

EB4260A/EB4260B Laminating Polyurethane Adhesive

(Specially for PET/Steel lamination)

Description

EB4260A/EB4260B is a high-strength, anti-aging functional two-component aromatic polyurethane adhesive. Suitable for laminating of metal/polymer printed film for can packaging, and the finished product has the characteristics of high strength, resistance to forging, corrosion resistance, etc. It can withstand 0~180° cold bending without delamination.

Declaration

OCHEM EB4260A/EB4260B 2-component EA base polyurethane adhesive are in compliance with the positive lists of the following, internationally accepted guidelines for the production of articles intended to come into indirect contact with food stuff.

- EU RoHS directive (EU) 2015/863 amending Annex II to directive 2011/65/EU
- CFR, title 21, § 175.105 of the FDA, Washington D.C., respectively
- Regulation (EC) No 1907/2006 concerning the REACH

Technical Properties

These properties are typical but do not constitute specifications.

Item	EB4260A (OH component)	EB4260B (NCO component)
Type	Main agent	Hardener
Ingredient	Polyester polyol agent	Isocyanate-terminated Polymer
Appearance	Light yellow transparent liquid	Light yellow transparent liquid
Solid Content(%)	60±2	75±2
Viscosity (mPa.s)	4000±1000 (25℃)	2500±1250 (20℃)
Solvent	Ethyl acetate	Ethyl acetate
Mix Proportion	5	1
Shelf life	360days	360days

Typical Features:

- EB4260A/B is a functional adhesive.
- Specializing for lamination of PET / Steel, Al/Al .
- With excellent bonding strength, high resistant of stamping and corrosive.

Recommended Operating Conditions

◆ <u>Application Method</u>	Direct gravure
◆ <u>Application Cylinder</u>	60-200 line
◆ <u>Application solids</u>	20-40% (Recommend 30%)
◆ <u>Pot Life</u> Static	8 hours approximately
◆ Dynamic	12 hours approximately
◆ <u>Dry Coating Weight</u>	4.0-5.0 gsm
◆ <u>Drying Section Temperature</u>	50-60℃ 60-70℃ 70-80℃ (three section)
◆ <u>Laminating Temperature</u>	50-80℃
◆ <u>Cure Time</u>	Over 48 hours (45-55℃)

◆ Cleaning Solvent
Ethyl Acetate
Mix Ratio By Weight

Solid content(%)	Mix Ratio		Operating Mix Ratio In Drums Weight		
	EB4260A	EB4260B	EB4260A	EB4260B	Ethyl Acetate(kgs)
35	5	1	20	4	18.8
30	5	1	20	4	26
25	5	1	20	4	36
20	5	1	20	4	50.8

Solvent is ethyl acetate, acetone, MEK, the water content should be less than 0.03%, the alcohol content should be less than 0.02%, Ethyl acetate is recommended.

Humidity over than 60% , the mix ratio should be over than EB4260A:EB4260B=4:1.2

Package

Pack in steel drum normally.

Main agent is 20kg/drum. Hardener is 4kg/drum.

Safety & Storage

Store in cool, dry, well-ventilated area away from heat and ignition sources . Keep container tightly closed.

Refer to MSDS for more safety information

Precautions

1. The LDPE and CPP films must be corona-treated with a surface tension greater than 38 mN/m. The PA film must be double-corona treated as an intermediate layer. The surface tension must not be less than 52 mN/m; the surface tension of the PET film must not be Less than 52 mN/m.
2. The temperature and humidity of the environment have a great influence on the time for storing the configured adhesive. It is recommended to arrange the adhesive in small quantities for a few times in high temperature and high humidity weather to avoid waste.
3. During the laminating processing, care must be taken to check and control the viscosity.
4. Residual adhesive: The remaining adhesive cannot be used in principle. If the amount of residual liquid is excessive, it shall be sealed and stored in cool place after dilution, which could be used as diluent for operation in next day, and a small amount shall be little by little added to the newly prepared adhesive solution. It cannot be used any more, if it appears cloudy, translucent or thickened.
5. The concentration and additives in the film have an influence on the bonding strength of the laminated film and must be selected before use.
6. Do not mix this product with other adhesives. If necessary, please consult our technical department.
7. Pay attention to fire prevention and static elimination.

Important notice

These documents we provided are made on the basis of our recent knowledge and experience, all these terms we mentioned are only suitable in normal condition and could be used as references. Please test and affirm before formal production or contact with our technician to some especial structures of films and stuffs packed, we do not take on any legal duty for these documents.