

VAROSIVE

VD - 9670R/75H

Two -Component PU System
For Dry Laminating Adhesive

VAROSIVE VD - 9670R/75H System is highly versatile two component polyurethane adhesive for general lamination of various plastic films, metalized films and aluminum foil.

It is suitable for food packaging and has good adhesion, high initial tack and good chemical resistance.

1. Characteristic of VD-9670R/75H

High initial adhesion

Good adhesion at non-printing portion.

Excellent adhesive to PET, LDPE, Al., T-Die and Anchor coating.

2. Specification

Specification of VD-9670R

- Type : polyurethane(Polyester type)
- Appearance : Pale yellow transparent liquid
- Solid Content : $66 \pm 2 \%$
- Viscosity(at 25) : $3,500 \pm 1,000$ cps
- Shelf life : 6 Months
- Solvent : Ethyl acetate
- Packing : 18Kgs Tin Can or 100Kgs or 200Kgs Steel Drum

Specification of VD-75H

- Type : polyurethane cross-linker
- Appearance : Pale yellow transparent liquid
- Solid Content : $75 \pm 2 \%$
- Viscosity(at 25) : $2,000 \pm 500$ cps
- Shelf life : 6 Months
- Solvent : Ethyl acetate
- Packing : 20Kgs Tin Can or 200Kgs Steel Drum
- NCO content : 12.5 - 13.5 %

3. Practical Usage of VD-9670R/75H

Diluents : Ethyl acetate, MEK or blends of these

Mixing Ratio(w/w) : VD-9670R/75H = 100/15

Applicable solid : 25 - 40%

Coating method : Gravure roll coating

Coating weight : 150mesh, 2.0 - 4.0 g/m²(dry)

Drying condition : 70 - 90

Line speed : 80 -100 m/min

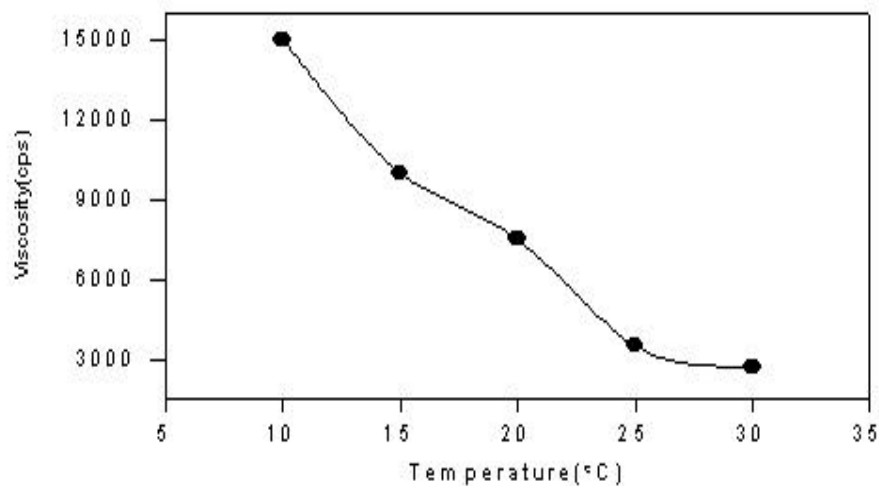
Pot life : 24hrs at room temperature

Aging time : 48hrs at approx. 60

4. Diluents Table

NV(%)	Mixing Ratio			Total(Kg)
	DV-9670R(Kg)	DV-75H(Kg)	Thinner(Kg)	
25	32.36	4.86	62.79	100
30	38.83	5.83	55.34	100
35	45.31	6.80	47.89	100
40	51.78	7.76	40.46	100

5. Viscosity change of VD-9670R with the temperature



6. Viscosity change of VD-9670R/75H with the mixing ratio of diluents at the 25

NV(%)	Mixing Ratio			Viscosity(25) [Zahn #3 (sec)]
	DV-9670R(Kg)	DV-75H(Kg)	Ethyl acetate(Kg)	
45	100	15	56.66	13.6
40	100	15	78.12	10.6
35	100	15	105.7	8.7
30	100	15	142.5	7.8
25	100	15	194.0	7.4
20	100	15	271.3	6.9

7. Application

OPP / CPP
OPP / LDPE
OPP / MCP
PET / LDPE
PET / Al. Foil
PET / Nylon etc.

8. Caution

Please avoid contamination of water and alcohol.
Please store in tightly closed container at cool and dark place.
Please use after complete agitation with diluents.
Please don't use residue of mixed varnish.

HEPCE CHEM Co., Ltd.

<http://www.hepce.com>

E-mail : hepce@hepce.com

H/O & Factory : TEL : +82-31-491-1611, FAX : +82-31-491-7400,

ShiWha Ind. 6BA-505, #683-4, Sunggok-dong, Ansan-City, Kyungki-Do, Korea, 425-110

R & D Center : TEL : +82-31-417-0662, FAX : +82-31-417-0111

RM No. 412, Ansan Technopark, #1271, Sa -dong, Ansan-City, Kyungki-Do, Korea, 425-791