



سهامی خاص ثبت ۴۸۴۶۱

شرکت صنایع شیمیایی آذین بسپار سپاهان

(Pu Adhesive, Polyol, Saturated polyester)

تولید کننده انواع پلی ال ها، پلی استرهای اشباع، چسبهای پلی یورتان

چسب لمینیت پایه حلالی استریل گرید (HHP⁺)

APSHHPSBL polyurethane adhesives are widely used in manufacturing food-packaging laminates which need high temperature sterilization. They have high performance such as ۱۲۱°C resistance, ۴۰ minutes high-temperature cooking. The advantages include the high solid content, low viscosity and high peel strength. it can be applicable to the high, medium and low speed compound machine of dry composite.

product spec	APSHHPSBL	N-۶۵ (hardener)
appearance	slightly yellow	color less
solid content	۶۵%	۶۵-۶۷%
viscosity cp@۲۵c	۴۰۰-۷۰۰	۱۱۰۰-۱۲۰۰
solvent	ethyl acetate	ethyl acetate
storage temp	۱۵-۲۵c	۱۵-۲۵ c
shelf life	۱۲ months	۳ month
package	۲۲۰ kg barrel	۲۲۰ kg barrel

دستور العمل مصرف چسب

Instruction:

- Use ratio: main agent : curing agent : solvent → ۵:۱:۳-۴
- Adhesives dilution method and working concentration

(۱) Dilution method: put ethylacetate in to the main agent, mix and then add curing agent fully mixing

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سهامی خاص ثبت ۴۸۴۶۱

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(Pu Adhesive, Polyol, Saturated polyester)

تولید کننده انواع پلی ال ها، پلی استرهای اشباع، چسبهای پلی یورتان

..... تاریخ:

..... شماره:

..... پیوست:

(۲) Working concentration: Ordinary adhesives in the ۲۵٪ ~ ۳۰٪, streaming adhesives in the ۲۸٪ ~ ۳۵٪

۳. when main agent mixed with curing agent, please run out in six hours. When the temperature belows $^{\circ}\text{C}$, the mixture could be extended to ۱۲ hours. However, when the mixture appeared turbid or high viscosity, it could not used.
۴. Substrate surface should clean and dry, and no dust pollution. Plastic film surface should be treated by the corona to make its surface tension above 40 dyne/cm . It can obtain the ideal bonding effect.
۵. Coating quantity: It depends on the product usage, dry adhesives coating quantity generally was $3 \sim 4 \text{ g/m}^2$. The material containing aluminum foil should be cooked at 121°C . Coating quantity should be $4 \sim 5 \text{ g/m}^2$.
۶. Complex: The temperature of the composite films usually controls in $50 \sim 100^{\circ}\text{C}$. Transparent film compound is easily influenced by heat, the complex temperature is $50 \sim 60^{\circ}\text{C}$. The complex temperature for aluminum film is $80 \sim 100^{\circ}\text{C}$, and others are $70 \sim 80^{\circ}\text{C}$. Humidity generally controls in $50\% \sim 70\%$, high humidity would greatly influence the adhesive performance.
۷. Dry: In order to make the solvent in the film coated with adhesive evaporation, the film should be through the drying devices. The air flow, speed and the temperature should be controled.
۸. Aging: The composite products after compund treatment should be send to the aging room and they can attain the bonding strength. The temperature was $50 \sim 60^{\circ}\text{C}$. The aging time is more than ۲۴ hours. For cooking products, the aging time is more than ۴۸ hours.

User Guide (notice for use)

۱. Polyurethane adhesives belong to flammable solid. No open flames.

۲. If open the package of the products, please run out in a short time. Curing agent easily absorbs moisture and goes bad. The products should be pay attention to dry, sunscreen and sealed storage.
۳. Polyurethane adhesives should avoid mixing with solvent containing lively hydrogen, such as water, alcohol and amine.
۴. The storage period of main agent is one year. It must be stored in the shadows. If it expires do not go bad, it



still can continue to use.

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