

Herberts-MP 1009 / KN 75

Description: Herberts-MP 1009 with Hardener KN 75 is a solvent based two component polyurethane-cross-linking adhesive system.

Range of application Herberts-MP 1009 / Hardener KN 75 is an "all-round" adhesive system for all "medium to high performance" applications of film/film and film/aluminium laminates. In general, the surfaces can be printed, unprinted or metallized.

This adhesive system is also suitable for the production of laminates of paper and cardboard against plastic films and aluminium.

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 test concerning the suitability are necessary. The desired properties of the complex have to be verified by performance tests prior to production.

Physical properties	MP 1009	KN 75
	OH-component	NCO-component
solids content [%]	75 ± 2	75 ± 2
solvent	ethyl acetate	ethyl acetate
viscosity [mPa·s/25°C]	2000 - 5500	1000 - 3000
mixing ratio [parts by weight]	100	12 to 15

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 %]	MP 1009 [in kg]	KN 75 [in kg]	ethyl acetate [in kg]	Viscosity Ford Cup-B4 (25°C)
25	100	15	230	14sec
30	100	15	173	16sec
35	100	15	131	18sec
40	100	15	101	20sec
45	100	15	77	26sec

Pot Life 24 hours at ambient temperature at 25 % solids and 8 hours at 35% solids. Humidity will negatively influence the pot life.

Application On all dry laminating machines, with smooth or rotogravure rollers.

Application weight At least 2 g/m² dry. Optimum adhesion is obtained with an application weight of approx. 3 g/m².

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.

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 Herberts-MP 1009 and 9 months for Hardener KN 75 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>Herberts-MP 1009 / KN 75 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> <p>- CFR, title 21, § 175.105 of the FDA, Washington D.C., respectively.</p> <p>Herberts-MP 1009 / KN 75 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	LF = solvent free
2K = two component	LH = solvent borne

Deleted:

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.
