



Flextra™ SFA 8230 + Flextra™ XR 1215

Description **SFA 8230** with crosslinker **XR 1215** is a solvent free 2-component non-yellowing polyurethane adhesive based on an aliphatic isocyanate.

Technical Data		SFA 8230	XR 1215
Component		Hydroxyl	Isocyanate
Solid Content		100 %	100 %
Viscosity at 25°C		15.000 – 27.000 mPas Can be solid < 20°C	2.000 – 4.000 mPas
Density		1,21	1,16
Mixing Ratio	pbw-%	100	65
	parts by volume-%	100	67

Food Contact Status **SFA 8230 + XR 1215** can be used to produce flexible packaging material intended for use in food packaging.
Detailed information on specific regulations are available upon request.

Application **SFA 8230 + XR 1215** is suitable for lamination of printed and unprinted, transparent, metallized and aluminium foil containing structures. **SFA 8230 + XR 1215** can be used for lamination of aluminium foil, polyester, coated cello, nylon, polyethylene, oriented and Cast-polypropylene, as well as SiOx and AlOx coated webs.
Structures laminated with **SFA 8230 + XR 1215** show after curing high bond strength and good heat resistance. Film/Film structures laminated with **SFA 8230 + XR 1215** are resistant to boiling, pasteurisation, sterilisation (up to +130°C).
SFA 8230 + XR 1215 is suitable for lamination of olefin films with low content of slip additive (250 ppm erucamide calculated on 70µ film thickness).

Processing **SFA 8230 + XR 1215** should only be used on laminators which are designed for solvent free adhesives. For regular production using an automatically working mixing unit is strongly recommended.
For a test run both components can be mixed with an agitator before pouring into the dosing gap of the laminator. This amount of pre-mixed adhesive should be consumed within 20 – 30 minutes.

Temperatures	
Mixing unit	45 – 50°C
Dosing roller	40 – 50°C
Coating roller	50 – 60°C
Nip roller	40 – 70°C

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Cleaning	<p>If the laminator stops for more than 30 minutes the rollers have to be cleaned. Using ethyl acetate with addition of approx. 20% Triacetin (Glycerol triacetate) as a cleaning solvent is recommended.</p> <p>We recommend using ethanol for final cleaning, especially for the rubber roller.</p> <p>Precautions listed in the material safety data sheet of the solvent have to be followed.</p>						
Coating weight	<table border="0"> <tr> <td>Unprinted film/film-laminates, standard:</td> <td>1,5 – 1,8 g/m²</td> </tr> <tr> <td>Printed film/film-laminates, standard:</td> <td>1,8 – 2,0 g/m²</td> </tr> <tr> <td>Problematic structure: (aggressive packed goods and sterilisation)</td> <td>2,0 – 2,2 g/m²</td> </tr> </table>	Unprinted film/film-laminates, standard:	1,5 – 1,8 g/m ²	Printed film/film-laminates, standard:	1,8 – 2,0 g/m ²	Problematic structure: (aggressive packed goods and sterilisation)	2,0 – 2,2 g/m ²
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Combining	<p>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.</p>						
Cross linking	<p>Lamination manufactured with SFA 8230 + XR 1215 have to be crosslinked at increased temperature for 5 – 7 days at 40 – 45°C.</p>						
Additional Information	<p>If SFA 8230 is solidified it must be molten at temperatures not exceeding 80°C before use.</p> <p>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.</p>						
Safety instructions	<p>Follow material safety data sheet.</p>						
Storage	<p>SFA 8230 + XR 1215 can be stored for 6 month (after date of shipping) in unopened original containers. Once opened, the containers – especially XR 1215 – has to be used within 24 hours. Opened containers should be well closed again.</p>						

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