



# ADCOTE™ 122HV

**Description** ADCOTE™ 122HV is a two component curing type laminating adhesive designed for laminating combinations of polyester, metallized polyester, nylon, polyvinyl chloride, polyethylene, polypropylene, aluminum foil, and paper.

Adcote 122HV plus Coreactant F (100:7.0 pbw) is recommended for use in laminations requiring high degrees of bond strength, age stability, thermal resistance and chemical resistance. Where ultraviolet resistance is of prime concern, Adcote 122HV plus Coreactant 9H1H (100: 5.6 pbw) would be preferred.

**Suggested Substrates** Film to foil laminations.  
Metallized polyester (met-PET).  
Polyester (PET).

Typical Physical Properties	Adhesive	Unit
Solids Content	42	%
Viscosity (25°C)	1250 to 1700	mPa·s
Weight/Gallon	7.90	lb
Mix Ratio by Weight (PBW)	• 5.6 to 100 • 7.0 to 100	

\*These are typical properties only and are not to be construed as specifications. Users should confirm results by their own tests.

### Recommended Processing Guidelines

This system can be applied at a solid content of 42% by reverse gravure, direct gravure or with smooth roller system.  
Apply product onto the less porous, more stable substrate.  
Prior to adding the Coreactant, use a mechanical mixer to stir the Adhesive with enough speed until a vortex is formed, assuring that the adhesive is drawn from the sides and bottom of the mixing vessel.

### Recommended Application Weight

Apply 3.2 to 4.8 g/m<sup>2</sup> dry total coating weight, depending on substrate, printing and application.  
Higher applied adhesive weights may be required in laminations of heavy gauge substrates and/or where high levels of heat or chemical resistance are required.

### Drying Guidelines

Dry properly with sufficient amount of heated air at adjusted temperature range of 93 to 121°C to evaporate solvents at given production speed.

### Slitting / Rewind Time

Slitting and rewind is possible after 4.0 to 8.0 hr at 21°C (70°F).

### Curing Time

Bond strength immediately off the laminator is only fair but improves rapidly at 21°C (70°F).  
Maximum chemical and thermal properties develop within 7-14 days, provided that curing is done for a minimum of 7 days at 45 - 50°C (113 - 120°F).

Suggested Application and Operating Guidelines	Adhesive	Unit
Recommended Dilution Solvent	• Ethyl Acetate Urethane Grade • Methyl Ethyl Ketone Urethane Grade • Toluene	

### Suggested Cleanup Guidelines

A proper cleaning procedure should be implemented and practiced as part of the machine operation.  
After finishing work, the equipment should be cleaned immediately with organic solvents like ketone or acetate, or similar organic solvents before the product's cure progresses too far.

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**Storage and Shelf Life Guidelines**

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When exposed to cold temperatures of 0 - 10°C (32 - 50°F), the product may form a reversible gel or structure while in solution. This is a physical phenomenon and has no bearing on the final characteristics or performance of the product.

This characteristic is reversible when both heat and shear are applied. Heat the product safely in the original container to 35 - 60°C (95 - 140°F). Allow venting of the container. Avoid using electric band heaters which may cause localized hot spots.

Upon reaching target temperature, mix for 1 to 3 hours with moderate shear, using a disperser or "Cowles" type blade until completely homogeneous and no gel particles. Replace any lost solvent or dilute as necessary for the application method to be used.

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**European Food Legislation**

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Due to the evolving nature of European and local food legislations, please contact us at <https://www.dow.com/en-us/contact>, for food contact status.

**Notes**

These are typical properties only and are not to be construed as specifications. Users should confirm results by their own tests.

# ADCOTE™ 122HV

## FDA Regulation

		ADCOTE™ 122HV	
FDA Regulation		Complies	Opinion Date
<b>21CFR175.105</b>	Yes with limitations		12-05-2000
<b>Section Title:</b>	Adhesives		
<b>Limitations:</b>	Adcote 122HV with Coreactant F SOLVENT MUST BE COMPLETELY EVAPORATED DURING DRYING AND CURING.		

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