Epotal® ECO 3702

Adhesive Raw Material

Product description Water-based compostable adhesive according to EN 13432.

Key benefits Lamination adhesive for compostable structures based on a broad variety of compostable films and paper.

Chemical nature Aqueous dispersion of a polyurethane dispersion

Properties

Physical form Liquid, dispersion

Technical data
(not supply specification)

Solid content	DIN EN ISO 3251	~ 40 %
pH value (23°C)	DIN ISO 976	~ 8
Viscosity, dynamic (23°C, 250 1/s)	DIN EN ISO 3219	~ 40 mPa*s

Application

It is recommended applying Epotal® ECO 3702 by reverse gravure coating. For direct gravure coating, the usage of a smoothing bar helps achieving a good coating quality. The smoothing bar should be operated against the web direction.

It is strongly advised to add a water-emulsifiable, polyfunctional isocyanate crosslinker such as Basonat® LR 9056 to improve the overall performance of the adhesive.
We recommend a concentration of 3% of Basonat® LR 9056 based on wet Epotal® ECO 3702. The pot-life of the formulated adhesive after addition of the Basonat® LR 9056 is approximately 4 hours at room temperature. In order to achieve a good coating quality, it is recommended to minimize pot-life as much as possible.

In order the achieve proper wetting on the substrate surface, a wetting agent should be used. We recommend Lumiten I-SC with an amount of 0.1% - 0.5%. Lumiten® I-SC needs to be added under stirring 12 h before applying the adhesive.

When Epotal® ECO 3702 is applied by gravure coating at higher speed, addition of a defoamer is recommended.
A possible defoamer is Tego® Antifoam 2291 with an amount of 0.05% - 0.1%. To minimize separation of the defoamer, we recommend to stir the formulated adhesive during lamination process.

If thickeners are added or if Epotal® ECO 3702 is mixed with other products, it is important to make sure that none of the components has a pH of lower than 7 in order to prevent coagulation. Epotal® ECO 3702 can only be mixed with anionic dispersions or with dispersions that contain a protective colloid.

Manufacturers must carefully carry out their own trials when developing adhesives based on Epotal® ECO 3702, as there is a host of factors in production and processing that we cannot cover exhaustively in our trials, which can influence compatibility with other components of the adhesives, their wetting of and adhesion to different substrates etc.

Storage

Store protected against freezing.

The product should not come in contact with exposed iron or non-ferrous metal during storage or processing.

Keep container tightly sealed.

The headspace of bulk storage tanks must be kept saturated with water vapor.

Safety

When handling this product, please comply with the advice and information given in the safety data sheet and observe protective and workplace hygiene measures adequate for handling chemicals.

Note

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