

## HT3135A/HT3135B Laminating Polyurethane Adhesive

### Description

HT3135A/HT3135B is an ester based two-component aromatic polyurethane adhesive in high temperature steaming grade, widely used in laminating of various treated film like BOPP、PET、NY、PE、RCPP、AL、Paper、etc .

The adhesive has a certain resistance to media and corrosion resistance, , offers excellent bonding strength, has wide range of product adaptability, which is suitable for laminating of PET, NY, CPP and PE. The adhesive is specially designed for food packaging which demands processing at 135°C/30min retorting in the laminating structural of film/foil

### Declaration

OCHEM HT3135A/HT3135B 2-component ester based 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, § 177.1390 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	HT3135A (OH component)	HT3135B (NCO component)
Type	Main agent	Hardener
Ingredient	Polyester polyol agent	Isocyanate-terminated Polymer
Appearance	Light yellow transparent liquid	Light yellow transparent liquid
Solid Content(%)	50±2	75±2
Viscosity (mPa.s)	2000±1000(25°C)	2500±1250(20°C)
Solvent	Ethyl acetate	Ethyl acetate
Mix Proportion	20	3
Shelf life	360days	360days

### Typical Features:

- HT3135A/B is designed to laminate the film which use to package the contents which need to be steamed at 135°C less than 30 minutes in the producing ,
- High initial and final bonding strength, good peeling strength.
- With a certain anti-medium and anti-corrosive effect, good working property.

### Recommended Operating Conditions

**Dilution:** Firstly add ethyl acetate to the main agent, stir well, and then add a curing agent. Be sure to pour the curing agent, leave a small amount of ethyl acetate to clean the barrel and stir well.

**Coating method:** It can be applied to the coating of any plain roller and anilox roller.

- ◆ Application Method hexagonal mesh rotogravure
- ◆ Application Cylinder 100~110 line, mesh depth 70um (coating weight above 4.0GSM)

◆ Application solids	20-40% (Recommend 30%)
◆ Pot Life	Static 8 hours approximately
◆	Dynamic 24 hours approximately
◆ Dry Coating Weight	4.0-5.5 gsm depending on structure
◆ Drying Section Temperature	50-60°C 60-70°C 70-80°C(three section)
◆ Laminating Temperature	75-85°C
◆ Cure Time	over72 hours (45-55°C)
◆ Cleaning Solvent	Ethyl Acetate

**Mix Ratio By Weight**

Solid content %	HT3135A KGS	HT3135B KGS	Ethyl Acetate KGS
30	20	3	12
25	20	3	17.8
20	20	3	26
15	20	3	38

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.

**Package**

Pack in iron drum normally.

**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

**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.