

MONZA COAT SB HIGH PERFORMANCE SOLVENT BASE ADHESIVE (MONZA SBH A + MONZA SBH B) for PET/VMPET/LLDPE, PET/Alu/LLDPE

DESCRIPTION OF THE PRODUCT

Monza SBH A with co-reactant (Monza SBH B) is a solvent-based two-component polyurethane-adhesive with high resistance against aggressive filling goods. Designed for lamination of film/film and aluminum-triplex structures, typically consisting of PET, BOPP, OPA, coated cello, aluminum foil, and metallized films with CPP and LLDPE. High initial bonds and excellent bond and sealing strength after final curing. High heat pasteurization and retort resistance.

PHYSICAL PROPERTIES

	Monza SBH A	Monza SBH B
Type / chem. Character	OH	NCO
Solid content [%]	50 ± 2	60
Viscosity @ 25°C	1000 ± 500 mPas	18 +/- 2 sec, DIN 4
Solvent	Ethyl acetate	Ethyl acetate
Density @ 20°C [g/cm ³]	1.06	1.12
Appearance	clear	clear
Standard mixing ratio [Mass %]	100	20

PROCESSING

Diluents:

Suitable solvent is urethane grade of ethyl acetate (water <0.05%, alcohol <0.05%).

Mixing Instruction:

normally applied at solid contents between 20 - 35 %. The following table indicates approximate viscosities at given solid content:



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

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

	Solid Content			
	20%	25%	30%	35%
Monza SBH A [kg]	100	100	100	100
Monza SBH B [kg]	190	128	87	57
Ethyl acetate [kg]	20	20	20	20
Viscosity (Sec DIN-4)	13	14	18	26

Pot life:

Dynamic pan stability of the mixed adhesive is more than 24 hours. The pot life is more than 48 hours; a fresh mix should be made every 8 hours.

Coating weight:

Standard applications (dry): 2.5 - 3.5 g/m²

Higher demands (dry): 3.5 - 4.5 g/m²

(boil-in-bag, retort packaging)

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 to substrate, coating weight and machine speed.

Unsuitable drying conditions may cause increased solvent retention. Web temperature of 50 – 65C with good air volume is usually adequate for complete solvent removal.

Lamination at ambient temperature is possible to reduce curling and shrinking effects.

Warmer nips may improve wetting, clarity and bond strengths, 40 – 60C heated nips are desirable. For olefinic films corona-treatment is necessary. Corona discharge treatment on polyester and nylon films improves bond strength and wetting.

CURING TIME

Curing reaction starts immediately after lamination. Rewind and slitting is possible after several hours.

Good chemical resistance is attained after 7 to 10 days at room temperature.

Highest heat and product resistance can be achieved by curing laminate at 45-50C for >3 days (starting directly after lamination).



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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

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

FOOD STUFF LEGISLATION STATUS

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

- Code of Federal Regulations 21 CFR 175.105(not 177.1390) for food packaging materials
- Monza SBH A or Monza SBH 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 SBH A and Monza SBH B do not contain BADGE, BFDGE or NOGE.

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



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