Supplier grade — model assigned per order

PVC/PET Film to Steel & Aluminum Lamination Adhesive

PRODUCT DESCRIPTION

Single-component solvent-based adhesive for laminating decorative PVC/PET film to cold-rolled steel, aluminum and galvanized sheet on a heated production line.

APPROVED APPLICATION SCOPE

PVC/PET decorative film to cold-rolled steel, aluminum or galvanized sheet. Requires a controlled coating and oven/heated-line process; not intended for manual ambient-temperature lamination.

TECHNICAL DATA

Property	NC-verified value
Appearance	Colorless to pale-yellow transparent viscous liquid
Viscosity at 25 °C	120–140 s, Ford cup No. 4
Solid content	20–30%
pH	6–7
Initial set	≤ 5 seconds under the validated line process
Optimum strength	After 24 hours
180° peel strength	> 50 N (GB 2790-81)
Erichsen cupping	≥ 5 mm
Typical coating weight	40–50 g/m²
Required sheet temperature	150–210 °C

DIRECTIONS FOR USE

- Degrease and prepare sheet and film; validate surface treatment and line compatibility.
- Apply 40–50 g/m² uniformly. Too much or too little adhesive reduces bond performance.
- Heat the sheet to the validated range of 150–210 °C and laminate with controlled pressure and line speed.
- Condition for 24 hours before final bond evaluation. Approve a line trial before commercial production.

STORAGE & PACKAGING

Store tightly sealed in a cool place. Shelf life: six months. Typical packaging: 200 kg galvanized drum.

CONTROL NOTE No fixed public model is assigned in the NC supplier master. The sales order must identify the approved supplier grade and batch before shipment.

SAFETY & LIMITATION

For professional or industrial use only. Read the current Safety Data Sheet before handling. Wear suitable gloves and eye protection, ventilate the work area and keep containers closed. This TDS provides guidelines, not a production specification. The purchaser must validate suitability, process settings and finished-product performance under actual operating conditions.