



Flextra™ SBA 5201 + Flextra™ XA 3377

Description **SBA 5201** with crosslinker **XA 3377** is a solvent based 2-component high performance aliphatic polyurethane adhesive. The system is particularly designed for room temperature curing.

Technical Data	SBA 5201	XA 3377
Component	Hydroxyl	Isocyanate
Solid Content	59 – 61 %	74 – 76 %
Viscosity at 25°C	500 – 3.500 mPas	500 – 900 mPas
Solvent	Ethyl acetate	Ethyl acetate
Density	1,06	1,04
Mixing Ratio	100	5,5

Food Contact Status **SBA 5201 + XA 3377** can be used to produce flexible packaging material intended for use in food packaging.
Detailed information on specific regulations are available upon request.

Application **SBA 5201 + XA 3377** is suitable for lamination of printed and unprinted, transparent, metallized and aluminium foil containing triplex structures. **SBA 5201 + XA 3377** can be used for lamination of aluminium foil, polyester, coated cello, nylon, polyethylene, oriented and Cast-polypropylene as well as SiOx or AlOx coated webs. Structures laminated with **SBA 5201 + XA 3377** show after curing high bond strength and good heat resistance. Structures laminated with **SBA 5201 + XA 3377** are resistant to boiling, pasteurisation, sterilisation and show good resistance to aggressive packed goods.
SBA 5201 + XA 3377 is suitable for lamination of olefin films with high content of slip additive (250 ppm erucamide calculated on 70µ film thickness).

Mixing Instruction **SBA 5201 + XA 3377** should be diluted to the desired solid content according following table:

	25%	30%	35%
SBA 5201	100	100	100
Solvent	151	108	78
XA 3377	5,5	5,5	5,5
Total	257	214	184
Viscosity (sec/DIN 4mm)	13	15	18
Solvent Ethyl acetate			

Trademark/brand AB 1234

Diluents	Suitable solvents are ethyl acetate and acetone (polyurethane grade).						
Pan Life	The dynamic pan stability of the mixed adhesive is 24 hours, a fresh mixture every 8 hours is recommended.						
Coating weight	<table> <tr> <td>Unprinted film/film-laminates, standard:</td> <td>2,2 – 2,5 g/m²</td> </tr> <tr> <td>Printed film/film-laminates, standard:</td> <td>3,0 – 3,5 g/m²</td> </tr> <tr> <td>Problematic printing inks vacuum packing, boil in bag and aggressive packed goods:</td> <td>4,0 – 5,0 g/m²</td> </tr> </table>	Unprinted film/film-laminates, standard:	2,2 – 2,5 g/m ²	Printed film/film-laminates, standard:	3,0 – 3,5 g/m ²	Problematic printing inks vacuum packing, boil in bag and aggressive packed goods:	4,0 – 5,0 g/m ²
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Drying	A web temperature of 50 – 65°C with good air volume is usually adequate for complete solvent removal.						
Combining	Increased temperature of the nip roller improves wetting and transparency of the laminates. Depending on kind of laminated films and machine speed nip temperatures of 40 – 70°C are recommended.						
Cross linking	Lamination manufactured with SBA 5201 + XA 3377 can be cured at ambient temperature for 5 to 7 days. Storing at increased temperatures (30 – 40°C) for 1 to 3 days will reduce cure time and improve performance to the highest level.						
Additional Information	It is recommended that the converter does his own lamination trials and tests of the resulting laminated structure due to the fact that additives, especially out of polyolefin films and printing inks, can affect the properties of the structure immediately or later. For olefin films corona-pretreatment is necessary. Corona-pretreatment of polyester- and nylon-films improves wetting and adhesion.						
Safety instructions	SBA 5201 + XA 3377 are highly flammable. The products should be stored at a dry and cool place.						
Storage	SBA 5201 + XA 3377 can be stored for 6 month (after date of shipping) in unopened original containers. Once opened, the containers – especially XA 3377 – has to be used within 24 hours. Opened containers should be well closed again.						

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