

weeton Weeton™776A /776B is a two-component polyether adhesive for

flexible lamination valid for various plastic film, aluminum film and aluminum foil and alike substrate. Weeton™776A /776B provides good adhesion featuring a very high initial tack, excellent solvent release, perfect compatibility, good wetting, good heat resistance and good chemical resistance.

776A /776B is recommended for applications requiring a faster curing speed. 776A /776B adhesive product has high compatibility with the slip agent, can be used for wPE (>=80um) like OPP / PE, Ny / (w)PE and so on. For aluminum foil structure, 776A /776B also shows an excellent positioning force and peel strength build-up.

Under proper conditions, 776A /776B used for film / film structures, can withstand boiling treatment.

Properties

Product Name	776A	776B
Component	Hydroxyl group	Isocyanate component
Mixing Ratio	1:1(mass ratio)	
Solids Content	75 ± 2 %	75 ± 2 %
Viscosity	1500 ± 500mPa.s (Brookfield LVT,25°C)	1500 ± 800mPa.s (Brookfield LVT,25°C)
Solvent	Ethyl acetate	Ethyl acetate
Color	Yellowish	Colorless to yellowish
Density	1.09 g / cm ³	1.08 g / cm ³

I. Directi

1. Dilution: Suitable solvents are ethyl acetate (EA), acetone and Methyl ethyl ketone provided that the water content does not exceed 300 ppm. Do not use aromatic or alcoholic solvents.

2. Preparation of Adhesive Mixture: After having added the right quantity of solvent to 776A and having achieved the required solid content, 776B has to be stirred into the 776A solvent mixture.

3. List of Dilution: When the ethyl acetate is used for dilution to obtain an accurate solid content, the amount required should refer to the following table

776A	776B	Solvent	Solid Content	Viscosity
20KG	20KG	26.7 KG	45%	16-18s
20KG	20 KG	35.0 KG	40%	13-15s
20KG	20 KG	45.7 KG	35%	12-13s
20KG	20 KG	60.0 KG	30%	11-12s

* Viscosity is based on the average viscosity of the Ford cup 3# (25°C).

4. Pot life: The ready-for-use adhesive in closed containers has a working time of about



24 hours. If the laminating machine doesn't use up adhesive, the retention time shouldn't be more than 2 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.

5. Coating: 776 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.

6. Coating weight: Depending on the film or foil combination and the end use of the laminate, the adhesive weight may range from 2.0-3.5g/m² (dry). For printed laminates the weight has to be adjusted accordingly, it should be approx.0.5-1g/m² higher than for unprinted films.

7. Dry: The laminating machine should have good air volume, wind speed, wind pressure and the appropriate 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 strength and surface finish of the laminates.

9. Curing: Stored in curing chamber (35-45°C) or similar wild environment, various film/film and film/foil the laminates will be ready for cutting within around 24 h. Nevertheless, the curing time should be extended if the laminates are used for bagging.

10. Film properties: The completely cured 776A/776B polyurethane film is transparent, odorless, elastic and aging-resistant.

II. Product certification

775A/776B is in full compliance with FDA175.105

III. Storage/Transport

1. Storage: 776A/776B have a storage life of 9 months when stored at cool and dry place in unopened drums. Once opened, containers of 776A/776B 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.

IV. Packaging specifications

776A:20 KG /bucket

776B:20 KG /bucket

V. Notes

When using 776A/776B 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.

VI. Others



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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 carrying 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.

