

**GLUit-SA 1980/ SH 075** is a solvent based two component polyurethane adhesive system for flexible packaging application.

| PRODUCT SPECIFICATION<br>COMPONENT | GLUit-SA 1980             | GLUit-SH 075              |
|------------------------------------|---------------------------|---------------------------|
|                                    | OH                        | NCO                       |
| SOLIDS in %                        | 80 ± 2                    | 75 ± 2                    |
| VISCOSITY @ 25°C in cps            | 6000 – 7500               | 1500 – 2500               |
| DENSITY in gm/cm <sup>3</sup>      | 1.19                      | 1.16                      |
| COLOUR                             | Colourless to Pale Yellow | Colourless to Pale Yellow |
| APPEARANCE                         | Clear                     | Clear                     |
| SOLVENT                            | Ethyl Acetate             |                           |
| MIX RATIO (Pbw)                    | 100                       | 15                        |

Viscosity is measured by Brookfield DVII\*

### APPLICATION AREA

**GLUit-SA 1980/SH 075** is an adhesive system for all general to medium performance applications of film/film and film/aluminium laminates with or without interior printing or metallized surface. It exhibits good optics on white background when laminated to metalised films.

### DILUTION

**GLUit-SA 1980/SH 075** is applied by reverse or direct gravure application system at a solids content range of 35 to 45% solids. The product should be diluted with urethane grade solvents like Methyl Ethyl Ketone (MEK), Ethyl Acetate or acetone to achieve the desired solid content depending on the cylinder specification and solids content requirement

The converter can choose the dilution ratio as per the chart given below. .

| PROCESSING PARAMETERS<br>DILUTION   | SOLIDS CONTENT  |       |       |       |
|-------------------------------------|---|-------|-------|-------|
|                                     | 45%   | 40%   | 35%   | 30%   |
| GLUit-SA1980 in kgs                 | 10.00   | 10.00 | 10.00 | 10.00 |
| GLUit-SH 075 in kgs                 | 1.50  | 1.50  | 1.50  | 1.50  |
| Ethyl Acetate in kgs                | 8.80  | 11.30 | 14.60 | 18.90 |
| Viscosity by B4 ford cup (in secs)  | 19±1  | 16±1  | 15±1  | 14±1  |
| Coat Weight (Dry) gm/m <sup>2</sup> | 1.5 - 4 (depends on substrate, print and application) |       |       |       |
| Tunnel temperatures °C              | 70 to 80°C with adequate Air intake and Exhaust       |       |       |       |
| Nip temperature                     | 50 to 60°C with adequate Nip Pressure                 |       |       |       |

### POT LIFE

The mixed adhesive will have a pot life of about 20 - 24 hours at ambient temperature. It is advisable to dilute the mixture to below 30% and store it in a closed container at temperatures between 15 – 35°C. But it is recommended to use material well before this time and use it with 3 parts of freshly mixed adhesive to have better results.



# GLUit-SA 1980/ SH-075

2K Solvent Based Polyurethane System

## CURING TIME

Curing of the laminates depends on the substrates used, applied coating weight and storage condition. Further processing of the laminates for 3-ply, Rewinding or slitting is possible after 24 hours if stored at above 30°C. Processing of pouches should take place after complete cure of the laminate which is achieved after 7 – 10 days depending on the temperature and humidity conditions.

## STORAGE GUIDLINES

**GLUit-SA 1980** have a storage of 12 months and **GLUit-SH 075** for 9 months if stored in a cool and dry environment in original unopened container. The opened containers of **GLUit-SA 1980/ SH 075** should be closed tightly and must be used as soon as possible.

## CAUTION

**GLUit-SH 075** is polyisocyanates, any contact with skin should be avoided. Safety regulations with regards to handling of isocyanates have to be followed. Please refer to the local safety instruction and our safety data sheet.

## FOOD LEGISLATION

**GLUit-SA 1980/ SH 075** is in compliance with the positive lists of the internationally accepted guidelines for the production of articles intended to come into indirect food contact. Since Food contact regulatory requirement are constantly evolving, you can ask our Technical Team to forward your request.

**GLUit-SA 1980/ SH 075** is **BADGE-free**.

## Remark

Our technical support team is always ready to assist you the usage of the adhesive. Prior to the regular production, we recommend you to verify the suitability of our product with the other components of the laminates. Please refer to our general technical brochure

## 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.

**inkofix**

Website: [www.inkofix.com](http://www.inkofix.com) Email: [info@inkofix.com](mailto:info@inkofix.com)

## CORPORATE OFFICE

25/33, 3rd Floor, East Patel Nagar, New Delhi,  
India -110008  
Tel.: +91-11-42481111 | Fax: +91-11-42481126

## UNIT

Kila No.14, 17, Village Bhigan, Tehsil Ganaur,  
Distt. Sonipat, Haryana, India -131039  
Tel.: +91-130-3520900 ext:628