

## MONZA COAT SB MEDIUM PERFORMANCE SOLVENT BASE ADHESIVE

(MONZA SBM A + MONZA SBM B)

For NY/LLDPE, PET/LLDPE , PET/Alu/LLDPE

### DESCRIPTION OF THE PRODUCT

Monza SBM A +Monza SBM B is a solvent-based two-component polyurethane-adhesive adhesive with good resistance against aggressive filling goods.

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

Good initial bonds and excellent bond and sealing strength after final curing. Many transparent and aluminum containing structures are highly resistant to pasteurization, boiling and sterilization.

### PHYSICAL PROPERTIES

	Monza SBM A	Monza SBM B
Type / chem. Character	NCO	OH
Solid content [%]	60	100
Viscosity @ 25°C	400 mPas	21.5 sec DIN4
Solvent	Ethyl acetate	Ethyl acetate
Density @ 20°C [g/cm <sup>3</sup> ]	1.07	1.00
Appearance	clear	clear slightly hazy
Standard mixing ratio [Mass %]	100	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 SBM A [kg]	100	100	100	100
Monza SBM B [kg]	5	5	5	5
Ethyl acetate [kg]	112	81	58	39
Viscosity (Sec DIN-4)	12	13	15	19

### 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 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. Full cross linked 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

If this system is intended to be used for high-temperature food-contact applications we recommend to demonstrate compliance to the primary aromatic amine requirements of Annex II of Regulation 10/2011 under the foreseen conditions of use, as the system is based on aromatic isocyanates.



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