

Herberts-EPS 7280 / Hardener KN 75

Description: Herberts-EPS 7280 with Hardener KN 75 is a solvent based two component polyurethane-cross-linking adhesive system.

Range of application Herberts-EPS 7280 / Hardener KN 75 is an "all-round" adhesive system for all "medium performance"-applications of film/film and film/aluminium and paper, cardboard or greaseproof paper against films or aluminium. In general, the surfaces can be printed, unprinted or metallized.

Before starting production the suitability of the used printing inks, film qualities, film additives, coatings etc. has to be controlled individually. In case of any change of quality of these printing inks, films etc. new tests concerning the suitability are necessary. The desired properties of the complex have to be verified by performance tests prior to production.

Physical properties

	<i>EPS 7280</i>	<i>Hardener KN 75</i>
	<i>OH-component</i>	<i>NCO-component</i>
solids content [%]	80 ± 2	75 ± 2
solvent	Acetone	ethyl acetate
viscosity [mPa·s/25°C]	4000 - 6000	1000 - 3000
density [g/cm³]	1,15 ± 0,02	1,17 ± 0,02
mixing ratio [parts by weight]	100	16
for met. films [parts by weight]	100	16 (in case of good metal to film adhesion) 8 (in case of poor metal to film adhesion)
for Al/parchment [parts by weight]	100	20

Dilution Dilution may be done with PU grades (< 0,1 % H₂O-content) of ethyl acetate, acetone, MEK or a mixture of these solvents. The adhesive system should be processed at a solids content of approx. 35 %.

solids content [in %]	EPS 7280 [in kg]	KN 75 [in kg]	ethyl acetate [in kg]	viscosity flow cup Ford 4 (20°C)
45	100	16	89	20 sec.
40	100	16	114	16 sec.
35	100	16	147	15 sec.
30	100	16	191	14 sec.

Pot Life 24 hours at ambient temperature if diluted (solids content of the mixture 25 %). Humidity will negatively influence the pot life.

Application Parameters Herberts laminating adhesive must be applied using appropriate laminating equipment. Different methods are possible, the most preferred ones being application by rotogravure system.
Herberts laminating adhesives may be used with cold or heated nip rollers. For dry laminations heated nip rollers are preferable (50 to 60°C), but not for the lamination of paper for which we recommend working with cold rollers.

Application weight

film/film	≥ 2 g/m ²	paper/cardboard	≥ 3,5 g/m ²
met. films	≥ 2,5 g/m ²	parchment	≥ 4 g/m ²
film/Al	≥ 3 g/m ²		

Drying	Drying conditions must be adjusted to substrate, application weight and line speed in order to avoid the retention of solvents. The dried and fully cured adhesive film will be transparent and neutral in odour.
Curing Time	Rewinding, slitting as well as the production of triplex-laminates is possible already after a few hours. Maximum cure will be reached in 7 to 10 days depending on temperature and humidity conditions.
Storage	12 months for EPS 7280 and 9 months for Hardener KN75 when adhesive and hardener are stored in originally closed containers at temperatures between 10 and 35°C. The remainder in partly emptied barrels must be used as soon as possible.
Precautions	<p>During processing, solvent vapours must be exhausted by an adequate ventilation. When processing these resins precautions for the use of isocyanates have to be observed.</p> <p>The corresponding EEC safety data sheets are part of this technical information.</p>
Food Legislation	<p>EPS 7280 / KN75 is in compliance with the positive lists of the following, internationally accepted guidelines for the production of articles intended to come into indirect contact with foodstuff :</p> <ul style="list-style-type: none"> - recommendations of the German Health Dept. (BfR), chapter XXVIII, - the EEC-directive 2002/72 and amendments (including 90/128/EC and amendments), the Council of Europe's resolution AP (96) 5 and amendment, - CFR, title 21, § 175.105 of the FDA, Washington D.C., respectively. <p>Herberts EPS 7280 / KN75 is BADGE-free.</p>
Remark	Please refer to our general technical brochure " Bostik Laminating Adhesives " for additional information

Bostik can also offer:

- 1K-LF laminating adhesives
- 2K-LF laminating adhesives (cold and warm system)
- 1K-LH laminating adhesives
- 2K-LH laminating adhesives, for food and industrial application.
- Gloss lacquers of the series GL 3000
- Primers; e.g. for PVDC coating, for printing ink applications, as extrusion primers
- Heat seal lacquers, sealable against PVC, PS and PP
- Colour concentrates for laminating adhesives (solvent borne and solvent free)
- Heat seal coatings based on Vitel[®] resins
- Cold seal Adhesives

Please contact us directly or our local representation for further assistance:

1K = one component
2K = two component

LF = solvent free
LH = solvent borne

Prior tests are advised (or recommended) for any industrial use. Moreover, the recommendations for implementation should be followed. It is recommended to follow our precautionary measures listed in the specification sheets.
