



Technical Information

Issue: December 2015

Product Name

85-600958-4 Nutriflex Cold foil adhesive E01

1. Description / Application

UV-Flexo cold foil adhesive for in-line foil stamping, radical curing.
The product can be used straight out of the container.

2. Product Safety

Intended Use

Food packaging, pharma, or hygiene: **YES**

Only for food packaging inks

These inks are only suitable for use on the non-food-contact side of food packaging, provided that they are applied using the relevant Good Manufacturing Practices (a system for ensuring that products are consistently produced and controlled according to quality standards) and according to the guidelines in this Technical Data Sheet.

The printer, converter and the packer/filler each have a responsibility to ensure that the finished - printed - article is fit for the intended purpose(s) and that the ink and coating components do not migrate into the food at levels that exceed legal, regulatory and industry defined requirements.

Please refer to Siegwerk's "Statement of Composition" for further regulatory information.

In case of specific applications, please contact your technical application service.

For further information, please refer to Siegwerk's Customer Guidance: Printing Inks for Food Packaging ("Know How") on <https://www.siegwerk.com/en/our-responsibility/product-responsibility/customer-communications/food-packaging-safety.html> in particular chapter 5. "The printer's selection of ink" has to be observed.

3. Properties / Substrates

Properties

- Adhesive with low viscosity, printability is similar to a laminating adhesive.

Substrates

- In line Corona pre-treated, orientated polypropylenes (OPP) with min. 40 mN/m surface tension.
- In line Corona pre-treated, biaxially-orientated polypropylenes (BOPP) with min. 40 mN/m surface tension.
- Varnished/primered polypropylenes (label material).
- Selected acrylic varnished polypropylenes.

Further printing substrates after technical evaluation.

Preliminary adhesion tests are recommended.

Consider that at stamping on absorbent materials due to increased application quantity of adhesive, details can get lost at fine drawings and details while compensating the absorption rate.

In case of doubt, please contact in time our technical department.



4. Printing and processing instructions

Flexo printing unit, which is equipped with a special lamination unit and following UV curing unit. Especially suitable for the wet lamination process.

Stamping foil

Use gold and silver cold stamping foils especially recommended for the cold stamping process by the foil manufacturers.

Recommended anilox roller and min. applied quantity

- plastic foils 180 l/cm 6cm³/m²
- paper 100 l/cm 12 cm³/m²

Guidelines for use

Before the print job is started, new materials must be checked for compatibility with the planned laminating adhesive / inks combination, even if their suitability on a comparable type of the same substrate group is proved.

The test prints, especially on self-adhesive labels, have to be examined after die-punching (in particular at the edges) for bond strength, and, if necessary, for resistance to water, the packaging contents and other job-specific requirements.

Due to possible different material shrinkage and other alterations, these examinations must be repeated after one day.

Consequently, for every new job in which printing is done on a known material, but with untested ink and printing combinations, the aforementioned tests have to be carried out as well.

Stir up well each ink or varnish before use. Mainly whites, colours containing white, varnishes, mat varnishes as well as gold and silver inks show sedimentation of essential components.

Please see also the information of the material safety datasheet.

Cleaning

The adhesive can be removed from tools by using methoxypropanol.
Reactive UV-thinners are not suitable for cleaning.

5. Shelf life

This product has under normal conditions a shelf life of **at least 9 months**. Within this period the product is usable in conformity with the indications of this data sheet.

Normal conditions mean:

- Storage in firmly closed, not yet tapped containers.
- Temperatures not exceeding 20°C for weeks or 25°C for days.
- Do not expose open containers to direct sunlight or strong light sources.

Because of the differences in materials for printing, processing conditions and test criteria this Technical Information can only be of an advisory nature. Our data reflect the latest state of our knowledge and are based on the characteristics established in the laboratory and on practical experience. Your own tests with the original materials under the respective conditions are indispensable. We disclaim any liability for applications for which this product is not foreseen.