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General Comments

Dow's Technical Service is ready to supply assistance in regards to the correct use of our products.

Interaction may occur with other components of the structure. Inks, retained solvents from any source, substrates, additives, coatings and the packed product are some of the components that may cause a property change of the total structure.

Before regular production, the end user is responsible to verify the suitability and performance properties of the total construction for the intended end use application, including the suitability of the process, construction and components.

If used in conjunction with high slip films (COF <0.2), it is strongly recommended to verify that potential film property changes, due to the lamination process and materials, are acceptable for the end use performance requirements.

The Coreactant or Catalyst must be used at the recommended mix ratio to achieve the desired properties.

Especially unfavorable substrate circumstances and combinations are: laminates containing polyamide (PA) film; of PA to high EVA content PE; white pigmented PE or combination of both; sealing films with excess slip, antifogging or antistatic additives.

Alcohol and similar materials containing active hydrogen can react with this adhesive causing inadequate cure and unexpected performance.

This product is sensitive to moisture and should be stored under and transferred with dry nitrogen.

The adhesive layer must be separated from the food product by a functional barrier. Consult your Dow Technical Sales representative for suggestions and further information.

Other Coreactant or Catalysts are available for special uses. Consult your Dow Technical Sales representative for suggestions and further information.

Like all MDI-monomer containing adhesives, a potential monomer migration risk may interfere with the sealing properties of the sealant film.

Recommended Application Weight

Apply 1.3 to 2.0 g/m² dry, depending on substrate, printing and application.

Nip Temperature

The adhesive can bond with room temperature pressure nip rollers; however heating the rollers up to 49 to 71°C would be recommended for most applications.

The rubber roll in the nip with hardness of 85 Shore A or greater is recommended.

Slitting / Rewind Time

Slitting and rewind is possible after 6.0 to 24.0 hr at 21°C (70°F).

Curing Time

Converters should verify appropriate cure times and conditions for their individual application.

It is necessary to wait until complete curing has taken place before the laminate is fit for use.

The curing process is normally completed 7.0 day after lamination at 24°C and may be influenced by the type of film used, applied weight and by the storage conditions.

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Dow strongly encourages its customers to review both their manufacturing processes and their applications of Dow products from the standpoint of human health and environmental quality to ensure that Dow products are not used in ways for which they are not intended or tested. Dow personnel are available to answer your questions and to provide reasonable technical support. Dow product literature, including safety data sheets, should be consulted prior to use of Dow products. Current safety data sheets are available from Dow.

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c. use as a critical component in medical devices that support or sustain human life; or
d. use specifically by pregnant women or in applications designed specifically to promote or interfere with human reproduction.

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This document is intended for use within Latin America, North America

Published: 2017-01-13

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Form No. 400-00302379en
Rev: 2017-01-13