

Portion Packs

Coatings, Heat Seal Lacquer, Laminating
Adhesives and Primer

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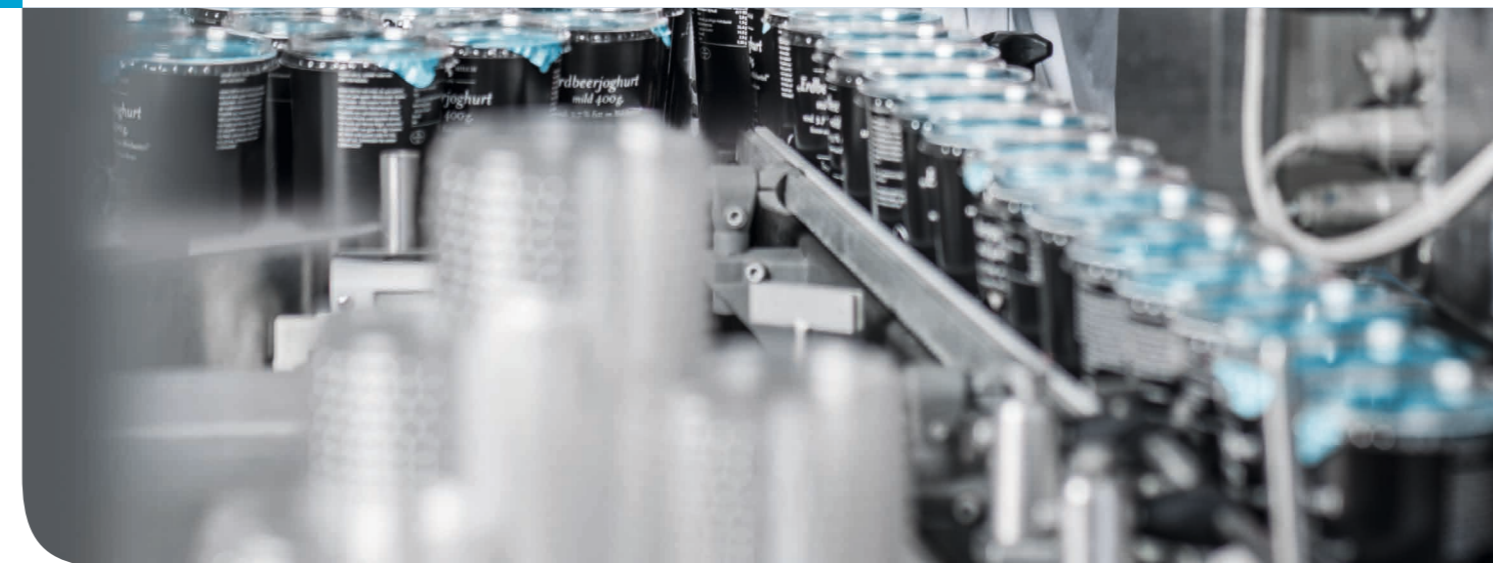
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ACTEGA-products for Portion Packs stand out due to:

- Excellent sterilization resistance
- Highest deep-drawability
- Availability in a great variety of color tones

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Coatings

Substrate	Product-function	Application Area		Technical Information									Food Contact Regulation***						Product Description	Productname	Company	
		exterior	interior	Solids* [%]	Film Weight** [g/m²]	Recommended PMT/ Substrate-temperature [°C]	Formulation		Application Process	BPA-NI	PVC-NI	MF-NI	FDA		EU	Swiss Ordinance	China	Nestlé approved				
							Solvent-based (SB)	Water-based (AQ)				175.105	175.300	10/2011/EC		SR.817.023.21	GB 9685-2008					
Alu	Protective	●	●	36 – 38	2,5 – 3,5	>150	●		Gravure		●	●	●	●	●	●	●	●	●	Retortable, imprintable with 2 component gravure & flexo inks, for non pre-treated aluminum, deep-drawable, clear, glossy	ACTEcoat K-9007-30	ACTEGA Rhenania
Alu	Protective	●		32 – 36	2,0 – 3,0	>150	●		Gravure		●	●	●	●	●	●	●	●	●	Retortable, highly heat pressure resistant, imprintable with 2 component gravure & flexo inks, deep-drawable, gold, glossy	ACTEcoat SC-240-1354	ACTEGA Rhenania
Alu	Protective			30 – 50	colourspecific	>150	●		Gravure	●	●	●	●	●	●	●	●	●	●	Deep-drawable, retortable, glossy, improved adhesion for critical aluminum-alloys, light packages e.g. pet food body, different colorshades available	ACTEcoat SC-320 series	ACTEGA Rhenania
Alu	Protective	●	●	46 – 50	2,2 – 2,8	>150	●		Gravure	●	●	●		●	●	●	●	●	●	Non-retortable, substrate pretreatment necessary, deep-drawable, clear, glossy	ACTEcoat CM-002-AC	ACTEGA Rhenania
Alu	Protective	●	●	45 – 49	8,0 – 12,0	>150	●		Gravure		●		●	●	●	●	●	●	●	Non-retortable, for non pre-treated aluminum, deep-drawable, white, glossy	ACTEcoat EB-2657-A	ACTEGA Rhenania
Alu	Protective	●	●	58 – 62	8,0 – 12,0	>150	●		Gravure		●		●	●	●	●	●	●	●	Non-retortable, for non pre-treated aluminum, high solids, deep-drawable, white, glossy, different colorshades available	ACTEcoat CM-251-W133	ACTEGA Rhenania
Alu	Protective	●		30 – 50	colourspecific	>150	●		Gravure	●	●	colourspecific	●	●	●	●	●	●	●	Deep-drawable, glossy, improved adhesion for critical aluminum-alloys, light packages e.g. menutrays, different colorshades available	ACTEcoat CM-320 series	ACTEGA Rhenania
Alu	Protective	●	●	33 – 35	colourspecific	>150	●		Gravure		●	colourspecific	●	●	●	●	●	●	●	Sealable to mylar-film, deep-drawable, glossy, improved adhesion for critical aluminum-alloys, light packages e.g. menutrays, different colorshades available	ACTEcoat CM-291 series	ACTEGA Rhenania

* After DIN EN ISO 3251 usually measured by 30 min, 180°C

** Dry, divergent weight possible

*** ● Only non-alcoholic food

Heat Seal Lacquer

Substrate	Technical Information					Food Contact Regulation*						Product Description	Productname	Company	
	Formulation		Application Process	BPA-NI	PVC-free	MF-NI	FDA		EU	Swiss Ordinance	China				Nestlé approved
Solvent-based (SB)															
	MEK (Methyl-Ethyl-Keton)	EAC (Ethyl-Acetat)				175.105	175.300	10/2011/EC	SR.817.023.21		GB 9685-2008				
Alu	●		Gravure	●		●	●	●	●		●	●	Retortable, clear, glossy	ACTEseal HM-660-0376	ACTEGA Rhenania
Alu		●	Gravure	●	●	●	●	●	●		●	●	Dual ovenable, opaque	ACTEseal HL-147-C-EE5	ACTEGA Rhenania
Alu		●	Gravure	●	●	●	●	●	●		●	●	Higher initial seal temperature version of HL-147-C-EE5, clear, mat	ACTEseal HL-147-R-EE	ACTEGA Rhenania
Alu	●		Gravure	●		●	●	●	●		●	●	Retortable, clear glossy, good price-performance-balance, corrosion resistance	ACTEseal HS-391 series	ACTEGA Rhenania
Alu	●		Gravure	●		●	●	●	●		●	●	Individual set of colors and solvent combinations available	ACTEseal HM-660 series	ACTEGA Rhenania
Alu	●		Gravure	●		●	●	●	●		●	●	Retortable, white version of HS-391	ACTEseal HS-400	ACTEGA Rhenania

* ● Only non-alcoholic food

Laminating Adhesives

Substrate		Food Contact Regulation*			Product Description	Technical Information Adhesive			Technical Information Hardener		Mix Ratio	Formulation	Performance			Film weight*** [g/m²]	Nip Station [°C]	BPA-NI	Company
Foil	Film	FDA 175.105	177.1390	EU 10/2011/EC		Productname	Solids** [%]		Productname	Solids** [%]			medium	medium - high	high				
●	cPP	●	●	●	Retort applications, good filling resistance, thermal and chemical resistance, especially for aluminum containing laminates, Hardener aliphatic (HDI based)	ACTEbond ASB-203	49	HT-038-S	100	100:5	Solvent-based		●	3,5 – 6,0	30 – 80	●	ACTEGA Rhenania		
●	cPP	●	●	●	Retort applications, good filling resistance, thermal and chemical resistance, especially for aluminum containing laminates, Hardener aliphatic (HDI based)	ACTEbond ASB-204-Z	49	HT-039-S	100	100:5	Solvent-based		●	3,5 – 6,0	30 – 80	●	ACTEGA Rhenania		
●	cPP	●	●	●	Retort applications, good filling resistance, thermal and chemical resistance, especially for aluminum containing laminates, Hardener aliphatic (HDI / IPDI based)	ACTEbond ASB-204-Z	49	HT-049-S	85	100:7	Solvent-based		●	3,5 – 6,0	30 – 80	●	ACTEGA Rhenania		
●	cPP	●	●	●	Retort applications, especially suitable for aggressive fillings, hardener aliphatic (HDI based)	ACTEbond ASB-232-Z	48	HT-039-S	100	100:5	Solvent-based		●	3,5 – 6,0	50 – 70	●	ACTEGA Rhenania		
●	cPP	●	●	●	Retort applications, especially suitable for aggressive fillings, hardener aliphatic (HDI / IPDI based)	ACTEbond ASB-232-Z	48	HT-049-S	85	100:7	Solvent-based		●	3,5 – 6,0	50 – 70	●	ACTEGA Rhenania		
●	cPP	●	●	●	Colored versions of corresponding clear adhesives	ACTEbond ASB-203 series ACTEbond ASB-905 series	colourspecific	HT-049-S	85	100:7	Solvent-based	colourspecific				●	ACTEGA Rhenania		

* For further detailed statements please contact our technical sales experts.

** After DIN EN ISO 3251 measured by 30 min, 180°C

*** Dry, divergent weight possible

Primer

Substrate	Technical Information											Food Contact Regulation***					Product Description	Productname	Company			
	Solids [%]	Measuring Method*	Film Weight** [g/m²]	Drying Conditions			Formulation		Application Process		BPA-NI	PVC-free	MF-NI	FDA		EU				Swiss Ordinance	China	Nestlé approved
				Recommen- ded PMT [°C]	IR Dryer	Hot Air	Solvent- based (SB)	Water- based (AQ)	Gravure	Flexo				175.105	175.300							
Alu	38 – 42	1	0,5 – 0,9	>150			●		●			●	●	●	●	●	●	●	Catalyst SP-829 required, clear	ACTEcoat HL-128	ACTEGA Rhenania	
Alu	28 – 32	1	1,8 – 2,2	<120			●		●			●	●	●	●	●	●	●	Primer for HSL	ACTEcoat HM-630-0309	ACTEGA Rhenania	
Alu	36 – 38	1	1,0 – 2,0	>150			●		●			●	●	●	●	●	●	●	Retortable, imprintable with 2 component gravure & flexo inks, for non pre-treated aluminum, deep-drawable, clear, glossy	ACTEcoat K-9007-30	ACTEGA Rhenania	
Alu	32 – 36	1	2,0 – 3,0	>150			●		●			●	●	●	●	●	●	●	Retortable, highly heat pressure resistant, imprintable with 2 component gravure & flexo inks, deep-drawable, gold, glossy	ACTEcoat SC-240-1354	ACTEGA Rhenania	
Alu	32 – 36	1	1,5 – 1,9	>150			●		●	●	●	●	●	●	●	●	●	●	Deep-drawable, retortable, glossy, improved adhesion for critical aluminum-alloys, light packages e.g. pet food body, different colorshades available	ACTEcoat SC-320 series	ACTEGA Rhenania	
Alu	46 – 50	1	2,2 – 2,8	>150			●		●	●	●	●	●	●	●	●	●	●	Non-retortable, substrate pretreatment necessary, deep-drawable, clear, glossy	ACTEcoat CM-002-AC	ACTEGA Rhenania	
Alu	45 – 49	1	8,0 – 12,0	>150			●		●			●	●	●	●	●	●	●	Non-retortable, for non pre-treated aluminum, deep-drawable, white, glossy	ACTEcoat EB-2657-A	ACTEGA Rhenania	
Alu	58 – 62	1	8,0 – 12,0	>150			●		●			●	●	●	●	●	●	●	Non-retortable, for non pre-treated aluminum, high solids, deep-drawable, white, glossy, different colorshades available	ACTEcoat CM-251-W133	ACTEGA Rhenania	
Alu	30 – 50	1	colourspecific	>150			●		●	●	●	colospecific	●	●	●	●	●	●	Deep-drawable, glossy, improved adhesion for critical aluminum-alloys, light packages e.g. menutrays, different colorshades available	ACTEcoat CM-320 series	ACTEGA Rhenania	
Alu	33 – 35	1	colourspecific	>150			●		●			●	colospecific	●	●	●	●	●	Sealable to mylar-film, deep-drawable, glossy, improved adhesion for critical aluminum-alloys, light packages e.g. menutrays, different colorshades available	ACTEcoat CM-291 series	ACTEGA Rhenania	
Alu	25 – 30	2	1,0 – 2,0			●		●	●	●									Matt pre print primer	TerraWet PrimerG 16/109	ACTEGA Terra	
Alu	40 – 45	2	1,0 – 2,0			●		●	●	●					●			●	Primer for aluminum foil to be printed with NC inks	TerraWet Primer G 16/215	ACTEGA Terra	
Alu	25 – 30	2	0,8 – 2,0			●		●	●	●					●				Pre print primer	TerraWet Primer G 16/305	ACTEGA Terra	
Alu	34 – 39	2	1,0 – 2,0		●	●		●		●					●			●	Primer to be coated with UV coatings or for laminations	TerraWet Primer G 9/601 FoodSafe	ACTEGA Terra	

* Measuring methods:
 1) After DIN EN ISO 3251 usually measured by 30 min, 180°C
 2) After Sartorius Moisture Analyzer

** Dry, divergent weight possible
 *** ● Only non-alcoholic food

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