

TECHNICAL DATA SHEET

TEXACOTE SF301/CR300

➤ Description:

<i>Polymer type</i>	TEXACOTE SF301 with co-reactant CR300 is a solvent-free two component polyurethane adhesive.
<i>Product performance</i>	TEXACOTE SF301/CR300 is used for lamination of printed and unprinted substrates, aluminium, metallised and transparent structures.
<i>Properties</i>	<p>TEXACOTE SF301/CR300 shows excellent wettability, good final bonds, resistance to boiling and pasteurization in transparent structures.</p> <p>It is particularly indicated in applications where a medium to high chemical resistance with the filler is required; thermal resistance is medium-high, the adhesive is generally indicated for structures where the filled material is not aggressive from the chemical stand point.</p> <p>Considering the fact that the final result depends not only on the adhesive but on many factors (such as pre-treating of plastic films, type of printing inks, quantity of slip agents, other additives, etc) it's advisable to perform preliminary suitable tests before proceeding with industrial scale production.</p>

➤ Technical data:

	TEXACOTE SF301	TEXACOTE CR300
<i>Appearance</i>	Clear	Clear
<i>Type/chemical character</i>	isocyanate	hydroxyl
<i>Solids content (%)</i>	100	100
<i>Viscosity BKF 25°C (mPa*s)</i>	3500 ± 1500 (°)	2500 ± 1000 (°)
<i>Density @ 25°C (g/cm³)</i>	1,124	1,20
<i>Mixing ratio by weight</i>	100	50
<i>by volume</i>	100	48

(°) values certified for each batch

TEXACHEM Int. warrants that the properties of the product TEXACOTE, TEXAFLEX and TEXAGLOSS are truthful, in compliance with all statutory requirements and exclusively come from its own knowledge and experience. TEXACHEM Int. also warrants that, when used in accordance with the instruction provided and in standard condition, the products TEXACOTE, TEXAFLEX and TEXAGLOSS are free from the facts. There are no other warranties, expressed or implied. Considering the existence of different materials and the fact that the conditions of application cannot be under our control, the user must verify the suitability of the product for the intended use, through adequate tests. The user of the product TEXACOTE, TEXAFLEX and TEXAGLOSS has knowledge of the correct use of the product and accept all risks and liability

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➤ Regulations:

The individual monomers used in the manufacture of TEXACOTE/TEXAFLEX/TEXAGLOSS systems are conform and listed in the regulations like:

EC : COMMISSION REGULATION (EU) No 174/2015
BGA : GERMAN BgVV- Empfehlungen, Teil A XXVIII
USA : CFR, TITLE 21,§ 175.105 FDA Washington D.C.

TEXACOTE SF301/CR300 contains monomeric aromatic isocyanate MDI (>2%) and should be processed at temperatures over 40°/45°C only with special precautions to be taken in handling (MSDS).

➤ Application guide:

Mix ratio

TEXACOTE SF301 **100** CR300 **50**

The different mixing ratio is related to the required structures:

Standard ratio	100 : 50
OPA/PE (suggested)	100 : 60

Coating weight

The adhesive weight may vary between 1,5-4 g/m².

Temperatures

Dosing and mixing unit	40 - 45°C
Applicator roll	40 - 45°C
Laminating unit	40 - 60°C

Increase of viscosity (@ 40°C) :

time 0'	=	2000 mPa*s
after 30'	=	10.000 mPa*s
after 60'	=	60.000 mPa*s

Application

The adhesive can only be applied on special laminating machines equipped with a multiple roll applicator which allows the dosing of high-viscous adhesives and consequent small coating weights. Depending on the construction of the laminate the application weight varies between 1,5 and 4 g/m².

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Dosing

The adhesive is fed continuously by a metering and mixing unit with a mechanical mixing head or a stable and static metal mixing tube. The amount of adhesive depends on the consumption. Pre-heating of components, according to the above table, is necessary to improve flow properties in automatic mixing units. Propeller mixers are recommended instead of static mixers.

Laminating conditions

Precise web tension control together with a suitable winding programme avoids delaminations as well as telescoping and curling effects. The use of the right pressure/temperature of the calender and nip rolls, improve the final bond strength and optical properties. The continuous adhesive flow prevents an viscosity increase, avoiding pot-life issues.

Cleaning

After a standstill of the machine longer than 30 mins. the applicator has to be cleaned with suitable solvents and the dosing unit has to be washed (automatically). The same cleaning procedure has to be followed as soon as production stops. Suitable cleaning agents are phthalate plasticizers MEK or ethyl acetate.

Curing

The laminates may be rewound and slit after 1-2 days depending on the storage temperature. Manufacture of triplex laminates is normally possible 12 hour after duplex production. Complete curing will be achieved after 7 days of storage at room temperature.

➤ **Packing:**

The adhesive is supplied in the following packaging:

- 25 kg pails
- 220 kg drums

and have a warranty of 9 (nine) months when stored in unopened original containers. Once opened , especially the containers of TEXACOTE SF301, have to be used within 24 hours. It is important that opened containers are well closed in case of partial use.

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➤ **Additional information**

Films, additives, contained in such films (antistatic, slip agents etc.) printing inks, preliminary treatment proceedings, operative conditions of rolling and manufacture products are all factors which may influence, even after time, the properties of adhesion and endurance of the rolled products. In order to achieve the best results, the specific features of each component used in the production of the package must be considered.

Our Customer Service is available for providing you with all the assistance and information you might need for the correct use of our adhesive system.

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