

HT3360A/HT3360B Laminating Polyurethane Adhesive

Description

HT3360A/HT3360B is a two-component ethyl acetate solvent based aromatic polyurethane adhesive which is specially designed for pesticide packaging. The laminated structure can obtain higher initial bonding strength and final bonding strength, it is also available for 121°C/30min retorting film/foil food packaging. The adhesive has certain resistance to media and corrosion, and is excellent in coating. It is widely used in lamination of BOPP、PET、PA、PE、RCPP、AL, etc. It is also used for purpose of cold forming applications.

Declaration

OCHEM HT3360A/HT3360B 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, § 177.1395 of the FDA, Washington D.C., respectively
- Regulation (EC) No 1907/2006 concerning the REACH

As an indirect contact material in food and drugs packaging industry, OCHEM HT3360A/HT3360B are definitely suitable to make the film laminating for food packaging and doesn't contain any noxious, destructive and harmful material to human health.

Technical Properties

These properties are typical but do not constitute specifications.

Item	HT3360A (OH component)	HT3360B (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)	3500±1000 (25°C)	2300±1200 (20°C)
Solvent	Ethyl acetate	Ethyl acetate
Mix Proportion	5	1
Shelf life	360days	360days

Recommended Operating Conditions

- ◆ Application Method hexagonal mesh rotogravure
- ◆ Application Cylinder 100~110 line, mesh depth 70um (coating weight above 3.5GSM)
- ◆ Application solids 20-40% (Recommend 30%)
- ◆ Pot Life Static 8 hours approximately
- ◆ Dynamic 24 hours approximately
- ◆ Dry Coating Weight 4.2~5.5 gsm
- ◆ Drying Section Temperature 50-60°C 60-70°C 70-80°C(three section)
- ◆ Laminating Temperature 75-85°C

- ◆ Cure Time above 72 hours (45-55°C)
- ◆ Cleaning Solvent Ethyl Acetate

Mix Ratio By Weight

Solid content(%)	Mix Ratio		Operating Mix Ratio In Drums Weight		
	HT3360A	HT3360B	HT3360A	HT3360B	Ethyl Acetate(kgs)
35	5	1	20	4	18.9
30	5	1	20	4	29
25	5	1	20	4	36
20	5	1	20	4	51

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

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.

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

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.

