

XCNA-3030A/B

Two-component solvent-free flexible packaging adhesive

Product Description:

XCNA-3030A/B is a solvent-free polyurethane adhesive for two-component composite film. This product is suitable for the bonding of a variety of plastic film or plastic film with aluminized film structure, with low smell, large elasticity and fast curing. Suitable for transparent plastic film can withstand boiling and 121°C steam sterilization.

II. Product specifications:

Name of name	XCNA-3030A	XCNA-3030B
Appearance	Light yellow to yellow liquid	Colorless to yellow liquid
Component	- NCO	- OH
Mix ratio (mass)	100	80 (75-85)
Cleaning agent	Ethyl acetate	

III. Typical application structure:

- BOPP/VMCPP ●PET/PE ●BOPA/PE
- PE/PE ●BOPP/PP ●BOPP/PE

IV. Technical data

Name of name	XCNA-3030A	XCNA-3030B
Density (45°C)	1.15 g/cm ³	1.15 g/cm ³
Solid content	100%	100%
Viscosity (25°C)	mPas ~1500	mPas ~2000

New Adhesive Mix viscosity (35°C)	mPas ~1000
Mix for 15 minutes	mPas ~1500

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Version:

Mix for 30 minutes	mPas ~3000
Mix for 60 minutes	mPas ~15000

V. FRAMEWORK FOR FOOD CONTACT MATERIALS

Meet the requirements of the FDA of the United States Food and Drug Code, meet the hygienic standards of GB9683 composite food packaging bags, and meet the requirements of the migration of specific substances in the national standards for food safety, food contact materials and product additives.

VI. GUIDELINES ON USE

Preliminary statement: read the product's safety instructions before use to understand protective measures and safety guidelines.

Protective measures: in order to avoid the dispersion of volatile isocyanate into the working area, the coating area must be well ventilated.

1. Applicable conditions: solvent-free compounding machine, mixing mode for automatic mixing system or manual mixing.
2. Coating: g/m 1.2-2.5²(according to different substrates and applications)100:75-85(according to different substrates and different applications), in which the recommended proportion of common structures and the amount of glue added are as follows:

Composite structure	Recommended proportion	g/m amount of glue suggested ²
BOPP/ CPP (PE)	100: 80	1.2-1.5
PA/PE (CPP)	100: 75	1.4-1.8
VMPET/PE inner layer	100: 75	1.4-1.7
BOPP/VMPET, BOPP/VMCPP	100: 82	1.5-1.8
PA/R CPP	100: 73	1.8-2.2

Note: the above is for reference only, the customer should make appropriate adjustments according to the actual situation, including but not limited to film thickness, printing



requirements, etc

3. operating

temperature :35-

45°C temperature

set as follows

(°C) temperature setting	XCNA-3030A	XCNA-3030B
Pre-heating	40-42	42-44
Rubber mixer piping	40-43	
Measuring roll	42-45	



Coating roller	42-45
Composite roll	35-50 (adjusted for different substrates)

4. Operable time: after mixing ≥ 30 minutes, glue in the slot should be as fresh as possible.
 5. Compound conditions: appropriate tension control and winding settings to avoid delamination, crimping and tunneling.
 6. When the machine stops coating for 30 minutes or more, solvent should be used to clean the coating system and metering mixing system (safety measures should be observed).
1. Curing time: the two-layer structure can be cut into bags for about 12-16 hours, the three-layer structure and the maturation time with the requirement of boiling and cooking should be extended properly, and the users should adjust according to the actual substrate and environment to meet the requirements.
 2. Adhesive containing isocyanate should avoid direct contact with skin and food.

VII. STORIES

An unopened adhesive has a storage period of 6 months (10-30°C in a dry environment). Once opened, when the material is not used up, it should be strictly sealed and used up in a short period of time.

VIII. Points for attention

1. the final composite product quality is affected by a number of factors, including ink (gold, silver, ink, etc.), film (smooth agent, corona value, etc.), equipment process, environment, etc. and the composite product may be used for different uses including special contents (ethylmaltol, solvents, etc.) or special processes (octagonal zipper bags, hot filling, etc.). the user is responsible for conducting a small test before mass production to determine that the final product meets the requirements of the user (including but not limited to the above factors).

2. The matching property with ink system should be considered in composite printing film. The compatibility between adhesive and ink should be tested in advance. Before the batch production of aluminum plating composite, the user has the responsibility to test and pilot the matching property of ink.
3. The composite surface of the film should be treated by corona, PE、CPP the surface tension of the film should be greater than 38, the surface tension of the BOPA film should be greater than 48, and the surface tension of the PET film should be greater than 45.
4. Because environmental temperature and humidity have great influence on maturation time and compound effect, it is suggested that the environmental temperature and humidity of users should be $^{\circ}\text{C}15-30$ /30%-70% 。 **When the ambient temperature is below 20°C , it is recommended that the glue be preheated in the curing room (not more than 45°C) for 4-12 hours, and then poured into the glue mixer.** In addition, it is suggested that the film storage warehouse be stable, which is beneficial to the composite appearance and strength.