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TECHNICAL DATA SHEET

NOVACOTE NC- 825-A with co-reactant CA-26

DESCRIPTION

NOVACOTE NC-825-A with co-reactant CA-26 is a solvent-based two-component polyester polyurethane adhesive. One of the remarkable features of this adhesive system is the resistance against aggressive filling goods.

PRODUCT PERFORMANCE

NOVACOTE NC-825-A + CA-26 is designed for lamination of film/film and aluminium-triplex structures, typically consisting of PET, BOPP, OPA, coated cello, aluminium foil, and metallised films with CPP and LLDPE. Laminates produced with **NOVACOTE NC-825-A + CA-26** show high initial bonds and after curing, high heat pausterisation and retort resistance.

TYPICAL PRODUCT DATA

	NC-825-A	CA-26
Type/chem. Character	OH	NCO
Solid Content (%)	50 ± 2	60 ± 1
Viscosity @ 25°C	1,000 ± 500 (mPas)	18 ± 2 sec, DIN 4
Solvent	ethyl acetate	ethyl acetate
Density @ 20°C [g/cm ³]	1,06	1,12
Appearance	Clear	Clear
Mixing Ratio [Mass %]	100	20

PROCESSING

Diluents:

Suitable solvents are urethane grades of ethyl acetate, MEK (H₂O <0,05%) or acetone (H₂O <0,1%)

Mixing Instructions

NOVACOTE NC-825-A + CA-26 is normally applied at solid contents between 20 - 35 %. The following table indicates approximate viscosities at given solid content:

	Solids Content [%]			
	20%	25%	30%	35%
NC-825-A(kg)	100	100	100	100
Diluent ethyl acetate [kg]	190	128	87	57
CA-26	20	20	20	20
Viscosity DIN-4-Cup @ 25°C[sec]	13	14	18	26

Pan life

Dynamic pan stability of the mixed adhesive is more than 24 hours. The pot life is more than 48 hours; a fresh mix should be made every 8 hours.

Coating weight

Standard applications (dry): 2,5 – 3,5 g/m²
Higher demands (dry): 3,5 – 4,5 g/m²
(boil-in-bag, retort packaging)

Required coating weight of particular application has to be evaluated in specific trials by the end-user

Drying	All drying conditions have to be adjusted to substrate, coating weight and machine speed. Unsuitable drying conditions may cause increased solvent retention. Web temperature of 50 – 65°C with good air volume is usually adequate for complete solvent removal.
Additional	Lamination at ambient temperature is possible to reduce curling and shrinking effects. Warmer nips may improve wetting, clarity and bond strengths, 40 – 60 °C heated nips are desirable. For olefinic films corona-treatment is necessary. Corona discharge treatment on polyester and nylon films improves bond strength and wetting.
Safety instruction:	Contains monomeric isocyanates and solvents. Processing only when good ventilation available and special precautions are taken in handling (material safety data sheet).
CURING TIME	<p>Curing reaction starts immediately after lamination. Rewind and slitting is possible after several hours. Good chemical resistance is attained after 7 to 10 days at room temperature.</p> <p>Highest heat and product resistance can be achieved by curing at 50°C for more than >3 days (starting directly after lamination).</p>
STORAGE	NOVACOTE NC-825-A and CA-26 are highly flammable. The products should be stored at a dry and cool place. Guaranteed shelf life is 6months in unopened, original containers.
FOOD STUFF LEGISLATION STATUS	<p>The constituents of NOVACOTE NC-825-A and CA-26 are in accordance with the following “Code of Federal Regulations” 21 CFR 175.105 (not 177.1390) for food packaging materials.</p> <p>NOVACOTE NC-825-A and CA-26 are manufactured in accordance with guideline 94/62 and do fulfil the mentioned limit of <100ppm for lead, cadmium, mercury and chromium (IV).</p> <p>NOVACOTE NC-825-A and CA-26 do not contain BADGE, BFDGE or NOGE</p> <p>Detailed information regarding actual foodstuff legislation status is available upon request</p>