

# Technical Information

## Technopur CB 2005-21



Type of adhesive	Technopur CB 2005-21 is a moisture curing reactive Polyurethane hotmelt with a high initial tack. The adhesive film has an excellent UV-stability.							
Field of application	Technopur CB 2005-21 is especially used for the production of folding cartons and clear boxes. Different films as A-PET, G-PET and pretreated PP-films can be used. All materials have to be well pretreated (> 38 mN/m) and tested before in industrial trials.							
Product specifications	Test Method							
Viscosity	7.500 ± 1.500 mPas at 130 °C	Brookfield Thermosel, spindle 27						
Open time	55 ± 10 s	AIE-PUR 10-028						
Colour	transparent when molten and after cooling							
FDA status	Technopur CB 2005-21 is in compositional compliance with the FDA § 175.105							
Properties	Technopur CB 2005-21 is fast setting and shows a high initial strength after cooling. The adhesive provides a good adhesion on various substrates. After crosslinking with moisture the adhesive film has duroplastic behaviour leading to a high temperature stability and high flexibility even at low temperatures. The adhesive film is non-yellowing and therefore especially suitable for transparent unprinted folding boxes.							
Processing	<table><tr><td>Premelting unit:</td><td>100-130 °C</td></tr><tr><td>Hose:</td><td>120-150 °C</td></tr><tr><td>Nozzle:</td><td>140-160 °C</td></tr></table> <p>Depending on the application unit and machine the parameters have to be individually adjusted for a good wetting and optic. If the machine is stopped for extended periods, the temperature should be reduced in the melting unit and in the hoses to avoid increase in viscosity.</p>		Premelting unit:	100-130 °C	Hose:	120-150 °C	Nozzle:	140-160 °C
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Curing	Depending on the humidity, the thickness of adhesive layer and film quality the product will achieve the final strength after 3-7 days. For curing an ambient temperature of at least 20 °C has to be assured. Lower temperatures will slow down curing. After physical setting the adhesive has already a high handling strength. To obtain a bubble free adhesive seam the adhesive bean should be pressed to form a thin and even adhesive film.							
Cleaning	For the cleaning of application equipment we recommend our product Purmelt Cleaner 2							
Disposal	see Material Safety Data Sheet							

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<b>Classification</b>	Technopur CB 2005-21 is no hazard product according to guideline 67/548/EWG.
<b>Safety information</b>	The product contains a polyurethane prepolymer with a low content of remaining monomer of < 1,0%. An effective exhaust hood should be installed at the coating unit and the premelting unit to prevent isocyanate vapours from getting into the atmosphere at temperatures above 100 °C. Please observe the local safety regulations for the handling of isocyanate products and obey the MAK-value (TAGS 900) for IPDI of 0,01 ppm / 0,092mg/m <sup>3</sup> . Contact with skin, even with cold adhesive, should be avoided; contamination of skin which might occur have to be removed immediately. More detailed information is available in the material safety data sheet.
<b>Storage Conditions/ Shelf life</b>	In closed original packaging 9 months at 5-25 °C. The containers should be stored in a dry environment. The adhesive should be used directly after opening the container.

The information provided herein, especially recommendations for the usage and the application of our products, is based upon our knowledge and experience. Due to different materials used as well as to varying working conditions beyond our control we strictly recommend to carry out intensive trials to test the suitability of our products with regard to the required processes and applications. We do not accept any liability with regard to the above information or with regard to any verbal recommendation, except for cases where we are liable of gross negligence or false intention.  
Düsseldorf, March 2005