

Solvent-based heat-seal lacquer, developed for lidding food packaging . Heat-seal lacquer for direct one-step application on ALU, PET, PP and PAPER foils, suitable for sealing on ALU, PET, PS, PP, PVC and PLA tanks. HSL-1255-AT is used in packaging for water cups, softdrinks and dairy products.

Product Description

Stellar HSL-1255-AT is a solvent-based, heat-seal lacquer based on special thermoplastic polymers and additives. The product is a heat sealable adhesive that can be directly coated in one step on ALU, PET, PP and PAPER surfaces. Proves to be an extremely low migration rate. 1255-AT is suitable also for other multi-purpose applications.

Appearance:	White Liquid
Active substance:	30-35 %
Specific gravity:	0,94 g/ml 20°C
Viscosity:	30 sec. (DIN 53211, 4mm)
Solvents:	Organic solvents, MEK, EA, Cylolohexan
Flash Point:	- 10°C

Application Information

Sealing on materials:	PET, PS, PP, PVC, PLA
Application methods:	Rotogravure, roller coating, semi-flexo
Recommended coating weight:	4–7 g/m ² solids
Recommended viscosity:	15–25 seconds (DIN 53211, 4 mm)
Recommended thinner:	Ethyl acetate, MEK

Recommended drying temperature: In general, temperatures between 130–160°C for 6–10 seconds are sufficient. The relation between machine speed and temperature, the applied lacquer weight, drying zone temperature–time profile, evaporation concentration, airflow rate, and humidity must be strictly observed. Therefore, we recommend testing and measuring the residual solvent content.

Adhesion and Seal Strength Values

AL / APET	N/15 mm: 10	(Brugger-HSG C 200°C, 1 sec, 460N, tolerance ±2)
AL / PS	N/15 mm: 12	(Brugger-HSG C 200°C, 1 sec, 460N, tolerance ±2)
AL / PP	N/15 mm: 10	(Brugger-HSG C 200°C, 1 sec, 460N, tolerance ±2)
PET / PS	N/15 mm: 9	(Brugger-HSG C 200°C, 1 sec, 460N, tolerance ±2)
PET / PP	N/15 mm: 9	(Brugger-HSG C 200°C, 1 sec, 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.

Hygienic instructions and Compliance

The hygienic properties of Stellar HSL-1255-AT lacquer have been defined in accordance with Regulation (EC) No. 1935/2004 of the European Parliament and Council on materials and articles intended to come into contact with food, and Commission Regulation (EU) No. 10/2011 on plastic materials and articles intended to come into contact with food.

Safety instructions

It is a highly flammable 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 and consumption

HSL-1255-AT is flammable and explosive; it must be stored in strict accordance with official regulations. Store in a cool, frost-free location. Protect from sunlight and temperatures above 30°C. Keep out of reach of children. The storage period is 6 months if the original packaging remains unopened. Products stored for longer periods must be tested before use. Before taken into production must be thoroughly mixed with a dissolver.

Delivery package

Metall Hobbock:	30 Kg
IBC Containers:	950 Kg



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