

PRODUCT DATA

Date: June 2004

Information No. 1

NIP WELD C 1540

Description:

A low foaming, fast drying cohesive coating suitable for application via high speed converting equipment. Provides a cohesive, and or destruct bond on coated and uncoated film, foil and papers when subjected to adequate sealing pressures.

Characteristics:

	Nip-WELD cohesive coating (see note #1)
Type of bond:	
Water resistance:	Good
Oil resistance:	Good
Flexibility:	Excellent
Blocking:	Minimal (see note #3)

Typical Properties:

• TYPE	Water based elastomer
• SOLIDS	56-58 %
• VISCOSITY	120 – 160 mPa.s.
• ODOR	Ammoniacal
• COLOR	Off white
• Ph	10,2 (see note #5)
• SPECIFIC GRAVITY	1

Product contains no flammable organic solvents.

CAUTIONS:

NOT USABLE AFTER FREEZING.

STIR BEFORE USING (See note #4).

Do not use with brass, copper, or bronze equipment.

Do not use with natural rubber equipment (rollers, hoses, etc.)

Do not use high shear pumps (See note #6).

Food legislation:

The raw material used for the manufacture of Nip-Weld C1540 comply with:

- US Regulation: CFR 21 – part 175.105 and 107.170 (b), subject to the extraction:
- GERMAN Recommendation BGVV Chapters XIV and XXI.

The adhesive is allowed for direct food contact applications.

Please note that the user of the product is responsible for determining the suitability for the intended use, and he will need therefore to review the relevant regulations.

Health and Safety:

Nip-Weld C1540 contains ammonia and inhalation can cause some discomfort and should be avoided.

This present sheet does not exempt from preliminary tests realization for any industrial use.

In addition, the process recommendations are to be imperatively respected.

Please refer to our safety data sheets for instructions of use.

HANDLING / APPLICATION:

Machine / materials:	Gravure, smooth roll coater
Storage life:	6 months
Store in:	16 - 32°C
Running temperature:	21 - 32°C
Film application:	See Note #2
Diluent:	Ammoniated Water (use as received)
Clean equipment:	Wet film – water Dry film – water

REMARKS

Note #1:

Both surfaces to be sealed must be coated with NIP-WELD cohesive coating C1540 dried thoroughly and then combined with adequate pressure.

Note #2:

Film application, as necessary, generally 3.0 – 5.0 g/m² depending on the substrate and seal requirements.

Note #3:

Properly dried Nip-Weld will adhere only to themselves. However, to minimize potential blocking, a polyamide over-lacquer is generally suggested as prudent-applied to the reverse side of converted structure.

Note #4:

CAUTION: Poor machining and blocking of cohesive film will occur if Nip-Weld is not thoroughly stirred before using.

Note #5:

Instability develops as pH decreases. If pH drops below 8.5, acqua ammonia (29.4%-26°Be) should be added to pH -10.

Note #6:

Use low speed, low shear pumps only. A piston type displacement pump or a systaltic pump, set to feed as necessary, rather than recirculate is best.

NIP-WELD cohesive coating is a registered trademark of BOSTIK.