KPN GRAPHIC

# MONZA COAT SF ALIMINUM

## SOLVENT FREE ADHESIVE

**(MONZA SFAL A + MONZA SFAL B)**

**for PET/Alu/LLDPE**

## DESCRIPTION OF THE PRODUCT

Monza SFAL A with co-reactant (Monza SFAL B) is a solvent-free, fast curing two component polyurethane adhesive. In this system, the main component is -OH terminated and the cross-linker is -NCO terminated. Adhesive is formulated for superior bonding to aluminum foil and metalized films such as metalized PET, BOPP, CPP and PE.
Monza SFAL A + Monza SFAL B is used for the lamination of printed or unprinted, metallized and transparent structures consisting of PET, BOPP, OPA, Al or SiOx coated films, foil, PE and CPP films with excellent final bonds and heat resistance.

## PHYSICAL PROPERTIES

| | Monza SFAL A | Monza SFAL B |
|---|---|---|
| Type / chem. Character | OH | NCO |
| Solid content [%] | 100 | 100 |
| Viscosity @ 25°C mPas | 8000 ± 2000 | 6000 ± 1500 |
| Density @ 20°C [g/cm³] | 1.186 | 1.199 |
| Appearance | clear | clear |
| Standard mixing ratio1 [By Weight %] | 100 | 70 |
| Standard mixing ratio1 [By Vol %] | 100 | 69.2 |
| Standard mixing ratio2 [By Weight %] | 100 | 80 |
| Standard mixing ratio2 [By Vol %] | 100 | 79.1 |

*Mix ratio depends upon ink type and structure of laminate

## PROCESSING

**Mixing Instruction:**
Should be used on machines equipped with a metering and mixing unit with continuous mixing of components at a selected ratio. The adhesive mixture should be processed within 10 minutes to obtain a constant coating weight.

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## MIXING INSTRUCTION

Mixing unit: 40 to 45°C
Dosing roller: 40 to 45°C
Application roller: 50 to 60°C
Nip roller: 50 to 70°C

**CLEANING:**

If the machine is stopped for more than 20 minutes, the application unit rollers should be cleaned. Suitable cleaning agents are , plasticizers or glycerol triacetate. If the adhesive application units are explosion-proof, esters or ketones may also be used for cleaning. All precautions listed in the product Safety Data Sheets (SDS) of the cleaning agents should be taken.

**COATING WEIGHT:**

Standard applications : 1.2 – 2.5 g/m2. However, required coating weight of particular application has to be evaluated in specific trials by the end-user.

**CURING**

The curing reaction starts immediately after lamination. Curing at elevated temperatures (around 35-45C) reduces curing time, and improves heat and product resistance properties.

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## STORAGE

Guaranteed shelf-life is six months in unopened original containers. Once opened, the containers – especially MONZA SFAL B should be protected from moisture. It is also important that opened containers are well closed again after use.

## SAFETY

MONZA SFAL B Contains monomeric MDI (>2%) and should be processed at temperatures above 40C only when special precautions are taken in handling (Refer to safety data sheet).

### FOOD STUFF LEGISLATION STATUS

The constituents of Monza SFAL and Monza SFAL B are in accordance with:
"US Code of Federal Regulations" 21CFR§175.105 for food packaging materials.
Monza SFAL A and Monza SFAL B are manufactured in accordance with guideline94/62 and do fulfil the mentioned limit of <100ppm for lead, cadmium, mercury and chromium(VI).
Monza SFAL A and Monza SFAL B do not contain BHT, BHA, TPP, BPA, BADGE, BFDGE or NOGE.

### IMPORTANT NOTE

Before we introduce a new adhesive to the marketplace, the adhesive is comprehensively tested in our own laboratories. However, because of the hundreds of possible film combinations and the different printing ink systems used in various parts of the world, as well as the diversity of food, cosmetics, medical and pharmaceutical products that may be packaged in laminates made with our adhesives, we cannot possibly forecast their performance under all circumstances. Therefore, we strongly urge our customers to test our adhesives on a small scale to establish that laminates made with our adhesives are suitable for the end-uses for which they are intended prior to commencing large-scale production.