

GLUit-SA 1280/ SH-75 is a general-purpose solvent-based adhesive for flexible packaging application.

PRODUCT SPECIFICATION	GLUit-SA 1280	GLUit-SH 075
COMPONENT	OH	NCO
SOLIDS in %	80 ± 2	75 ± 2
VISCOSITY @ 25°C in cps	10000 – 14000	1500 – 2500
DENSITY in gm/cm ³	1.18	1.16
COLOUR	Colourless to Pale Yellow	Colourless to Pale Yellow
APPEARANCE	1.18	1.16
SOLVENT	Ethyl Acetate	
MIX RATIO (Pbw)	100	15

Viscosity is measured by Brookfield DVII*

APPLICATION AREA

GLUit-SA 1280/ SH 075 adheres to a wide range of substrates like polyester, polyethylene, Poly propylene, aluminium foil and metallised films and is suitable for lamination of transparent, Printed, metallised film structures used in flexible packaging.

DILUTION

GLUit-SA 1280/ SH 075 system is best used at a range of 30 to 45% solids. For dilution of the adhesive system polyurethane grade ethyl acetate is recommended with a moisture content < 0.03%. Depending on the cylinder specification and solids content requirement, converter can choose the dilution ratio as per the chart given below.

DILUTION CHART	DILUTION			
	Solids Content	45%	40%	35%
GLUit-SA 1280 in kgs	10.00	10.00	10.00	10.00
GLUit-SH 075 in kgs	1.60	1.60	1.60	1.60
Ethyl Acetate in kgs	8.85	11.40	14.70	19.10

RECOMMENDED OPERATING CONDITION

- GLUit-SA 1280 and Hardener SH 075 should be mixed as per the dilution table to get required solid content.
- The mixed Adhesive can be applied by Gravure Cylinder
- The mixed adhesive will have a pot life of about 8 hours approximately. But it is recommended to use material well before this time to have better results.
- The normal range of dry adhesive weight is 1.5 – 4 GSM. Depending on the structure used and the end use application.
- The nip temperature should be in the range of 50 to 80°C
- The green bond of the system is good. The bond strength after 12 hours should be good enough for operations like slitting and rewinding.
- Normal cure time is 5 to 10 days at room temperature. Full properties like bond strength, heat resistance and chemical resistance will develop by this time.



GLUit-SA 1280/ SH-075

2K Solvent Based Polyurethane System

HANDLING AND STORAGE CONDITIONS

- Store in a cool, dry and well-ventilated area away from sources of heat and ignition.
- Use adequate safety precautions while opening, dispensing, mixing and emptying of the material
- It is advised to use proper Personal Protection Equipment while handling the materials. All must follow appropriate safety and hygiene guidelines.
- Empty containers might be hazardous and must be stored and disposed of as per regulations of local authorities.
- Material safety data sheets can be referred to for more information on handling and disposal of these materials.
- If stored in proper storage conditions the Resin component has a shelf life of 12 months and the hardener component a shelf life of 6 months

DISCLAIMER

The information provided in this data sheet is based on our knowledge and experience. There are many variables at laminators end which will influence the performance like the machine running parameters, operational conditions, various structures used and ambient conditions which are beyond our control. We advise our customers to make their own determination of suitability of this product for their application by making trials at their end. As such this information is offered in good faith but we cannot accept any liability.

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