

## Blister

Coatings, Heat Seal Lacquer, Laminating  
Adhesives and Primer

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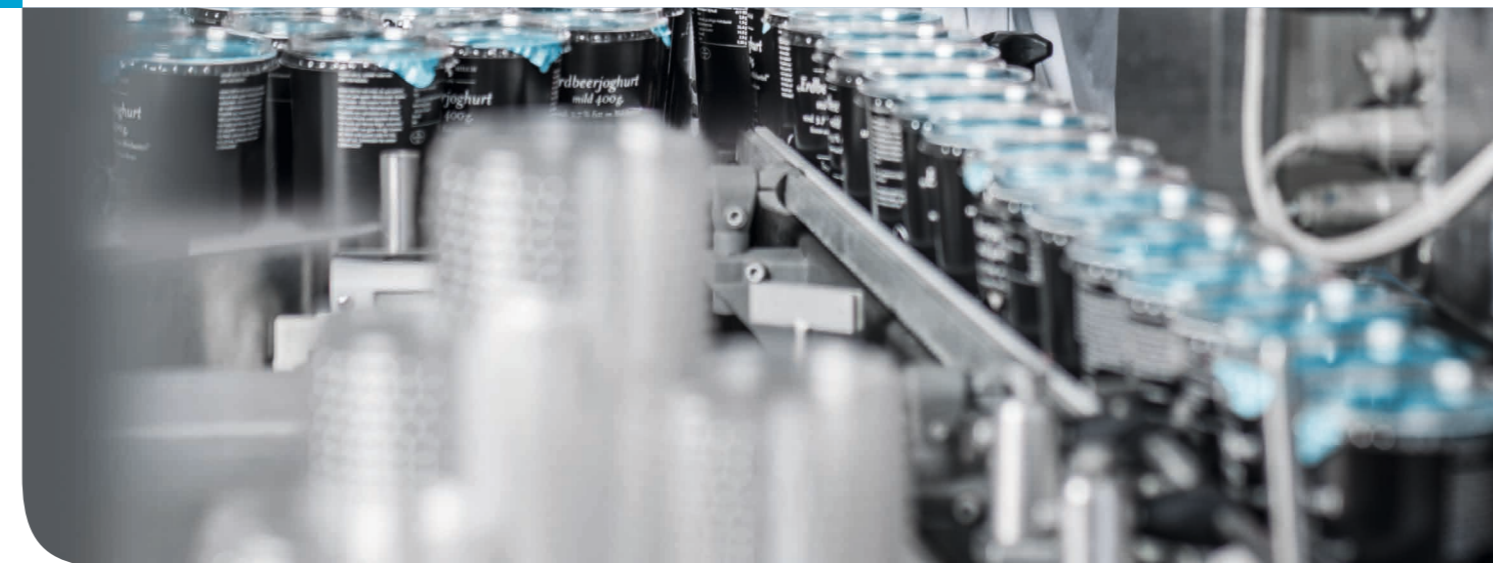
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ACTEGA-products for Blister are characterized by:

- Good rolling-oil tolerance on hard foil
- Long time experience in fulfilling high requirements of the pharma industry

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# Coatings

Substrate			Product-function	Application Area	Technical Information											Food Contact Regulation***					Product Description	Productname	Company			
Paper	Foil	Film			Solids [%]	Measuring Method*	Film Weight** [g/m²]	Drying Conditions			Formulation		Application Process		BPA-NI		PVC-NI	FDA		EU	Swiss Ordinance	China	Nestlé approved			
								Recommend-ed PMT / Substrate-temperature [°C]	IR Dryer	Hot Air	Solvent-based (SB)	Water-based (AQ)	Gravure	Flexo				175.105	175.300	10/2011/EC	SR.817.023.21	GB 9685-2008				
	●		Protective	Exterior	37 – 41	1	1,0 – 1,4	>150			●		●		●	●	●	●	●		●	OPV, Heat pressure resistant, clear, glossy	ACTEcoat SL-819-V	ACTEGA Rhenania		
●	●	PE	Protective	Exterior	32 – 36	1	0,8 – 1,2	<120				●	●		●	●	●	●	●	●	●	OPV, Heat pressure resistant, clear, glossy	ACTEcoat SW-001-0277	ACTEGA Rhenania		
	●		Protective	Exterior	35 – 39	1	0,3 – 0,9	<120			●		●	●	●	●	●	●	●		●	Catalyst ZU-322 required, suitable for printing lines pmt ~100°C, clear, glossy, only for full surface printing	ACTEcoat SL-819-DWA	ACTEGA Rhenania		
	●	BoPP, PP, oPP	Protective	Exterior	40 – 50	2	1,0 – 2,0		●	●		●	●						●		●	Neutral coating	TerraWet Protective Coating G 9/221 M	ACTEGA Terra		
●	●	BoPP, PP, oPP	Protective	Exterior	37 – 42	2	1,0 – 2,0		●	●		●	●						●		●	Neutral coating	TerraWet Protective Coating G 9/221 FoodSafe	ACTEGA Terra		
	●	BoPP, PP, oPP	Top Coat	Exterior	25 – 30	2	0,8 – 2,0			●		●	●	●					●			Transparent topcoat with good scratch resistance, printable	TerraWet Primer G 16/305	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

\*\*\* ● Not directly listed, but in compliance

● Only non-alcoholic food

# Heat Seal Lacquer

Substrate		Sealing Partner							Technical Information							Food Contact Regulation**					Product Description	Productname	Company			
Foil	Film	PP	PS	APET	PVC	Itself	Alu	Others	Sealing Values [N]	Sealing Temperature [°C]	Formulation		Application Process	BPA-NI	PVC-NI		MF-NI	FDA		EU	Swiss Ordinance	China	Nestlé approved			
											MEK (Methyl-Ethyl-Keton)	EAC (Ethyl-Acetat)						175.105	175.300							
●					●	●			13 – 17	280	●		Gravure	●			●	●	●	●	●	●	●	Retortable, clear, glossy-resistant	ACTEseal HM-660-0376	ACTEGA Rhenania
●					●		TBT*	PVDC	10 – 14	180	●	●	Gravure	●			●	●	●	●	●	●	●	Good price-performance balance, mat	ACTEseal HM-070	ACTEGA Rhenania
●							TBT*		18 – 28	230	●	●	Gravure	●			●	●	●	●	●	●	●	High sealing values, mat	ACTEseal HM-072-M	ACTEGA Rhenania
●					●		TBT*	PVDC	11 – 15	180	●	●	Gravure	●			●	●	●	●	●	●	●	Transparent version of HM-070	ACTEseal HM-071-T	ACTEGA Rhenania
●		●							8 – 12	170	●		Gravure	●	●		●	●	●	●		●	●	For PP and PE Blister, mat	ACTEseal HM-150-0316	ACTEGA Rhenania
	●			●					11 – 13	200		●	Gravure	●	●		●	●	●	●	●	●	●	APET blister, mat	ACTEseal HSC-147-G	ACTEGA Rhenania
●			●		●			PVDC	6 – 11	200	●		Gravure	●	●		●	●	●	●	●	●	●	Clear, glossy, good hot-tack	ACTEseal HS-590	ACTEGA Rhenania

\* TBT = To be tested

\*\* ● 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				
●	PVC, oPA	●	●	●	Thermal and chemical resistance, especially for aluminum containing laminates ( <b>no primer</b> for aluminum to oPA-side <b>necessary</b> ), Hardener aliphatic (HDI based)	ACTEbond ASB-203	49		HT-038-S	100	100:5	Solvent-based			●	3,5 – 4,5	50 – 70	●	ACTEGA Rhenania
●	PVC, oPA	●	●	●	Thermal and chemical resistance, especially for aluminum containing laminates (primer for aluminum to oPA-side necessary), Hardener aliphatic (HDI based)	ACTEbond ASB-232-Z	48		HT-038-S	100	100:5	Solvent-based			●	3,5 – 4,5	50 – 70	●	ACTEGA Rhenania
●	PVC, oPA	●	●	●	<b>Colored</b> versions of corresponding clear adhesives	ACTEbond ASB-203-series ACTEbond ASB-905-series	colourspecific		HT-038-S	100	100:5	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		
Paper	Foil	Film	Solids [%]	Measuring Method*	Film Weight** [g/m²]	Drying Conditions		Formulation		Application Process		BPA-NI	PVC-NI	MF-NI	FDA		FDA	EU	Swiss Ordinance	China	Nestlé approved		
						Recommended PMT [°C]	Hot Air	Solvent-based (SB)	Water-based (AQ)	Gravure	Flexo												
	●		37 – 41	1	1,0 – 1,4	166 – 177		●		●		●	●		●		●	●		●	Heat pressure resistant, UV- and Laser imprintable, clear, glossy	ACTEcoat SL-819-V	ACTEGA Rhenania
	●		35 – 39	1	0,3 – 0,9	99 – 104		●		●	●		●		●		●	●		●	Suitable for printing lines pmt~100°C, heat pressure resistant, clear, glossy	ACTEcoat SL-819-DW	ACTEGA Rhenania
	●		35 – 39	1	0,3 – 0,9	99 – 104		●		●	●		●		●		●	●		●	Catalyst to ZU-322 required, 2 pack version of SL-819-dw, clear, glossy	ACTEcoat SL-819-DWA	ACTEGA Rhenania
		PE	32 – 36	1	0,8 – 1,2	130			●	●			●		●		●	●	●	●	Waterbased, heat pressure resistant, imprintable with flexo-, gravure- and UV-inks, clear, glossy	ACTEcoat SW-001-0277	ACTEGA Rhenania
	●		38 – 42	1	0,5 – 0,9	171		●		●			●	●	●		●	●	●	●	Catalyst SP-829 required, clear, primer for laminating Alu to OPA side for tropical blister	ACTEcoat HL-128	ACTEGA Rhenania
	●	BoPP, oPP, PP	25 – 30	2	1,0 – 2,0		●		●	●	●										Matt pre print primer	TerraWet PrimerG 16/109	ACTEGA Terra
●			28 – 34	2	0,5 – 1,0		●		●	●										●	Primer for metallization	TerraWet Primer G 16/216	ACTEGA Terra

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