
Technical Data Sheet

MORBOND 675A + MORBOND 675C

MB 675A + MB675C is a two component STRAIGHT CHEMISTRY general purpose LAMINATING adhesive for flexible packaging lamination.

TECHNICAL DATA:

ADHESIVE MORBOND 675

HARDNER MORBOND 675C

Appearance:	Light yellow.	Light Yellow.
Solids Content:	75 % \pm 2%.	75 % \pm 2%
Carrying Solvent:	Ethyl acetate.	Ethyl acetate
Viscosity at 25°C:	2500 \pm 100 mPas/sec.	2000 \pm 1000 mPas/Sec
Functionality:	OH.	NCO.
Mixing Ratio:	100 parts by weight.	20 part by weight

TYPICAL LAMINATES:

Polyester / alufoil.
Alufoil / polyethylene
Polyester / polyethylene.
Metallised polyester / polyethylene.
Polyamide / polyethylene.
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FEATURES & BENEFITS:

- Excellent adhesion to polyester films, alufoil and metallized films.
- Good slip retention on polyethylene films.
- Wide machine tolerance, running well at most machine settings.
- Multi-purpose, providing good bonds to most substrates.
- Product resistance on clear films.
- Good running stability and pot life.

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MIXING / DILUTION DATA:

Solids Content:	40%	35%	30%	25%	
Viscosity at 25°C(ZAHAN CUP 3)	15-17	13-15	11-13	10-11	SECONDS
ADHESIVE MORBONDB 675A	100	100	100	100	SECONDS
HARDENER MORBONDB 675C	20	20	20	20	KILOS.
ETHYL ACETATE	105	137	180	240	KILOS.

First mixes ADHESIVE MORBOND 675A with ethyl acetate followed by homogeneous mixing of both and then add HARDENER CURATIVE 75-60 into the mixture.

APPLICATION SOLIDS:

Typically, MB 675A + MB675C is applied at between 30 % and 45 % solids, depending on the available coating cylinder and the required coating weight.

NIPPING CONDITIONS:

Combine the adhesive coated web to the treated secondary web at between 50°C and 90°C.

F.D.A. STATUS:

The composition of MB 675A + MB675C conforms to the positive list of the American F.D.A. regulations, Chapter 21, Section 175-105 for laminating adhesives.

B.G.A. STATUS:

The composition of MB 675A + MB675C conforms to the positive list of the German B.G.A. regulations, Section XXVIII, 'Cross-linked polyurethanes as adhesives for packaging materials'.

E.E.C. STATUS:

The individual monomers used in the manufacture of MB 675A + MB675C are listed in the Plastics Directive, Section 1, Part 1, 'Authorized Monomers'.

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IMPORTANT SUGGESTION:

NOTE:

- Environmental humidity may affect the final bond of the laminate; hence slight increase in hardener qty may help in such condition.
- We do not suggest remaining adhesive for second operation however If too much of adhesive is left then same can be kept tightly closed in cool place. Use it as diluent with newly made fresh batch by adding small qty.
- The shelf life of MB 675A is 12-months and 10-months for MB675C. Both are extendable by 3-mnth.
- **Coat weight of minimum of 2.5 gsm in non-foil and 3.0-3.5 gsm in foil structure is required.**
- In case of hard / high bond requirement in Foil structure; ratio can be changed from 100 : 20 to 100 : 25
- Bonds requirement should be checked on higher gauge (above 80 mic) poly before any commercial run.
- In case of low green bonds, increase temperature in dryers and increase nip temperature.
- For higher bond strength requirement or poly of 80 micron and above , use ratio 100:25.

For further important and useful information on this product, please consult our general product information sheet entitled 'Solvent Based Laminating Adhesives'.