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TECHNICAL DATA SHEET

NOVACOTE SF-7680 WITH CO-REACTANT CA-7906

DESCRIPTION: **NOVACOTE SF-7680** with co-reactant **CA-7906** is a solvent-free, fast curing two component polyurethane adhesive.

PRODUCT PERFORMANCE: **NOVACOTE SF-7680 + CA-7906** is used for the lamination of printed or unprinted, metallized and transparent structures consisting of PET, BOPP, OPA, CPA, foil, PE and CPP films. Laminates manufactured with **NOVACOTE SF-7680 + CA-7906** showed excellent final bonds and heat resistance after curing.

TYPICAL PRODUCT DATA

	SF-7680	**CA-7906**
Type/Chemical Character	**NCO**	**OH**
Solid Content (%)	100	100
Viscosity @ 25ºC (mPas)	3000±1500	2500±500
Density @ 20ºC (g/cm^3)	1.231	1.204
Appearance	Clear to slight hazy	Clear
Mixing ratio (by weight) Mixing ratio (by Vol.)	**100** 100	**80** 82

PROCESSING: **NOVACOTE SF-7680 + CA-7906** should be used on machines equipped with a metering and mixing unit with continuous mixing of components at a selected ratio. The adhesive mixture should be processed within 10 minutes to obtain a constant coating weight.

TEMPERATURES:

Mixing unit:	>20 ºC
Dosing Roller:	30 to 45ºC
Application roller:	30 to 45 ºC
Nip roller:	40 to 60 ºC

CLEANING: If the machine is stopped for more than 15 minutes, the application unit and mixing device should be cleaned. Suitable cleaning agent is glycerol triacetate or Novacote CL-7000. If the units are explosion-proof, esters or ketones can be used. All precautions listed in the material safety data sheets of the solvents should be taken.

COATING WEIGHT: 1.2 – 2.5 g/m^2. However, required coating weight of particular application has to be evaluated in specific trials by the end-user.

SAFETY INSTRUCTION: **NOVACOTE SF-7680** contains monomeric MDI (>2%) and should be processed at temperatures above 40 ºC only when special precautions are taken in handling (Refer to safety data sheet).

CURING: The curing reaction starts immediately after lamination. Adhesive cures completely in about 3 to 7 days at room temperature (around 25 ºC). Curing at elevated temperatures (around 35-45 ºC) reduces curing time, and improves heat and product resistance properties.

ADDITIONAL INFORMATION

STORAGE: Guaranteed shelf-life is six months in unopened original containers. Once opened, the containers – especially **NOVACOTE SF-7680** should be used within 24 hours. It is also important that opened containers are well closed again after use.

FOODSTUFF LEGISLATION STATUS: The constituents of **NOVACOTE SF-7680 and CA-7906** are in accordance with the following regulations:

"US Code of Federal Regulations" 21CFR§175.105 for food packaging materials and/or EC-Directive 10/2011/EC of 14 January 2011

NOVACOTE SF-7680 and CA-7906 are manufactured in accordance with guideline 94/62 and do fulfill the mentioned limit of <100ppm for lead, cadmium, mercury and chromium (VI).

NOVACOTE SF-7680 and CA-7906 do not contain BHT, BHA, TPP, BPA, BADGE, BFDGE or NOGE.

IMPORTANT NOTE: Before we introduce a new adhesive 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 adhesives, we cannot possibly forecast their performance under all circumstances. Therefore, we strongly urge our customers to test our adhesives on a small scale to establish that laminates made with our adhesives are suitable for the end-uses for which they are intended, prior to commencing large-scale commercial production.

Revised: 12/22