

MONZA COAT SF GENERAL PERFORMANCE

SOLVENT FREE ADHESIVE

(MONZA SFG A + MONZA SFG B)

for OPP/VMCPP,OPP/CPP

DESCRIPTION OF THE PRODUCT

Monza SFG A with co-reactant (Monza SFG B) is a solvent-free two-component polyurethane-adhesive (PU).

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

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 the use of adhesive. In case of changes in the quality of one component these tests have to be repeated

PHYSICAL PROPERTIES

	Monza SFG A	Monza SFG B
Type / chem. Character	NCO	OH
Solid content [%]	100	100
Viscosity @ 25°C	10000 ± 2500 mPas	1300 ± 400 mPas
Density @ 20°C [g/cm ³]	1.16	1.111
Appearance	clear to slight hazy	clear
Standard mixing ratio [Mass %]	100	40
Standard mixing ratio [Vol %]	100	42

PROCESSING

Mixing Instruction:

should be used on machines equipped with an automatic metering and mixing unit with continuous mixing of the adhesive components at a selected ratio.

For a test production both components could be premixed with an efficient agitator and then be poured between the metering rollers of application unit. The adhesive mixture should be processed within 15 minutes to obtain a constant coating weight.



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MIXING INSTRUCTION

Mixing unit: 40 to 45°C

Dosing roller: 40 to 50°C

Application roller: 50 to 60°C

Nip roller: 40 to 70°C

CLEANING:

If the machine is stopped for more than 20minutes, 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.

PRE-TREATMENT OF FILMS

Plastic films should be suitably pre-treated with corona discharge or chemically treated. For polyolefin films, corona treatment is mandatory. Pre-treatment will improve the results obtained with polyester and nylon films. Recommended corona treatment level on common films is as follows: PE, PP films: 38 dynes/cm; PET, O-Ny: 52 dynes/cm; metallized films: 38-40 dynes/cm. In-line corona treatment of pre-treated films (especially polyolefin films) further improves wettability of adhesive. Al foil surface should be free from any residual rolling oil.

COATING WEIGHT:

Standard applications : 1.2 – 2.2 g/m²

Higher demands (e.g., Boil-in-bag and sterilization applications): 2.2 – 2.8 g/m²

Note: The required coating weight for a particular application should be defined in specific trials by the end-user.

CURING

The curing reaction starts immediately after mixing. Rewinding and slitting is possible after 24 to 72 hours.

Best product resistance is reached after 7 to 10 days curing at room temperature of around 25C.

Curing of laminated rolls at elevated temperatures (35C - 45C) will reduce curing time, and increase heat and product resistance properties.



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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

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).

FOOD STUFF LEGISLATION STATUS

The constituents of Monza SFG A and Monza SFG B are in accordance with:

- Regulation EU 10/2011 of 14 January 2011 and amendment and/or
- Code of Federal Regulations 21 CFR 175.105(Adhesives)

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 SFG A and Monza SFG B do not contain BHT, BHA, TPP, BPA, BADGE, BFDGE, NOGE and GLYMO.

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

Note:

The responsibility for compliance of a final packaging material (for example, migration testing) made with our adhesive is with the manufacturer of the final packaging material and cannot be guaranteed by COIM as producer of adhesive components.

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.



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