

**MorBond MB655 + Hardner CT85***Revised Sept 2021***DESCRIPTION:**

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MB655 + CT85 is a 2-component, solvent based, reverse catalysed, polyurethane laminating adhesive system specially formulated for flexible packaging. MB655 + CT85 provides high heat and chemical resistance.

**TECHNICAL DATA:****MB655****CT85**

|                    |                        |                        |
|--------------------|------------------------|------------------------|
| Appearance:        | Clear to slightly hazy | Clear to slightly hazy |
| Solids Content:    | 70% +/- 2%             | 100%                   |
| Carrying Solvent:  | Ethyl Acetate          | Solvent Free           |
| Viscosity at 25°C: | 1,100 – 2,400 mPas     | 250 – 400 mPas         |
| Specific Gravity:  | 1.07                   | 1.04                   |
| Functionality:     | NCO                    | OH                     |
| Mixing Ratio:      | 100 parts by weight    | 3 parts by weight      |

**TYPICAL LAMINATES:**

Laminates can be made with the following substrates:

Orientated Polypropylene (OPP), Vacuum Metallized Orientated Polypropylene (VMOPP),  
Cast Polypropylene (CPP), Vacuum Metallized Cast Polypropylene (VMCPP),  
Treated Polyester (PET), Vacuum Metallized Polyester (VMPET),  
Cast Polyamide (Nylon), Orientated Polyamide (OPA),  
Polyethylene (PE), Linear Low Density Polyethylene (LLDPE)  
Aluminum Foil (ALUFOIL)

**FEATURES & BENEFITS:**

- Multi-purpose, providing good bonds to most substrates and alufoil.
- Suitable for metallised and barrier films.
- Good ink wetting, providing excellent appearance and finish.
- Good hold-out on difficult inks.
- Boiling resistance on clear films and alufoil.
- Product resistance on clear films and alufoil.
- Viscosity profile permits high machine speeds.
- Fast curing permitting slitting in 24 hours.

### **MIXING / DILUTION DATA:**

When mixing always mix the MB655 with solvent before adding the CT85.

|                 |     |     |     |     |       |
|-----------------|-----|-----|-----|-----|-------|
| Solids Content: | 30% | 35% | 40% | 45% |       |
| MB655:          | 100 | 100 | 100 | 100 | Kilos |
| CT85:           | 3   | 3   | 3   | 3   | Kilos |
| Ethyl Acetate:  | 140 | 106 | 80  | 59  | Kilos |
| Total Mixture:  | 243 | 209 | 183 | 162 | Kilos |

### **APPLICATION:**

Depending on the application cylinder available, apply MB655 + CT85 at between 30% and 45% solids to obtain a dry coating weight of between 2.5 / 4.0 g/m<sup>2</sup>. For highest heat and chemical resistant bonds, apply between 3.5 and 4.0 g/m<sup>2</sup>.

### **NIPPING CONDITIONS:**

Combine the adhesive coated web to the treated secondary web at between 40°C and 70°C.

### **USE RECOMMENDATION:**

Since the ingredients in films and inks may interfere with the good performance of this adhesive, customers are strongly recommended to carefully test MB655 + CT85 before using it in production, to check its suitability for each and every end-use requirement.

### **FOODSTUFFS PACKAGING STANDARDS:**

FDA CFR 21 § 175.105 (USA)

ECC 10/2011 (EU)

### **IMPORTANT SUGGESTION:**

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

### **Disclaimer:**

The suggestions for use given above are based on our experience and are believed to be correct. However, no guarantee of good results is given, nor implied. Since the products will be used under conditions that are beyond our control, no warranty is expressed, nor accepted. We strongly recommend and urge customers to conduct preliminary tests to confirm the suitability of the products for their own particular purpose and end-use requirements and under their own operating conditions.

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