



XCNA-3010A/B

Two-component solvent-free soft packing adhesive

Product description

XCNA-2020A/B is one of two-component polyurethane solvent-free soft packing adhesive. This product is suitable for the bonding between different kinds plastic films or plastic films and aluminized films. Transparent plastic film with XCNA-3010A/B can have the resistance to boiling water for about 30 min.

Product Attributes

| Code | XCNA-3010A | XCNA-3010B |
|----------------------|-------------------------------|-------------------------------|
| Appearance | Light yellow to orange liquid | Light yellow to orange liquid |
| Component | Curing agent | Base |
| Mixing ratio(weight) | 100 | 75 |
| Component | -NCO | -OH |
| Detergent | Ethyl acetate | |

Typical application

- BOPP/MCPP
- PET/PE
- BOPA/PE
- PVDC/PE
- BOPP/VMPET/PE

Technical data

| Model NO. | XCNA-3010A | XCNA-3010B |
|--|------------------------|------------------------|
| Density(45℃) | 1.11 g/cm ³ | 0.96 g/cm ³ |
| Solid content | 100% | 100% |
| Viscosity(45℃) | ~800mPas | ~400mPas |
| Viscosity of new adhesive mixture(35℃) | ~500mPas | |
| 15 minutes later | ~800mPas | |
| 30 minutes later | ~2000mPas | |
| 60 minutes later | ~000mPas | |

Food grade material regulations

- compliant with FDA regulations
- compliant with GB9683 hygienic standard of food package bag
- compliant with GB9685 national food safety standard of the migration requirements of the special substances in food contact materials and product additives

Usage guidelines

Preliminary statement: To understand the protective measures and safety guidelines, read the safety manual of the product before use.

Protective measures: In order to prevent volatile isocyanate from spreading to the work area, the coating area must be equipped with good ventilation equipment.

1.Applicable conditions: solvent-free compound machine, automatic mechanical mixing or manual mixing.

2.Consumption: 1.0-2.0g/m² (it will change according to different substrates and different application)

The recommended amount of glue for common structures is as follows:

| Composite structure | Suggested ratio | Recommended glue amount g/m ² |
|---------------------------|-----------------|--|
| PET/PP(PE) | 100: 75 | 1.3-1.6 |
| PA/PE(CPP) | 100: 70 | 1.3-1.8 |
| VMPET/PE (Inner layer) | 100: 75 | 1.4-1.7 |
| PVCD/PE | 100: 75 | 1.4-2.0 |
| BOPP/VMPET, BOPP/VMCPP | 100: 75 | 1.5-1.8 |

3. Operating temperature: 30-40℃

The specific temperature settings are as follows.

| Temperature settings(℃) | XCNA-3010A | XCNA-3010B |
|-------------------------|--|------------------|
| Preheat temperature | Room temperature | Room temperature |
| Mixer pipeline | 30-35 | |
| Metering roller | 35-38 | |
| Coating roller | 35-38 | |
| Composite roller | 35-50 (change according to different substances) | |

4. Operating time: ≥30 minutes after mixing (The adhesives in the glue tank should be kept as fresh as possible).

5.Composite condition: appropriate tension control and winding settings to avoid delamination, curling and tunneling.

6.When the machine stops coating for 30 minutes or more, solvents should be used to clean the coating system and metering mixing system (protective measures should be

followed).

7.Curing time: films with two-layer structure can be cut into bags in about 12-16 hours. Curing time of films with three-layer structure or which have special requirement of the resistance to boiling water or steam should be appropriately added. In mass production, customers should change the curing time according to different substrates and different application.



contain isocyanates, so direct contact with skin and food should be avoided.

Storage requirement:

The unopened adhesive has a storage period of six months(in the dry environment at 10-30°C).

Once opened but not used up, this product must be kept without air and should be run out as quickly as possible.

Considerations:

The quality of the final composite product is affected by multiple factors, including ink types (golden ink, silver ink, etc.), films (slip agent, corona value, etc.), equipment, environment, etc. And the final composite product may be used for different purpose including special contents (ethyl maltol, solvent, etc.) or special process (eight-side sealing zipper bag, hot filling, etc.). The user is responsible for conducting a small test before mass production in order to make sure that final product meets the users' requirements (including but not limited to the above factors).

When adhesives are used to composite printing films, it is necessary to consider the compatibility with the ink system. We suggest the user should conduct a small test before mass production, especially before the mass production of aluminized composite films.

The composite surface of the film needs to be corona treated, the surface tension of PE/PP film should be greater than 38 dyn, the surface tension of BOPA film should be greater than 48 dyn,

the surface tension of PET film should be greater than 45 dyn.

Due to the environmental temperature and humidity have a greater impact on the curing time and compounding effect, we suggest the users keep the environmental temperature at 15-20°C and keep the environmental humidity at 30%-70%.When the environmental temperature is lower than 20°C, it is recommended that the adhesive should be preheated in the curing room (not exceeding 45°C) for 4-12 hours, and then be poured into the glue mixer. In addition, stable film storage warehouse is good for the optic and adhesion of final products.

