



## Technical Data Sheet

Polyurethane Lamination Packaging Adhesive

<b>Product</b>	<b>Eagle SF 100A – Eagle SF 80C</b>	<b>W.e.f</b>	<b>08/04/2022</b>
<b>Category</b>	<b>Two component solvent Free</b>	<b>Rev.</b>	<b>00</b>

### DESCRIPTION:

Eagle SF 100A/ Eagle SF 80C is a bi-component solvent free polyurethane adhesive for flexible packaging laminates. It offers good bond strength and wettability.

### APPLICATION:

It is multipurpose product and works on variety of printed and unprinted substrates such as polyester, polyethylene, polypropylene and metallized substrates.

### SPECIFICATION:

<b>Properties</b>	<b>Eagle SF 100A (NCO Component)</b>	<b>Eagle SF 80C (OH Component)</b>
Appearance & Colour	Clear light yellow liquid	Clear light yellow liquid
Solids (%)	100	100
Viscosity @ 25°C	2000±1000 cPs	1000±500 cPs
Density	1.12±0.01	0.96±0.01
Mixing ratio	100	80

### POT LIFE:

Eagle SF 100A/ Eagle SF 80C has a good pot life making it easy cleaning for operators and can be run in high speeds. Mix adhesive viscosity profile\*

<b>Time (Minutes)</b>	<b>Viscosity (CPs)</b>
0	1000
15	1100
30	2200
45	6000

\* Mixed @ 40°C

### OPERATING CONDITIONS:

- Eagle SF 100A/ Eagle SF 80C is applied on solventfree laminating machine using multi roller application system
- The adhesive should be pre-heated to 40°C prior to application
- The adhesive and hardener must be mixed in prescribed ratio
- All films must have treatment level of minimum 38 dyne/cm
- Coating weight should be between 1.5-3.5 g/m<sup>2</sup> as per requirement
- The laminate should be cured at hot room for 24 hours for optimum strength
- Rubber roller should be of 75-80 shore hardness for proper lamination

**Eagle Forgings PVT LTD**

A3 Hosiery Complex Phase –II Noida, Uttar Pradesh – 201305

Tel: (0120) 4237733 | Email: [info@eaglegroupindia.com](mailto:info@eaglegroupindia.com) | Website: <http://eagle-grp.com/>



**SAFE HANDLING:**

Use PPE's (Gloves, safety goggles) while handling these chemicals. Refer MSDS for more information on safety aspect.

**FDA STATUS:**

Eagle SB 80/ Eagle HR 75 are suitable to make laminates for food packaging in accordance with regulation 21 cfr, Section 175.05 of the Food and Drug Administration, U.S.A.

**SHELF LIFE:**

Six months stored in original sealed containers @25-35°C.

*Note: Additives used in inks and films effects the laminate performance hence needed to be validated before conducting bulk production*

**DISCLAIMER:**

This information has been generated from laboratory tests and commercial trials. They are offered in good faith, but without guarantee, as conditions and methods of usage of this product is not in our control. We recommend that user should take small run and decide for its suitability before adopting in commercial run.

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