

Solvent-based universal Heat sealing lacquer for food packaging. One-component direct adhesive lacquer for ALU, PET, PP, and PAPER lidding folils. Suitable for sealing packaging made of ALU, PET, PS, PP, PVC, and PLA. Especially recommended for single-use water cups, soft drinks and dairy products.

Product description, components:

Stellar HSL-1250 is a solvent-based heat seal lacquer based on special thermoplastic polymers and additives. Serves as a single-stage direct adhesive lacquer on ALU, PET, PP, and Paper foils.

Appearance:	Milky, cloudy
Solid content:	30-35 %
Specific gravity:	0,93 g/ml
Viscosity:	30 sec. (DIN 53211, 4mm)
Solvent:	Methylethylketon, Ethylacetate, Cyclohexane
Flash point	- 10°C

Usage and application:

Sealing on materials:	ALU, PET, PS, PP, PVC, PLA
Application methods:	Rotogravure, roll coater, semi-flexo
Recommended coating weight:	4-7g/m ² dry film weight
Recommended viscosity:	15-30 sec. (DIN 53211, 4mm)
Recommended thinner:	Ethylacetate, MEK, Ethanol < 4%
Recommended drying temp.:	Generally temperatures between 130-160°C for 6-10 sec. are sufficient. The ratio between the machine speed and the temperature is adjusted according to a series of factors (such as the amount of applied lacquer, the temperature-time curve of the drying zones, the concentration of vapors, flow speed, humidity, etc.). For this reason, we recommend testing and measuring the content of residual solvents.

Sealing properties:

AL / APET	N/15mm	12	Brugger-HSG C 200°C 1sec. 460N Tolerance +-2
AL / PS	N/15mm	14	Brugger-HSG C 200°C 1sec. 460N Tolerance +-2
AL / PP	N/15mm	14	Brugger-HSG C 200°C 1sec. 460N Tolerance +-2
PET / PS	N/15mm	10	Brugger-HSG C 200°C 1sec. 460N Tolerance +-2
PET / PP	N/15mm	10	Brugger-HSG C 200°C 1sec. 460N Tolerance +-2

The values indicated above depend on the sealing temperature, and the values will decrease with lower temperatures

*Recommended for NC-coated paper surfaces. Internal trials are recommended.

Hygienic instructions

The hygienic properties of the lacquer comply with the legal requirements of Regulation (EC) No. 1935/2004 of the European Parliament and of the Council on materials and articles intended to come into contact with food, as well as Commission Regulation (EU) No. 10/2011 on plastic materials and articles intended to come into contact with food.

Safety instructions

Stellar HSL-1250 is a highly flammable and irritating liquid product with the risk of ignition and explosion of vapors. Protect from open flame, electrical discharges, reducing and oxidizing agents, etc. The substance irritates eyes, mucous membranes, and respiratory tract. Additional information can be found in the safety data sheets and conformity declarations.

Disposal

Must be disposed of in accordance with regulatory requirements for special waste disposal. Appropriate disposal method according to EU Waste Framework Directive (2008/98/EC): D 10 Incineration on Land. See safety data sheet.

Storage

Store cool and frost-free. Protect from sunlight and temperatures $>30^{\circ}\text{C}$. Keep out of reach of children. Original packaging should remain sealed and the product is shelf-stable for up to 12 months. The product is easily flammable and must be stored according to regulatory requirements.

Delivery package

Metall Drums:	30 Kg
IBC Containers:	950 Kg



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