



## ADHESIVES AND SEALANTS

### **ADCOTE™ 555/ADCOTE 536B** **Laminating Adhesive**

#### **Description**

Adcote 555 is an isocyanate terminated polyester urethane component of a two component, high-application solids adhesive system. The use of Adcote 536B is required to achieve full cure properties. This adhesive system adheres to a variety of substrates with excellent heat and chemical resistance.

Adcote 555/Adcote 536B is designed for laminating aluminum foil and a variety of polyester, polyolefin and coextruded films typically used in food, medical and industrial packaging applications. Adcote 555/Adcote 536B is suggested for optimum performance where slip modified films are used and applications requiring excellent heat and chemical resistance. Adcote 555/Adcote 536B also offers the benefit of a low nip temperature requirement, especially useful when producing temperature sensitive constructions.

#### **Typical Properties\***

	<b>Adcote 555</b>	<b>Adcote 536B</b>
Solids	70% ± 3%	75%
Viscosity at 25°C	1700 ± 800 cps	1800 cps
Weight/Gallon	8.5 lbs	9.4 lbs
Solvent	Ethyl acetate	Ethyl acetate
Mix Ratio	100 pbw	13.0 pbw
Diluents	Urethane grade ethyl acetate, NP acetate, methyl ethyl ketone or toluene	
Shelf Life	360 days	360 days

\*These items are provided for general information only. They are approximate values and are not considered part of a product specification.

#### **Recommended Operating Conditions**

Application Method	Direct gravure
Application Cylinder	130–200 line
Application Solids	35–45%
Dry Adhesive Weight	1.5–3.0 lbs/ream, 2.4–4.8 gsm
Dry Web Temperature	150–180°F / 65–82°C
Lamination Temperature	120–220°F / 49–104°C
Cure Time	3-5 days at 70°F / 21°C
Slitting/Rewinding Time	4–8 hours at 70°F / 21°C
Cleaning Solvent	Methyl ethyl ketone, ethyl acetate, NP acetate, or toluene

Dilution of Adcote 555/Adcote 536B below 30% solids may cause mechanical stability problems.

Adcote 555 is moisture sensitive. Containers should not remain open for an extended period of time.

### Suggested Mixing Procedure

1. Pre-weigh Adcote 555 into a clean, mixing container that is properly grounded.
2. Add the appropriate amount of urethane grade solvent.
3. With gentle mixing, add the recommended amount of Adcote 536B.

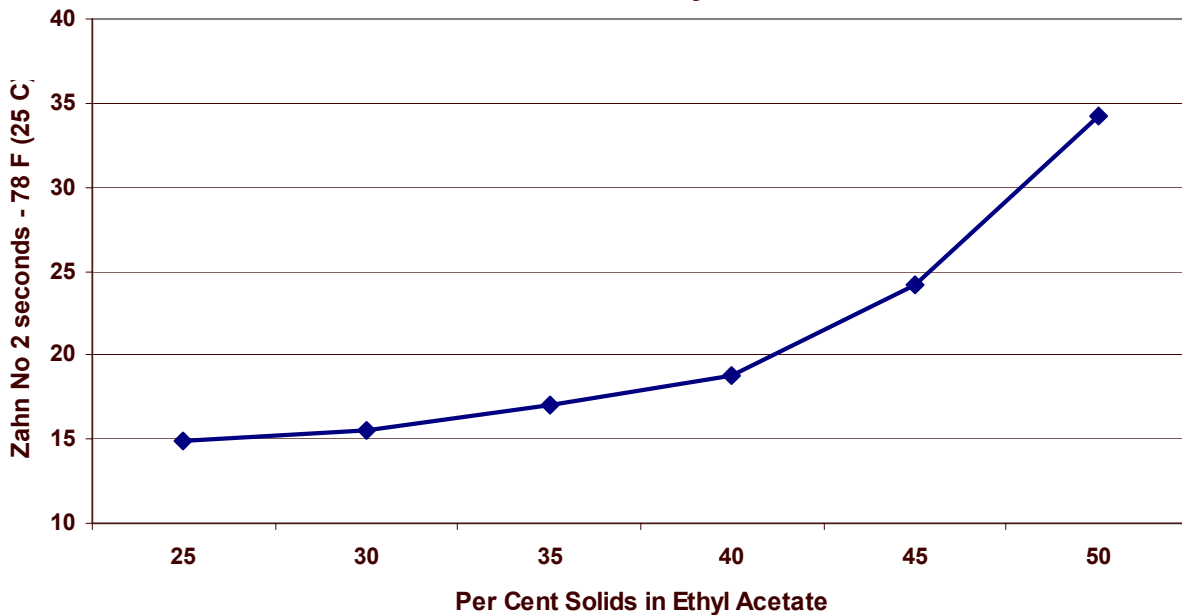
**Note:** The Adcote 555, Adcote 536B, and the mixing procedure involves handling of flammable solvents.

1. Ensure there is adequate ventilation when handling and mixing.
2. Ensure that the necessary grounding or bonding attachments are used on all containers and mixing vessels to avoid any static charge buildup while opening containers, pouring the mixture components and during mixing.

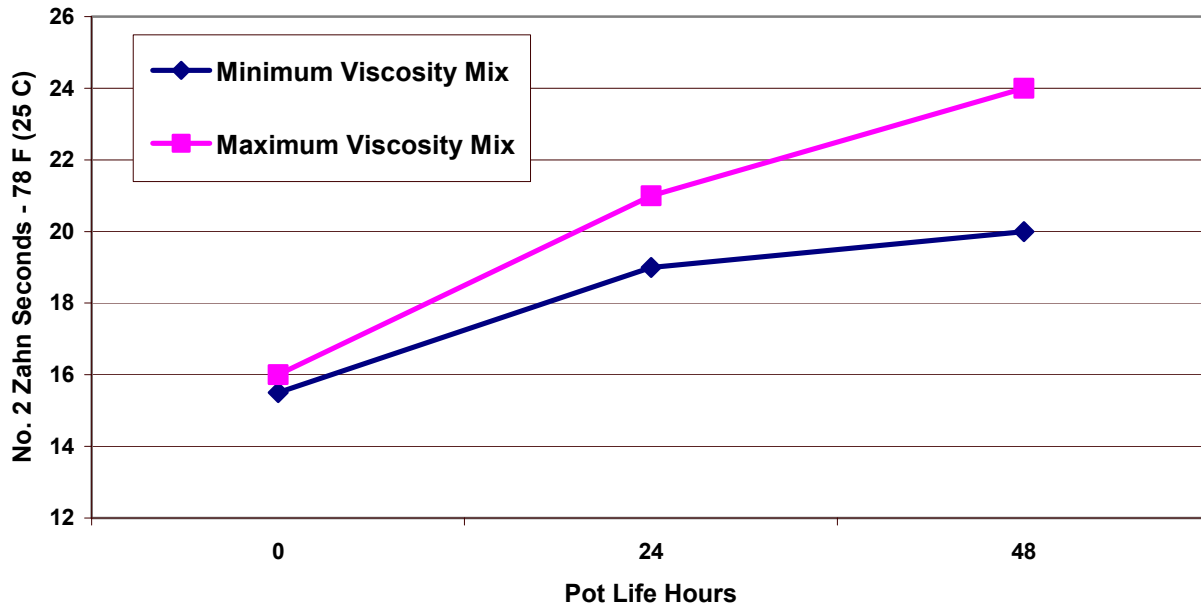
### Suggested Per Cent Solids Mixes (measured by weight)

Percent Solids	Adcote 555	Adcote 536B	Solvent	Total Mix
70.6	100	13	0	113
50	100	13	47	160
45	100	13	64	177
40	100	13	87	200
35	100	13	115	228
30	100	13	153	266

### Adcote 555 / 536B Solids - Viscosity No. 2 Zahn seconds



## Adcote 555 / 536B Static Pot Life - 40 % Solids



### Cleaning

1. Immediately clean up spills and splashes in an approved manner.
2. Wash and clean adhesive wetted parts with acetate or ketone solvents at the end of the production run before the adhesive's cure progresses too far, ensuring complete removal of the adhesive residue. Cured adhesive will be much more difficult to solvent clean from metal parts and from the application cylinder.
3. Cured adhesive may have to be cleaned by long term soaking in solvents, using chemical cleaners or sending the parts to be professionally cleaned.

### Safety, Handling and Storage

- Store in cool, dry, well-ventilated area away from heat and ignition sources. Keep containers tightly closed.
- Hot organic chemical vapors can suddenly and without warning combust when mixed with air. Ignition can occur at typical, elevated-temperature process conditions. Please evaluate such processes to assure safe handling conditions.
- Support and ground containers before opening, dispensing, mixing, pouring, or emptying. Open with non-sparking tools. If container is warm, open bung slowly to release the internal pressure.
- Wash thoroughly after handling. Wash contaminated goggles, face shield, and gloves. Professionally launder contaminated clothing before re-use.
- ATTENTION! Container can be hazardous when empty. Follow label warnings even after container is empty. Do not use heat, sparks, open flames, torches or cigarettes on or near empty containers. Do not reuse empty container without professional cleaning.
- Refer to Material Safety Data Sheet for more information.

Adcote is a registered trademark of Rohm and Haas Company.

These suggestions and data are based on information we believe to be reliable. They are offered in good faith, but without guarantee, as conditions and method of use of our products are beyond our control. We recommend that the prospective user determine the suitability of our materials and suggestions before adopting them on a commercial scale.

Suggestions for uses of our products or the inclusion of descriptive material from patents and the citation of specific patents in this publication should not be understood as recommending the use of our products in violation of any patent or as permission or license to use any patents of the Rohm and Haas Company.

Visit us at <http://www.rohmhaas.com/AdhesivesSealants>

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# Rohm and Haas Food and Drug Opinion

**Product Name:** ADCOTE(TM) 555

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<b>Regulation Number</b>	<b>Complies</b>	<b>Limitations</b>	<b>Opinion Date</b>
1CFR175.105	L	1	Feb 06, 2002

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**Legend:**

**L** Yes, this product is cleared with limitations as noted.

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**Limitations:**

**1** SOLVENT MUST BE COMPLETELY EVAPORATED DURING DRYING AND CURING.

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**Regulations:**

**21CFR175.105** ADHESIVES

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**Disclaimer:**

This information relates specifically to this product. We believe this information to be accurate and reliable as of this date. We recommend that our customers make their own determination on the suitability of this product for their particular application. We cannot guarantee that the indirect food additives/food-contact status of this product will remain unchanged indefinitely; therefore we recommend that you periodically verify its status.

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## Rohm and Haas Food and Drug Opinion

**Product Name:** ADCOTE(TM) 536B ADHESIVE

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<b>Regulation Number</b>	<b>Complies</b>	<b>Limitations</b>	<b>Opinion Date</b>
21CFR175.105	L	1	Oct 25, 2002
21CFR175.300	N		Apr 14, 2003
21CFR177.1390	N		Apr 14, 2003

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**Legend:**

**L** Yes, this product is cleared with limitations as noted.  
**N** No, this product is not cleared.

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**Limitations:**

**1** SOLVENT MUST BE COMPLETELY EVAPORATED DURING DRYING AND CURING.

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**Regulations:**

**21CFR175.105** ADHESIVES  
**21CFR175.300** RESINOUS AND POLYMERIC COATINGS  
**21CFR177.1390** LAMINATE STRUCTURES FOR USE AT TEMPERATURES OF 250F AND ABOVE

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