CLAIMS

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

a polymer 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
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 solvent-based pressure sensitive adhesive formulation of 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.

3. The solvent-based pressure sensitive adhesive formulation of claim 1, wherein the polymer comprises less than 5 wt.% of methacrylate monomers.

4. A label comprising:

a film and

a pressure sensitive adhesive layer formed of the solvent-based pressure sensitive adhesive formulation of claim 1.

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