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SF9200A/SF9200B Solvent Free Polyurethane Adhesive

(high performance, resistant to 121℃/30min film/film retort , low ordor, low friction coefficient and resistant to slip agent)

Description

SF9200A/SF9200B is a high performance two-component solvent-free aromatic polyurethane adhesive specially designed for 121℃/30min film-to-film retort-resistant packaging, The adhesive has a long storage time after mixing, and is easy to handle and easy to clean; the adhesive does not affect the PE film slip agent precipitation, thereby having excellent smoothness, widely used in laminating of various treated film like BOPP、CPP、LDPE、PET、PA、Aluminum foil and metallised film etc. But it is **not** recommended for being used in laminating PET/VMPET, PET/VMCPP and PET/AL

Declaration

OCHEM SF9200A/SF9200B 2-component solvent-free 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, § 177.1395 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	SF9200A	SF9200B
Type	Hardener	Main agent
Ingredient	NCO	OH
Appearance	Yellowish transparent liquid	Yellowish transparent liquid
Density（g/cm^3)	1.17	1.12
Solid Content(%)	100%	100%
Viscosity (BKF25℃)	2000±500cps	2000±500cps

- SF9200A:SF9200B recommended weight mix ratio is 100:65 and volume ratio is 100:67.9. This recommended weight mix ratio is available for film/film 121 ℃ /30min retort pack lamination. The weight mix ratio of SF9200A/SF9200B can be from 100:65 to 100:75. It is recommended to use at 30°C to 40°C or room temperature （25℃）. According to different operation requirements, the recommended coating weight for film/film retort packaging is 1.8-2.5g/m2, please find following different recommended usage amounts in laminations of different films structures.

Structures	Coating weight	配比
Non printed: BOPP/CPP, BOPP/PE, PET/PE, NY/PE,PET/CPP	1.2-1.4 g/ m^2	100: 70
Printed: BOPP/PE, BOPP/CPP, PET/PE, PET/CPP	1.6~1.8g/ m^2	
Water boiling resistant: NY/PE, PET/CPP	1.8~2.2 g/ m^2	
VMPET/PE, VMPET/CPP BOPP/VMPET	1.8~2.2 g/ m^2	100:70-75
BOPP/VMCPP, BOPP/VMPET, PET/VMPET. PET/ALU AL/PE	1.8~2.2 g/ m^2	
PET/ALU, PET/PA, PET/PET	2.0-2.2 g/ m^2	100:65
121℃ retort pack :PA//RCPP, PET/RCPP	1.8-2.5 g/ m^2	

Note: The above is for reference only, please adjust according to the actual situation (film thickness, ink area, temperature and humidity of the workshop, equipment status).

- Laminating Temperature: please find following different recommended operating temperatures in different processing sections.

Item	Temperature ℃	Remark
A Component	40~45 ℃	When the temperature is low in winter, the temperature can be appropriately increased
B Component	40~45 ℃	
Feeding Tube	40 ℃	Please make adjustments according to the actual situation. For example, when high frictional coefficient films are required or PE film is required to be relatively thin in second laminating, the laminating temperature can be properly reduced, and the cooling roll can be opened if possible. In winter conditions, the cooling roller can be changed to a heating roller, and then the laminated aluminumized films or thick PE films can have good leveling properties.
Transfer Roller	40~45 ℃	
Meter Roller	40~45 ℃	
Nip Roller	35~45 ℃	
Curing Chamber	40~45 ℃	
Curing time	> 24 hours	The special structures have to be curing for 48~72 hours, such as boiling grade, retorting grade, etc. The actual requirements shall prevail.

Note: When the temperature is low in winter, the adhesive should be put into the curing room in advance for more than 4 hours. To ensure a suitable operating environment, please pay attention to the environmental temperature and humidity in the summer, the moisture absorption of the film, and solvent residual of the printed film, etc. Otherwise, it is easy to lead the adhesive sticky and other problems, the operating humidity should not exceed 80%. When the humidity is low in winter,

the mix ratio should be properly adjusted.

Cleaning

After production, the surface of the device is cleaned with a suitable solvent to prevent it from being hard to clean after curing.

Package

Pack in steel barrel normally.
A-component is 200kg/barrel. B-component is 200kg/barrel. One 20FCL could be loaded totally 16000KGS net weight in 80 barrels

Safety & Storage

This product should be stored in the room without direct sunlight at temperature 15-25 °C, shelf life would be 12 months in unopened drums, it should be used as soon as possible after drum opened.

Attentions

- When laminating different types of ink or transparent ink film, it is necessary to confirm whether it is suitable
- When laminating PET printed film, confirm whether the appearance meets the requirements or not
- If the contents of the package are corrosive, please confirm and start production
- In actual production, if other types of OCHEM solvent-free adhesive are replaced, the cylinder, pipelines and rollers may not be cleaned. If solvent free adhesives other than OCHEM adhesives are replaced, the user must perform thorough cleaning of the feeding system.
- Please stop using adhesive and then contact us when you find that the adhesive has become turbid or there is agglomeration.