PRODUCT DATA

Date: February 2004 Information No. 1

NIP WELD C 1810

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.
Nip Weld C 1804 is NPEO free.

Characteristics:

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

Typical Properties:

• **TYPE**	Water based elastomer
• **SOLIDS**	56 %
• **VISCOSITY**	80 – 130 mPa.s.
• **ODOR**	Ammoniacal
• **COLOR**	Off white
• **Ph**	10 (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 C1810 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 C1810 contains ammonia and inhalation can cause some discomfort and should be avoided.

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 – strip off

REMARKS

Note #1:

Both surfaces to be sealed must be coated with NIP-WELD cohesive coating C1810 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 decreses. 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.