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TECHNICAL DATA SHEET

**Novacote NC-7105 + CA-7962
 PE Extrusion Primer**

PRODUCT DESCRIPTION	:	Novacote NC-7105+CA-7962 is a solvent-based 2-component polyurethane (PU) extrusion primer for printed and unprinted PET, BOPP, O-Ny and aluminium foil. Novacote NC-7105 + CA-7962 shows high heat and product resistance properties in laminates after complete curing.																																																					
PRODUCT REFERENCE	:	NC-7105 (-OH component)	CA-7962 Co-reactant (-NCO component)																																																				
SOLID CONTENT	:	(75 ± 2) %	(55±2)%																																																				
VISCOSITY	:	8000-12000 mPas at 25°C	14±2 sec DIN 4 cup																																																				
DILUENT	:	Ethyl Acetate (urethane grade only).																																																					
MIX RATIO BY WEIGHT	:	<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th></th> <th colspan="4" style="text-align: center;"><u>Running solids</u></th> </tr> <tr> <th></th> <th style="text-align: center;"><u>5%</u></th> <th style="text-align: center;"><u>10%</u></th> <th style="text-align: center;"><u>15%</u></th> <th style="text-align: center;"><u>20%</u></th> </tr> </thead> <tbody> <tr> <td>NC-7105 :</td> <td style="text-align: center;">100</td> <td style="text-align: center;">100</td> <td style="text-align: center;">100</td> <td style="text-align: center;">100</td> </tr> <tr> <td>Ethyl acetate :</td> <td style="text-align: center;">1650</td> <td style="text-align: center;">763</td> <td style="text-align: center;">467</td> <td style="text-align: center;">319</td> </tr> <tr> <td>CA-7962 :</td> <td style="text-align: center;">25</td> <td style="text-align: center;">25</td> <td style="text-align: center;">25</td> <td style="text-align: center;">25</td> </tr> <tr> <td>Total (kg)</td> <td style="text-align: center;">1775</td> <td style="text-align: center;">888</td> <td style="text-align: center;">592</td> <td style="text-align: center;">444</td> </tr> <tr> <td>Viscosity at 25°C</td> <td style="text-align: center;">10</td> <td style="text-align: center;">10</td> <td style="text-align: center;">10</td> <td style="text-align: center;">11</td> </tr> <tr> <td>DIN 4 Cup (sec)</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Viscosity at 25°C</td> <td style="text-align: center;">10</td> <td style="text-align: center;">10</td> <td style="text-align: center;">10</td> <td style="text-align: center;">11</td> </tr> <tr> <td>Rigosha Zahn Cup 3 (sec)</td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>					<u>Running solids</u>					<u>5%</u>	<u>10%</u>	<u>15%</u>	<u>20%</u>	NC-7105 :	100	100	100	100	Ethyl acetate :	1650	763	467	319	CA-7962 :	25	25	25	25	Total (kg)	1775	888	592	444	Viscosity at 25°C	10	10	10	11	DIN 4 Cup (sec)					Viscosity at 25°C	10	10	10	11	Rigosha Zahn Cup 3 (sec)				
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MIXING AND DILUTION INSTRUCTIONS	:	Mix NC-7105 + Ethyl Acetate first followed by co-reactant, CA-7962 . Stir the mixture well until it becomes a homogeneous solution.																																																					
DYNAMIC PAN-LIFE	:	24 hours (tested 20% running solids in ethyl acetate at 35°C/100% rh)																																																					
APPLICATION METHOD	:	Gravure coating or smooth roll coating.																																																					
DRYING CONDITIONS	:	Forced hot air (60-90°C) sufficient to remove the solvent. Exhaust must be efficient to remove solvent vapours from the drying tunnel.																																																					

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The information provided herein is to our best knowledge true and accurate. However, we cannot accept liability for any recommendation or representation made, since the conditions and methods of application are beyond our control. These are typical physical properties, not manufacturing specifications. For health and safety requirements, please refer to the Safety Data Sheets (SDS).

**Novacote NC-7105 + CA-7962
PE Extrusion Primer**

TYPICAL PE EXTRUSION TEMPERATURES	:	Extrusion cylinders: 192-330°C; T-Die: 320-330°C
DRY COATING WEIGHT	:	0.5-1.2 gsm dry (Note: Required coat weight of particular application has to be evaluated in specific trials by the user)
CURING TIME	:	The curing reaction starts immediately after extrusion. Higher curing temperatures ($\approx 35-40^{\circ}\text{C}$) will accelerate curing rate, and give better heat and product resistance properties.
SAFETY INSTRUCTION		NC-7105 and CA-7962 contain solvent, and CA-7962 contains monomeric isocyanates. Mixing and processing is recommended only when good ventilation is available and special precautions are taken in handling of materials (please refer to material safety data sheets).
STORAGE AND SHELF- LIFE	:	NC-7105 and CA-7962 are flammable liquids. Store under dry conditions at 5 - 30°C, and away from direct sunlight. Close the containers after each use especially co-reactant (CA-7962), which is highly moisture-sensitive. Use up the products as soon as possible once the containers are open. Otherwise, purging of the containers with dry air or nitrogen gas is recommended. Shelf life is 6 months in original unopened containers stored away from heat, direct sunlight and rain.
REGULATORY STATUS	:	Novacote NC-7105 + CA-7962 complies with US FDA Regulation, 21 CFR § 175.105 (Adhesives), and Commission regulation (EU) No. 10/2011.
IMPORTANT NOTE	:	Before we introduce a new product to the marketplace, the adhesive is comprehensively tested in our own laboratories. However, because of the hundreds of possible film combinations and the different printing ink systems used in various parts of the world, as well as the diversity of food, cosmetics, medical devices and pharmaceuticals that may be packaged in laminates made with our adhesive, we cannot possibly forecast their performance under all circumstances. Therefore, we strongly urge our customers to test our adhesive on a small scale to establish that laminates made with our adhesive are suitable for the end uses for which they are intended, prior to commencing large scale production. Adhesive are suitable for the end uses for which they are intended, prior to commencing large scale production.

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