

## MONZA COAT SB GENERAL PERFORMANCE SOLVENT BASE ADHESIVE (MONZA SBG A + MONZA SBG B)

for OPP/CPP, OPP/VMCPP, PET/VMPET/CPP

### DESCRIPTION OF THE PRODUCT

Monza SBG A with co-reactant (Monza SBG B) is a solvent-based two-component polyurethane-adhesive with high slip agent compatibility.

Used for lamination of printed or unprinted transparent and metallized PET-,BOPP-,CPP-,CPA-,OPA-and PE-structures as well as aluminum.

Good initial bonds and excellent bond and sealing strength after final curing.

Many transparent structures are highly resistant to pasteurization, boiling and sterilization.

Suitability of printing inks, films, additives etc. must be tested by the user prior to use. In case of changes in the quality of one component these tests have to be repeated.

### PHYSICAL PROPERTIES

|                                     | Monza SBG A          | Monza SBG B     |
|-------------------------------------|----------------------|-----------------|
| Type / chem. Character              | NCO                  | OH              |
| Solid content [%]                   | 75 ± 1               | 75 ± 1          |
| Viscosity @ 25°C                    | 2900 ± 1100 mPas     | 3500 ± 700 mPas |
| Solvent                             | Ethyl acetate        | Ethyl acetate   |
| Density @ 20°C [g/cm <sup>3</sup> ] | 1.08                 | 1.16            |
| Appearance                          | clear to slight hazy | clear           |
| Standard mixing ratio [Mass %]      | 100                  | 12.5            |

### PROCESSING

#### Diluents:

Suitable solvents are urethane grades of ethyl acetate, MEK(water content<0,05%) or acetone (water content <0,1%)

#### Mixing Instruction:

Monza G A firstly has to be diluted to the desired solid content. The co-reactant Monza G B has to be added slowly while mixture is stirred. The following table indicates approximate viscosities at a given solid content:



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|                       | Solid Content |      |      |      |
|-----------------------|---------------|------|------|------|
|                       | 35%           | 40%  | 45%  | 50%  |
| Monza SBG A [kg]      | 100           | 100  | 100  | 100  |
| Monza SBG B [kg]      | 12.5          | 12.5 | 12.5 | 12.5 |
| Ethyl acetate [kg]    | 129           | 98   | 75   | 56   |
| Viscosity (Sec DIN-4) | 13            | 15   | 17   | 23   |

### Pot life:

The pot life of the ready-to-use mixture in a closed container is more than 8 hours.

### Coating weight:

Standard applications (dry): 2.5 - 4.0 g/m<sup>2</sup>

Higher demands (dry): 3.5 - 6.0 g/m<sup>2</sup>

(Boil-in-bag, pasteurization and sterilization applications)

The required coating weight for a particular application has to be evaluated in specific trials by the end user.

### Drying:

All drying conditions have to be adjusted according to substrate, coating weight and machine speed. Unsuitable drying conditions may lead to increased solvent retention.

### CURING TIME

The curing reaction starts immediately after lamination. Rewinding and Slitting is possible after several hours. Best chemical resistance is reached after 7 to 10 days curing at room temperature. Storage at elevated temperatures will reduce curing time.

## STORAGE

Highly flammable. The products should be stored at room temperature in a dry area. Guaranteed shelf life is 6 months from the date of delivery in unopened, original containers. Once opened, containers should be closed tightly again and the material should be consumed within a short period.

## SAFETY

Contains monomeric MDI and highly flammable solvents. Process only when good ventilation is available and special precautions are taken in handling (material safety data sheet).



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### FOOD STUFF LEGISLATION STATUS

The constituents of Monza SBG A or Monza SBG B are in accordance with:

- Regulation 10/2011/EC of 14 January 2011
- Code of Federal Regulations 21 CFR 175.105 for food packaging materials

Monza SBG A or Monza SBG B are manufactured in accordance with guideline 94/62 and do fulfil the mentioned limit of <100ppm for lead, cadmium, mercury and chromium(VI).

Monza SBG A and Monza SBG B do not contain BADGE, BFDGE or NOGE.

Detailed information regarding actual foodstuff legislation status is available upon request.



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034-871604-6

kpnsale@kpn2552.com

kpngraphics.co.th