comprising the polylmerized residues of:

a. a vinyl acetate monomer, wherein the vinyl acetate monomer is present at a level of 10 to 15 wt.% based on the total weight of the polymer;

b. an acrylic ester monomer~~,~~ ; and

~~a.~~c. 5 wt% to 40 wt%, based on the total weight of the polymer, of a monomer having a hydroxyl or amine functionality;

a solvent, wherein the solvent comprising 14 wt.% of toluene and 56 wt.% of ethyl acetate, based on the total weight of the solvent-based pressure sensitive adhesive formulation;; and

a crosslinker;

wherein the polymer is present at a level of 15 to 45 wt.%, based on the total weight of the solvent-based pressure sensitive formulation and wherein the polymer has a polydispersity index from 1 to 10;

wherein the crosslinker is present at a level of 0.05 to 0.17 wt.%, based on the total weight of the solvent-based pressure sensitive formulation;

wherein the pressure sensitive adhesive formulation releases less than 2000 ng/cm^2 outgas as measured according to ASTM E 595 (1993); and

wherein the acrylic ester monomer is present at a level of 10 to 40 wt.%, based on the total weight of the polymer.

~~2. The formulation of claim 1, wherein the polymer has a glass transition temperature from -40 to -10°C.~~

~~3.~~2. The solvent-based pressure sensitive adhesive formulation of ~~any of the preceding claims~~claim 1, wherein the polymer has at least of one of: a weight average molecular weight from 25,000 to 400,000 g/mol or a number average molecular weight from 25,000 to 400,000 g/mol.

~~4.~~3. The ~~formulation of any of the preceding claims, wherein the polymer has a number average molecular weight from 25,000 to 400,000 g/mol~~solvent-based pressure sensitive

adhesive formulation of claim 1, wherein the polymer comprises less than 5 wt.% of methacrylate monomers.

~~5. The formulation of any of the preceding claims, wherein the polymer has a polydispersity index from 1 to 10.~~

~~6. The formulation of any of the preceding claims, wherein the polymer is present from 10 to 60 wt.%, based on the total weight of the formulation.~~

~~7. The formulation of any of the preceding claims, wherein the polymer comprises from 10 to 90 wt.% polyvinyl acetate monomer, based on the total weight of the polymer.~~

~~8. The formulation of any of the preceding claims, wherein the polymer comprises from 10 to 40 wt.% acrylic ester monomer, based on the total weight of the polymer.~~

~~9. The formulation of any of the preceding claims, wherein the polymer comprises from 5 to 50 wt.% monomer having a hydroxyl or amine functionality, based on the total weight of the polymer.~~

~~10. The formulation of any of the preceding claims, wherein the crosslinker is present from 0.05 to 5 wt.%, based on the total weight of the formulation.~~

~~11. The formulation of any of the preceding claims, wherein the solvent is present from 40 to 90 wt.%, based on the total weight of the formulation.~~

~~12. A solvent-based pressure sensitive adhesive comprising a polymer and a crosslinker, wherein the polymer comprises a vinyl acetate monomer, an acrylic ester monomer, and a monomer having a hydroxyl or amine functionality; and~~

~~further wherein the adhesive release less than 2000 ng/cm^2 outgas as measured according to ASTM E 595 (1993).~~

~~13. The adhesive of claim 12, wherein the polymer has a glass transition temperature from -40 to -10°C.~~

~~14. The adhesive of any of claims 12-13, wherein the polymer has a weight average molecular weight from 25,000 to 400,000 g/mol.~~

~~15. The adhesive of any of claims 12-14, wherein the polymer has a number average molecular weight from 25,000 to 400,000 g/mol.~~

~~16. The adhesive of any of claims 12-15, wherein the polymer has a polydispersity index from 1 to 10.~~

~~17. The adhesive of any of claims 12-16, wherein the polymer comprises from 10 to 90 wt.% polyvinyl acetate monomer, based on the total weight of the polymer.~~

~~18. The adhesive of any of claims 12-17, wherein the polymer comprises from 10 to 40 wt.% acrylic ester monomer, based on the total weight of the polymer.~~

~~19. The adhesive of any of claims 12-18, wherein the polymer comprises from 5 to 50 wt.% monomer having a hydroxyl or amine functionality, based on the total weight of the polymer.~~

~~20. The adhesive of any of claims 12-19, wherein the crosslinker is present from 0.05 to 5 wt.%, based on the total weight of the adhesive.~~

~~21.~~4. A label comprising:

a film and

a pressure sensitive adhesive layer formed of the solvent-based pressure sensitive adhesive formulation of claim 1~~any of claims 12-20~~.

~~22.~~5. The label of claim ~~21~~4, wherein the pressure sensitive adhesive layer has a coating weight from 5 to 60 gsm.

~~23. The label of any of claims 21-22, wherein the adhesive release less than 2000 ng/cm^2 outgas as measured according to ASTM E 595 (1993).~~

~~24. A method for producing a pressure sensitive adhesive layer, the method comprising:~~

~~providing a solvent, a crosslinker, and a polymer comprising a vinyl acetate monomer, an acrylic ester monomer, and a monomer having a hydroxyl or amine functionality;~~

~~mixing the solvent, crosslinker, and polymer to form an adhesive formulation; and~~

~~coating the formulation to form the pressure sensitive adhesive layer.~~

~~25. The method of claim 24, wherein the formulation is coated onto a film.~~

~~The method of any of claims 24-25, wherein the adhesive layer has a coating weight from 5 to 60 gsm.~~