

Rexta™

Solvent Lamination Retort Ink

Physical Characteristics

- Very low solvent retention and odor.
- Swiss Ordinance compliant.
- Bond performance to an array of lamination structures.
- Sterilization, boil and Retort capable.
- Proven performance for applications that require resistance properties such as detergents.

Solvent Reducers:

- Standard: 85/15 N-Propyl Alcohol / N-Propyl Acetate
- Fast blend: 80/20 Ethyl Alcohol / N-Propyl Acetate
- Slow blend: 80/20 N-Propyl Alcohol / PM Acetate
- Slow reducers: Glycol PnB, Pnp, PE, *use only as needed for print quality.*

Structures:

- BOPP/ink/adh/BOPP
- BOPP/ink/adh/LLDPE
- PET/ink/adh/LLDPE
- BOPP/ink/adh/BOPP/AF
- BOPP/ink/adh/LLDPE/AF
- *More specific structures can be requested by the TIA R&D center for ink properties and performance results.*

Adhesives tested:

- Toyo-Morton TM219/CAT-10 & TM386/CAT-29BL
- Ashland Purelam™ A 9500 / B 9240
- Henkel LA 7660 / LA 6029
- H.B. Fuller WD4120 / WD4132

Suggested Laminator Settings:

- Adhesive coating weight should be 1.0 – 1.2 lb/rm, consistent across full web
- Nip roller temperature should be 120-130.
- Nip roller pressure should be around 40 psi, consistent across full web
- Assuring the adhesive to catalyst ratio is correct. Incorrect balance can cause issues with application, wet out, and lamination performance.
- *Properties tested under controlled laboratory conditions.*

Press Conditions:

- Process Inks: 800 – 1000 LPI aniloxes
- Press speeds: 600 fpm – 1000+ fpm
- Web Pin-on temps: PP 130F – 140F, PET 165F – 175F

Ink Specifications:

- Shipping viscosity: 15-20 sec. #3 Signature Zahn
- Print viscosity-process inks: 24-30 sec. #2 Signature Zahn
- Ave.% Solids-Color= 30-45, Ave.% Solids-White= 55-70
- Shelf life: 12 months from manufactured date
- Ink Storage- 50F-100F in provided containers, out of direct sun.

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