



Adhesive solutions

for bags & sacks production

To creatively combine the variety of materials and designs

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Shopping bags & small bags

Due to growing concern for environmental protection the production sector of paper bags has become very important. Mitol offers a series of advanced adhesives for different gluing operations such as:



- ✓ longitudinal gluing - L
- ✓ gluing of bag bottom - B
- ✓ gluing of reinforcement - R
- ✓ bonding of handles – H
- ✓ window gluing - W

They represent optimal solutions for bonding a variety of papers used in bag manufacturing, from ordinary (low grammage) kraft papers, coated and lacquered papers to plasticized materials. The choice of the appropriate adhesive depends on materials used as well as on the technical properties of the gluing line.

Selection of dispersion adhesives

Product	Base	Viscosity (mPas) at 23°C	Application	Gluing material	Special properties
MEKOL 1200	PVAc dispersion	2 600 – 3 500	L, R, H applied by nozzle, disc	unlacquered, coated	fast setting, good cohesion
MEKOL 1301	PVAc dispersion	1 900 – 2 400	L, R, H applied by nozzle	unlacquered, coated	very fast setting, good adhesion
MEKOL 1301/1	PVAc dispersion	1 700 – 2 200	L, R, H applied by nozzle	unlacquered, coated	short open and setting time
MEKOL 1323/C	PVAc dispersion	7 000 – 8 400	L, R, H applied by nozzle, disc, roller	unlacquered, coated	fast setting, good cohesion and adhesion
MEKOL 1330	PVAc dispersion	4 000 – 8 000	B, longitudinal-window gluing, applied by nozzle, disc	PVC, PET, BOPP, treated PP, PE	very good adhesion on difficult-to-bond surfaces
MEKOL 1339/1	PVAc dispersion	1 650 – 2 300	L, R applied by nozzle	lacquered, coated	fast setting, good cohesion
MEKOL 1405	PVAc dispersion	2 300 – 2 800	longitudinal- window gluing, applied by nozzle, disc, roller	PVC, PET, BOPP, treated PP, PE	good adhesion on difficult-to-bond surfaces
MEKOL 1409/P	PVAc dispersion, starch	min. 98 000	B applied by roller	unlacquered, coated	pasty, very good wet tack, long open time
MEKOL 1413/G	PVAc dispersion	15 000 – 22 000	B applied by roller	unlacquered, coated	good wet tack, long open time
MEKOL 1447/1	PVAc dispersion	5 000 – 6 000	B, L, R, H applied by nozzle, disc, roller	unlacquered, coated	good wet tack, medium open time
MITOSOL 3918	PVOH water solution	2 700 – 4 200	small bags – L applied by roller, disc	unlacquered, coated	long open time

Selection of hot melt adhesives

Product	Base	Viscosity (mPas) at 150°C	Softening point (°C)	Open time (sec.)	Application	Gluing material	Special properties
TERMOKOL 2321	EVA	1 500 – 1 800	108 - 115	2 - 3	H, R, L applied by nozzle	coated surfaces	white, good adhesion, good thermal stability, odourless
TERMOKOL 2321/1	EVA	1 500 – 1 900	108 - 115	3 - 4	H, R, L applied by nozzle	coated surfaces, lacquered surfaces	light yellowish, very good adhesion
TERMOKOL 2341	SIS block copolymer	950 – 1 450 at 140°C	75 - 85	pressure sensitive	longitudinal-window gluing, applied by nozzle	PVC, PET, BOPP, treated PP, PE	light yellowish-transparent, pressure sensitive
TERMOKOL 2421	SIS block copolymer	1 360 – 2 040 at 160°C	73 - 83	pressure sensitive	longitudinal-window gluing, applied by nozzle	PVC, PET, BOPP, treated PP, PE	clear yellowish, pressure sensitive, good peel adhesion
TERMOKOL ULTRA 2370	metallocene polyolefin	800 – 1 200	105 - 115	3 - 4	H, R, L applied by nozzle	coated surfaces, lacquered surfaces	white, low consumption, good adhesion, odourless, fast setting, good thermal stability
TERMOKOL ULTRA 2380	metallocene polyolefin	950 – 1 450	103 - 113	10 - 11	H, R, L applied by nozzle	coated surfaces, lacquered surfaces, difficult-to-bond surfaces	white, low consumption, very good adhesion, odourless, long open time, good thermal stability

Plastic bags

The use of polypropylene (PP) or polyethylene (PE) in the production of plastic carrier bags as well as gluing PE/PP windows requires adhesives with good adhesion to difficult-to-glue materials. MITOL pressure sensitive hotmelts perform a strong and quality bond also in these conditions.

Product	Base	Viscosity (mPas) at 150°C	Softening point (°C)	Application	Gluing material	Special properties
TERMOKOL 2331	SIS block copolymer	1 900 – 2 900	73 - 83	gluing PE, R, H applied by segment	PE, PS and other difficult-to-bond materials	yellowish, pressure sensitive, high tack, very good adhesion to PE and PS



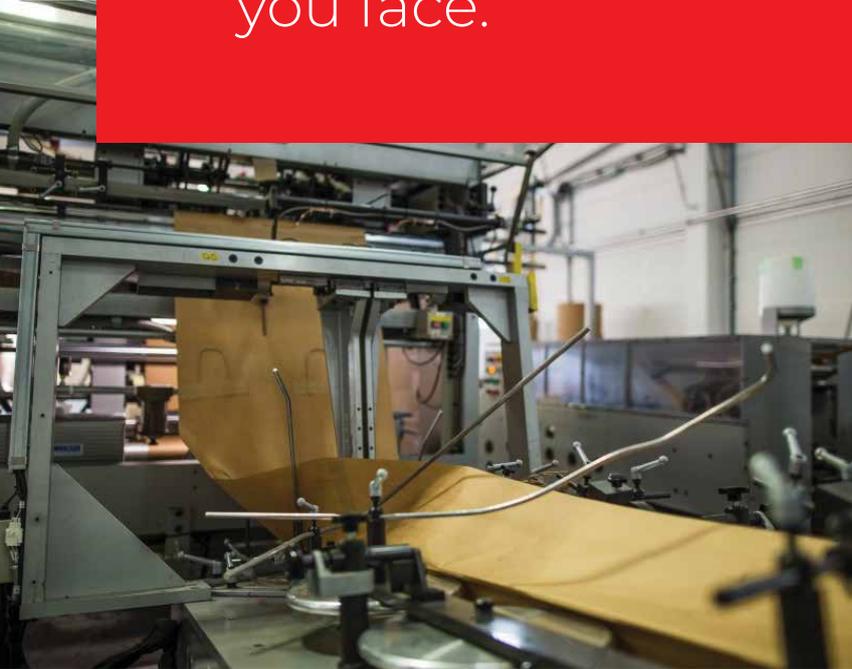
Multilayer paper sacks

A multi-wallpaper sack consists of two or more layers glued together. Outer layer is usually kraft paper, while inner layers can be different paper substrates or PE foils providing protection and moisture barrier. MEKOL adhesives formulated for this application have excellent processing properties, they allow high-speed production and provide a strong bond also to difficult-to-bond substrates.

Product	Base	Viscosity (mPas) at 23°C	Application	Gluing material	Special properties
MEKOL 1332	PVAc dispersion	1 500 – 2 000	gluing paper and treated PE foil, applied by nozzle, roller	treated BOPP, PE foil	good adhesion, fast setting
MEKOL 1332/1	PVAc dispersion	1 900 – 2 400	gluing paper and treated PE foil, applied by nozzle, roller	treated BOPP, PE foil	economic, longer open time

These products represent a limited selection of our product range. Contact our specialists for more information or technical data sheets.

Adhesive solutions for
every manufacturing challenge
you face.



MITOL is the leading Slovenian producer of adhesives providing innovative and effective solutions in the field of gluing for more than 70 years. With reliable, technologically advanced products and superior customer service we have managed to build close relationship with our partners in more than 35 countries around the globe. Being aware of the sustainability challenges we devote special attention to the selection of materials and production processes that reduce environmental impact.



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