

AT6170A/AT6170B Laminating Polyurethane Adhesive

(Alcohol based and High initial bonding)

Description

AT6170A/B is an alcohol based two-component polyurethane adhesive with high initial bonding strength, workable for small and medium size lamination machines with advantage of high transparency and high peel strength, widely used in laminating of various treated film like BOPP、PET、PA、CPE、CPP、AL、 etc .

Declaration

OCHEM AT6170A/AT6170B 2-component alcohol (polyether type) solvent 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, § 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	AT6170A	AT6170B
Type	Main agent	Hardener
Appearance	Light yellow transparent liquid	Light yellow transparent liquid
Solid Content(%)	70±2	70±2
Viscosity (mPa.s20C°)	9400±4600	17±5
Solvent	Alcohol, Ethyl acetate	Ethyl acetate
Specific gravity	0.93-0.97	0.93-0.97
Mix Proportion	6	1
Shelf life	360days	360days

Typical Features:

- Excellent initial bonding strength, better than AT6070A/B
- Especially be available to operate by small or middle dry laminating machine.
- Good transparency and high peeling strength

Recommended Operating Conditions

- ◆ Application Method Direct gravure
- ◆ Application Cylinder 100-200 line (65-80 line per cm)
- ◆ Application solids 20-35% (Recommend 30%)
- ◆ Pot Life Static 8 hours approximately
- ◆ Pot Life Dynamic 24 hours approximately
- ◆ Dry Coating Weight 1.5-3.0 gsm depending on structure
- ◆ Drying Section Temperature 55-65C° 65-75C° 75-85C°(three section)

◆ <u>Laminating Temperature</u>	50-80C°
◆ <u>Cure Time</u>	12 hours (40-50C°)
◆ <u>Cleaning Solvent</u>	Ethanol

Mix Ratio By Weight

Working Concentration %	AT6170A kgs	AT6170B kgs	Alcohol kgs	Viscosity(Zahn cup#3/25C°)(s)
35	6	1	7.0	40
30	6	1	9.3	27.2
25	6	1	12.6	18 . 6
20	6	1	17.5	15 . 3

Solvent is isopropyl, modified methanol, ethanol, purification shall be up to 95%. Ethanol is the recommended solvent.

Package

Pack in steel drum normally.

Main agent is 18kg/drum. Hardener is 3kg/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

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.

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.



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