

weeton it is a two-component polyurethane adhesive for various film/film laminates. This product features low viscosity, good transparency, good leveling ability and low solvent residue. 716 is suitable for lamination process of high speed and high work concentration.

I. Properties

Product Name	716 A	716 B
Mixing Ratio	1 : 1 (mass ratio)	
Solids Content	75±2%	70±2%
Viscosity	3650±1050mPa.s (Brookfield LVT, 25 °C)	2500±1000mPa.s (Brookfield LVT, 25 °C)
Solvent	Ethyl acetate	Ethyl acetate
Color	yellowish	Colorless to yellowish

II. Directions for use

- Dilution:** Suitable solvents are ethyl acetate, acetone and Methylethylketone provided that the water content does not exceed 300 ppm. Do not use aromatic or alcoholic solvents.
- Preparation of Adhesive Mixture:** After having added the right quantity of solvent to 716A and having achieved the required solids 716B has to be stirred into the 716A/solvent mixture.
- List of dilution:** When the ethyl acetate is used for dilution, to obtain an accurate solid content, it is required to refer to the following solvents.

716 A	716B	Solvent	Solids Content	Viscosity
20KG	20KG	24KG	45%	15-17s
20KG	20KG	32KG	40%	13-15s
20KG	20KG	40KG	36%	11-13s
20KG	20KG	56KG	30%	10-12s

* Viscosity is based on the average viscosity of the Zahn Cup 3# (25°C)

- Pot life:** The ready-for-use adhesive in closed containers has a working time of about 8 hours. If the laminating machine doesn't use up adhesive, the retention time shouldn't be more than 4 hours. Otherwise, the adhesive should be abandoned, or it may result in unstable laminated film.

Tropical area (Temperature >28°C + humidity >60%) pot life: Ready-for-use adhesive should be used up within 2 hours.

- Coating:** 716 is suitable for dry film laminating machine with smooth roller or gravure roller. Before mass production, repeated trials should be carried out to determine fitting roller.
- Application weight:** Depending on the film or foil combination and the end use of the laminate, the adhesive weight may range from 2.0-3.2g/m² (dry). For printed laminates the weight has to be adjusted accordingly, it should be approx. 0.5-1g higher than for unprinted films.
- Dry:** The laminating machine should have good air volume, wind speed, wind pressure and the appropriate



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temperature to avoid residual solvents. Temperature setting generally follows gradient principle (55°C-65°C, 65°C-75°C, 70°C-85°C). Adjust the temperature of the oven according to the performance of the processed products, raw materials, processing technology.

8. Pressure adjustment: Appropriate increase in laminating temperature and pressure can improve the bonding effect and surface finish of the laminates.

9. Curing: Stored in curing chamber (40-50°C), the laminates will be ready for cutting in 24h. The curing time should be extended if the laminates are used for bagging.

10. Film properties: The completely cured 716 polyurethane film is transparent, odorless, elastic and aging-resistant.

III. Product certification

716 is in compliance with FDA175.105

IV. Storage/Transport

1. Storage: 716 have a storage life of 9 months when stored at a cool and dry place in unopened containers. Once opened, containers of 716A/716B should be closed tightly again and the material should be consumed within a short period.

2. Transport: For details please refer to the corresponding safety data sheets.

V. Packaging specifications

716A:20KG/bucket

716B:20KG/bucke

VI. Notes

When using 716 an efficient exhaust hood has to be installed to the coating unit due to safety reasons. The exhaust efficiency has to be checked prior to production by gas analysis for isocyanate concentration in the air. Safety regulations with regard to handling of isocyanates have to be followed as per the guide line issued by the International Isocyanates Institute. Please also refer to the local safety instructions as well as our safety data sheet and contact Huitian for analytical support.

As the adhesive contains polyisocyanates any contact with skin has to be removed.

VII. Others

Film additives-particularly the types and content of slip agent in LDPE,MDPE and CPP films, film thickness, packed goods, printing inks, pre-treatment and film coating are of significant importance to the end use of the laminates and may affect the performance properties either directly or indirectly. Therefore, practical laminating tests as well as checks on the laminates are necessary before going into full scale production.

Statement

The information provided herein, especially recommendations for the usage and the application of our products, is based upon our knowledge and experience. Due to different materials used as well as to varying working conditions beyond our control we strictly recommend to carry out intensive trials to test the suitability of our products with regard to the required processes and applications. We do not accept any liability with regard to the above information or with regard to any verbal recommendation, except for cases where we are liable of gross negligence or false intention.



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