

# FlexTack® 2H50

**Description:** Aqueous adhesive based on modified acrylic dispersion for the manufacture of plastic laminates for sterilizable flexible packaging.

## Specifications:

**Appearance:** Whiteliquid

**Viscosity:** 13-15s(Ford Cup 4, 23 °C)

**Non-volatile content:**44 - 46%

**pH:** 6-8

**Appearance of dry film:** Transparent, glossy and somewhat sticky

**Applications:** Bonding of plastic films for the manufacture of highly demanding flexible packaging. Good adhesion to aluminum foil and the most common plastic films (PP, PET, PE, etc.), whether metallized or not. We recommend applying a dry adhesive quantity of approximately 3 g/m<sup>2</sup>.

An addition of 3-5% FlexTack® Harder 125 increases resistance to heat, water, and chemicals; the mixture of the two components can be used up to 4-5 hours after application. After drying in a hot air tunnel, calendaring between 50 and 80 °C is recommended.

**Properties:** The dry adhesive film is transparent and colourless and has a slight surface tack and very good resistance to light and UV radiation. Very good mechanical stability, with excellent machine performance.

**Recommendations for use:** The adhesive has a tendency to form skins in the presence of air, so the following is important:

- Avoid exposing the adhesive to air to prevent the surface layer from drying out. Close the containers tightly. If a glue drum is used in a machine, it must be covered.
- Avoid foaming (attention to controlled pumping). The foam, when drying, can cause the appearance of solid particles. Filtration by 50 micron mesh is recommended before introducing the adhesive into the tray to retain any particles or skins that may form. Avoid long machine idle periods.

It is recommended to handle laminates after at least 24 hours.

It is very important to take all possible measures for good maintenance of the machinery and good cleaning; This can avoid many problems.

The cleaning of the residues of this adhesive can be easily done with running water, preferably warm or hot.

**Regulations:** Suitable for the production of material for food packaging. For more information, please request a certificate of regulatory compliance.

**Presentation:** 1,000 kg containers.

**Safety and hygiene:**Consult the safety data sheet.

**Storage:** Store in the original container tightly closed at a temperature between 10 and 30 °C. Protect especially from frost and outdoor exposure. It is recommended to use within nine months after the date of manufacture indicated on the package label.

**Note:** These data and indications are based on our current knowledge, not presupposing a legal guarantee about the properties or suitability of the product for a particular application. It is the user's responsibility to carry out their own checks and tests.

Edition 0725

# FlexTack® 4M33

**Description:** Aqueous adhesive based on a modified plastic dispersion.

## Technical characteristics:

**Appearance:** Whiteliquid of very low viscosity.

**Viscosity:** 13to15seconds (Ford Cup n° 4 at 23°C)

**Total solids:** 44-46%approx.

**pH:** approx. 6 – 8.

**Dry film appearance:** transparent, glossy and lightly sticky.

**Aqueous solutions:** One-component adhesive for film to film gluing for the manufacture of flexible packaging for general purposes. Good adhesion on aluminum foil and the most common plastic films (PP, PET, PE, etc.), as they are metalized or not. We recommend applying an approximate amount dry adhesive of 3 g/m<sup>2</sup>.

An addition of approximately 3% of FlexTack® Harder-125 increases resistance the heat, water and chemical agents; this mixture can be used up to 4-5 hours after performing it. It is recommended, after their physical drying, a calendaring between 50 and 80°C; an immediate handling it is possible.

**Properties:** The dry adhesive film is transparent and colourless and presents a light surface tack and excellent resistance to UV radiation. It has a very good mechanical stability and excellent machine behaviour.

**Recommendations:** Adhesive has tendency to form skins in the presence of air, so it must be:

- Avoid exposure of the adhesive to the air (well close adhesive containers; the can of glue used in machine must be well covered; the foam formed can cause the presence of small skins -pay attention to the pump-, etc.).
- Avoid the long machine stop periods.
- To avoid the formation of foam in the glue tray, etc.

We recommend filtering the adhesive by 50 micron mesh when the glue is coming into the gluer, retaining possible formed skins. It is very important to take all possible measures in the equipment to maintain it clean and to avoid problems. The cleaning of the waste of this adhesive can be easily simply by running water; it is more efficient if it can be hot.

**Regulations:** The vast majority of adhesives and products marketed by Samtack, SL are preparations and:

- These not have to be registered under REACH. However, all the substances in our products which are regulated by REACH have already been pre-registered or registered. These contain
- no more than 0.1% of any of the Substances of Very High Concern (SVHC) listed in Annex XIV or are on the list of candidates to it. Otherwise Samtack undertakes to inform all customers affected by the MSDS.

Following the criteria of Regulation (EC) No. 1935/2004, is considered that food packaging adhesive FlexTack® 4M33 represents no danger for health.

**Presentation:** 20, 60 and 1,000 kg containers.

**Health and Safety:** See MSDS.

**Storage:** Keep in its own original container tightly closed until its application at a temperature of 10 to 30 ° C. Protect from frost and especially their exposure to the outside. Its use is recommended before nine months after manufacture (see the package label).

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OBSERVATION : Edition 0424

The product information in this data sheet is the best of our current knowledge and is giving in good faith but without warranty of product properties.

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# FlexTack® 6M30

**Description:** Aqueous adhesive based on a modified plastic dispersion.

## Technical characteristics:

**Appearance:** White liquid of low viscosity.

**Viscosity:** 12 to 14 seconds (Ford Cup n° 4 at 23°C)

**Total solids:** 44-46% approx.

**pH:** approx. 6 – 8.

**Dry film appearance:** transparent, glossy and lightly sticky.

**Aqueous adhesive One-component** gluing for the manufacture of flexible packaging for general purposes. Good adhesion on aluminum foil and the most common plastic films (PP, PET, PE, etc.), as they are metalized or not. We recommend applying an approximate amount dry adhesive of 3 g/m<sup>2</sup>.

An addition of approximately 3% of FlexTack® Hardener 125 increases the resistance; this mixture can be used up to 4-5 hours after performing it. It is recommended, after their physical drying, a calendaring between 50 and 80°C; an immediate handling it is possible.

**Properties:** The dry adhesive film is transparent and colourless and presents a light surface tack and excellent resistance to UV radiation. It has a very good mechanical stability and excellent machine behaviour.

**Recommendations:** Adhesive has tendency to

- form skins in the presence of air, so it must be:
- Avoid exposure of the adhesive to the air (well close adhesive containers; the can of glue used in machine must be well covered; the foam formed can cause the presence of small skins -pay attention to the pump-, etc.).
  - Avoid the long machine stop periods.
  - To avoid the formation of foam in the glue tray, etc.

We recommend filtering the adhesive by 50 micron mesh when the glue is coming into the gluer, retaining possible formed skins. It is very important to take all possible measures in the equipment to maintain it clean and to avoid problems. The cleaning of the waste of this adhesive can be easily simply by running water; it is more efficient if it can be hot.

# TECHNICAL DATA SHEET

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- no more than 0.1% of any of the Substances of Very High Concern (SVHC) listed in Annex XIV or are on the list of candidates to it. Otherwise Samtack undertakes to inform all customers affected by the MSDS.

**Presentation:** 20, 60 and 1,000 kg containers.

**Health and Safety:** See MSDS.

**Storage:** Keep in its own original container tightly closed until its application at a temperature of 10 to 30 ° C. Protect from frost and especially their exposure to the outside. Its use is recommended before nine months after manufacture (see the package label).

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# FlexTack® Harder-125

**Description:** Polyfunctional polyisocyanate emulsifiable in water.

## Technical characteristics:

**Appearance:** Colorless to slightly yellow liquid.

**Viscosity:** 400–800 mPa·s (Brookfield RVT, 23 °C)

**Density:** 1,18g/cm<sup>3</sup>(20 °C)

**Applications:** Crosslinker additive for lamination adhesives for FlexTack and SmarTack series. Adding approximately 3% of FlexTack Harder-125 calculated on the amount of adhesive it is recommended.

The addition should be done under mechanical agitation. It is recommended to prepare the mixture only for 6 to 8 hours following work (later lose effectiveness).

It is advisable to make preliminary tests that are considered necessary depending on the conditions of the materials and use. The product can cause irritation on contact with skin (handled with protective gloves, see Safety Data Sheet).

**Properties:** It has very good resistance to light and UV radiation. The product is very sensitive to moisture, so you should always keep the container closed.

**Recommendations:** To achieve good incorporation of the crosslinking FlexTack Harder-125 requires good mechanical stirring. It should be added slowly over the first component (FlexTack or SmarTack), trying to avoid foaming (which could be caused by excessively high speed agitation or by placing the stirring blade too close to the surface of the glue).

The two-component adhesive so prepared should be used immediately after preparation (loses effectiveness to be prepared 6 hours), having to prepare again last mix this time.

# TECHNICAL DATA SHEET

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FlexTack Harder-125 meets the requirements of the FDA 175.105 for indirect food contact.

**Presentation:** 1.3, 6.5 and 30 kg containers.

**Health and Safety:** See MSDS.

**Storage:** Keep in its own original container tightly closed until its application at a temperature of 10 to 30 °C. Protect from frost and especially their exposure to the outside. Its use is recommended before six months after manufacture (see the package label).

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OBSERVATION : Edition 0125

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