



# Ithane 46

(Provisional)

## Description

ITHANE 46 is a solvent-based polyurethane adhesive, with high chemical and thermal resistance.

## Application

ITHANE 46 is suggested for the lamination of transparent and aluminium-containing structures, with and without sandwich printing. Printing ink should be suitable for lamination.

## Technical Specifications

Method of analysis	MU	Standard
1. Total Solids	%	36±1
3. Brookfield Viscosity 25°C	mPa.s	1,000 - 2,000 <sup>(1)</sup>
Solvents		ethylacetate

<sup>(1)</sup> N. 2 RV; 20 RPM

quality of the coated product.

Lamination: at 50-70°C with a rubber roll.

## Packaging

25 kg or 190 kg metal drums.

## Storing

Keep in original hermetically closed drums.

Product must be stored in a ventilated and dry place. Avoid flames presence.

Shelf life is 6 months.

At low temperatures (0-10°C), ITHANE 46 may form a soft gel. The adhesive should be heated (35-50°C) and thoroughly stirred prior to use.

Attention: it contains flammable solvent!

Use within 6 months from production date (unopened and in the original packaging).

## Handling

ITHANE 46 can be applied by common application systems like reverse gravure, direct gravure or with semi flexo smooth

roller system at a solids content of 15-20%.

Use ethyl acetate, acetone and MEK with a maximum water content of 0.2% as diluents.

Avoid alcohols or alcohol containing solvents.

Coating weight: 2-5 g/sqm dry, depending on substrate, printing and application.

The product can be cured with isocyanic crosslinkers, to improve its chemical and thermal resistance. Remember that, in this case, the pot life of the product decreases to max 8 hours.

The drying process has to remove solvents completely, solvent residuals can compromise the