



Northwest Coatings

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2 Part Water Base Laminating Adhesive

Typical Film Combinations

- ❖ OPP to OPP
- ❖ MOPP to OPP
- ❖ PET to LDPE
- ❖ MPET to LDPE
- ❖ PVDC Coated PET to LDPE
- ❖ LDPE to OPP
- ❖ Nylon to Polyethylene
- ❖ Tri Lam: PET to Foil to LDPE
- ❖ Films need to be treated to 38-40 dynes minimum

Cure Speeds

350 to 1100 feet per minute via gravure, Up to 600 feet per minute via flexo. Faster speeds can be obtained via flexo through the use of optimized impinging air drying systems.

Regulatory Information

Product Meets 21 CFR 175.105, Solvent Content <2.0% V.O.C.

Attributes Of Waterbase 2 Part Chemistry

- ❖ Does not impart any additional flavor to food item packaged
- ❖ Provides suitable lamination for liquid or dry food (the adhesive is not affected by the contents of the package)
- ❖ Finished package has high clarity
- ❖ Adhesive does not impart tunneling
- ❖ Adhesive does not affect aesthetics of the films; does not corrode metalized layer, yellow PVDC, etc.
- ❖ Process does not involve specialized application equipment.
- ❖ Typically works with solvent and water base inks

End Use Applications

- | | |
|---------------------|-----------------------|
| Snack Foods | Frozen Food Overwraps |
| Bakery Items | Dry Mixes |
| Secondary Overwraps | Produce Wrap |
| Confectionary Items | Retort Pouches |

Bonds Green Tack: Immediate bond off laminator 50 to 250 grams/inch at coat weight of 0.75 to 1.5 dry lbs./3000 square feet.

Substrate Combination	Initial Peel in grams/inch	Final Peel in grams/inch
OPP to OPP	150 to 200	Film destruct
MOPP to OPP	100 to 150	Metal pulled off
PET to LDPE	150 to 200	PET destruct
OPP to LDPE	100 to 200	OPP destruct
Aluminum Foil to Paper	100 to 300	Paper destruct
Aluminum Foil to LDPE	150 to 300	LDPE destruct
Opaque Polyprop to OPP	150 to destruct	Film destruct
PET to Paper or Paperboard	200 to destruct	Destruct

