

Copolymer Dispersion

764.63

Application: **Paper and cardboard lamination:**
 Special adhesive for laminating pretreated (B)OPP, PET and acetate foils to printed or unprinted paper and cartons.
 High-performance product, one component.

Characteristics/ Directions for Use: Free of APEO.
 One-component, crosslinking without agent at room temperature.

Processing on standard application systems with doctor blade or double roller (metering roller) applicator system.

We recommend that all materials coming into contact with the glue are made of high-quality stainless steel (German standard V2A according to DIN EN 10027 – W-No. 1.4301 or better quality) or of inert plastics, e.g. Teflon, PP, polyamide.

Appearance: colourless transparent (dry film)
 Density at 20 °C [g/cm³]: approx. 1.03 ± 0.02 (Jowat test method)

Our Application Technology Department and our Application Specialists will provide technical data to assist you in your choice of an appropriate product for your requirements. Please observe the information in the section “Remarks”.

General laminating requirements: The properties (e.g. surface tension, plasticiser content...) and the conditioning of the substrates, as well as the processing conditions (e.g. ambient temperature, humidity...) will influence the processes of joining and the quality of the lamination. Customer tests under consideration of everyday production conditions are therefore absolutely necessary to define stable process parameters and to ensure that the product is fit for purpose. For best bonding results, the materials to be bonded should be free of dust, oil, and grease, and be dry. Ideally, the minimum temperature should be at 18 °C. Avoid draught. The surface tension of the films to be laminated should be above 38 mN/m. The print inks used should meet requirements of DIN ISO 2836.

When processed as one-component system, crosslinking will be completed after approx. 24 hours. However, further processing may be possible earlier, depending on the following stress. This must be determined by testing by the processor.

If the laminated compound is exposed to high mechanical stress during downline processing or if the films to be processed have a high rigidity (e.g. PET or acetate films), preliminary testing is absolutely necessary to ensure that the product is fit for purpose.

Specification: Viscosity at 20 °C [s]: 18 ± 2
 (DIN cup 4 mm)
 Solids content, 2 h at 90 °C [%]: 48.5 ± 1.0
 (Jowat test method)
 pH value at 20 °C: 7.5 ± 0.3
 (Jowat test method)

The values are always determined on the date of production.

continued on page 2

08/20 All data indicated are characteristics represented as average values. Our technical data sheets are periodically revised to represent the latest state of technology. This edition is replacing and superseding all previous ones, and is valid on the date of compilation.
Please refer to the last page of this technical data sheet for additional information.



- Cleaning:** Before curing, machines and equipment may be cleaned after use with warm or cold water, using Jowat® Cleaner Concentrate 192.40. Already dried adhesive can be dissolved using Jowat® Thinner 401.30. Please also observe the instructions in the corresponding technical data sheet and the safety data sheet.
- Safety instructions:** Please observe the corresponding safety data sheet and take appropriate precautions.
- Storage/
Handling:** For best-before date, please see container label.
After the elapse of the best-before date, it is essential that you again verify that the product is fit for your intended application.
Containers should remain stored at a temperature between 15 and 25 °C. Do not remove the lid completely during processing, to prevent the adhesive from drying and the formation of particles. Using a mixer during processing will generally lead to an improved application behaviour.
Protect from frost!
- Packaging:** Information about packaging types and units is available upon request.
- Remarks:** **For further information concerning safety, handling, transport and disposal, please refer to the Safety Data Sheet.**
The information on this data sheet is based on test results from our laboratories as well as on reported experience gained in the field by our customers. It can, however, not cover all parameters for each specific application and is therefore not binding upon Jowat, nor should it be relied upon in lieu of your own required testing. The information given in this leaflet does not represent a performance guarantee. Unless otherwise agreed with our customers, the values stated in the section "Specification" shall be regarded as the finally agreed upon product properties. No liability may be derived from the information contained herein nor from the information provided by our free technical advisory service.

Jowat Information

Gluing as one of the most efficient methods of bonding is constantly gaining importance and expanding into new areas of application. At the same time, the number of substrates to be bonded is also growing at an unprecedented rate. New methods and equipment to process adhesives are developed.

The in-house R & D departments of Jowat are responding with intensive efforts to keep pace with these constant changes. A highly qualified team of chemists and engineers is using the latest techniques and brightest ideas to provide the utmost in advice our customers and to make sure that they get the adhesive which meets their needs.

Our information is based on test results from our laboratories as well as on experience gained in the field by our customers. This advice, however, cannot cover all eventualities for each specific application and as such is not binding for us. Please, contact our technical service department in each case to find out what the actual technical state of development for the respective product is, and request the latest data sheet. Any use of our product without this precautionary measure would be your sole responsibility.

The processing company itself must therefore test the adhesives manufactured by us for suitability in each individual case. This applies to the first use of a sample as well as to modifications during an ongoing production.

We are therefore requesting all our new customers to test our adhesives for suitability on original parts at conditions equal to normal processing conditions. The bond has then to be subjected to the actual stress which it would undergo when in use and has to be assessed. This test is absolutely necessary.

Customers who undertake modifications during a running production are requested to pass this information on to us. Please notify us when machines are set to new parameters as well as when the substrates to be bonded are changed. Only then will Jowat be able to provide our most up-to-date information to the processor using our adhesives.

The information given in this leaflet is based on practical experience and on results of tests in our laboratory, and does in no way constitute any guarantee of properties. No liability may be derived from these indications nor from the recommendations made by our technical advisory service.