



**TECHNO**MELT®  
**A**QUENCE®

**ADHESIVES SOLUTIONS  
FOR THE LABELING  
INDUSTRY**



# ADHESIVE SOLUTIONS FOR The Labeling Industry

The use of the right adhesives during labeling operations is a topic that affects production efficiency, sustainability and consumer experience. Henkel labeling adhesives ensure reliable bonding on a variety of surfaces, for the entire spectrum of machines and applicators. This leads to enhanced consumer experience through improved application and more appealing appearance of the label as well as being able to withstand typical consumption conditions and last longer. The labeling results are influenced by the surface of the label, the bottle itself and the labeling unit. Therefore the choice of the right adhesive ensures a good labeling quality.

## Labeling Applications



**Glass Labeling**



**PET Labeling**



**Can Labeling**



**Plastic Container Labeling**

**Product Lines**

AQUENCE XP  
 AQUENCE GL  
 AQUENCE LP  
 AQUENCE PET  
 TECHNOMELT EM

## Special Requirements

Look out for products in the range especially developed to meet requirements such as:

- Ice water resistance
- Hypercondensation
- Petcycle approval
- Innovative dispensing technologies

## HENKEL INNOVATION

# Highlights



## Application Areas

- Casein-free high performance adhesive for glass labeling
- Suitable for multi-way containers
- Suitable for aluminum foil

## Higher Efficiency for Customers and Manufacturers



### IMPROVED PROCESS

- Reduced adhesive usage
- Fast and reliable label removal
- Super-easy cleaning



### REDUCED COMPLEXITY

- Wide range of applications
- Lower number of adhesives required



### LOWER TOTAL COSTS

- Greater price stability (independent of casein market)
- More efficient production thanks to improved mileage/capacity utilization

HENKEL INNOVATION  
**Highlights**



**AQUENCE GL 270/330**

**HIGH-PERFORMANCE  
HYBRID ADHESIVES RANGE  
FOR GLASS LABELING**

- Fit for difficult labels and coated glass
- Efficient consumption
- Excellent machinability
- AQUENCE GL 270: First choice for wineries and distilleries
- AQUENCE GL 330: First choice for breweries with advanced requirements



**TECHNOMELT EM 132-22**

**HIGH-PERFORMANCE  
ADHESIVES RANGE FOR  
PET LABELING**

- Reduced application temperature
- Low viscosity allows high machine speed
- High adhesion for reduced material usage
- Suitable for e.dot/nozzle application systems

## CORE RANGE FOR

# Labeling Applications



## AQUENCE Waterbased Adhesives

### Glass Labeling

	Recycling	Wet tack	CWR	IWR (days)	Shelf life (months)	Reference industries	Characteristics
<b>Casein-free labeling adhesive</b>							
<b>AQUENCE XP 150</b>	Multi-way	High	Low	<1	12	Breweries Spirits	Solid basic requirements solution. For dry to slightly wet bottles. High-speed compatible.
<b>AQUENCE XP 170</b>	Multi-way	Low	Low	<1	6	Mineral water	Low viscosity product for basic requirements and less demanding surfaces and labels.
<b>AQUENCE XP 180-22</b>	Multi-way	Medium	Medium	3 – 4	12	Soft drinks Wineries	For medium machine speed, high wet tack.
<b>AQUENCE XP 190</b>	Multi-way	High	High	>7	12	Breweries	For advanced IWR and CWR requirements. Suitable for all label types and foiling.
<b>Casein-based labeling adhesive</b>							
<b>AQUENCE GL 702 N</b>	Multi-way	Very high	Very high	1	6	Premium brewers	Troubleshooter with superior CWR. Zinc and borax free.
<b>Hybrid labeling adhesive</b>							
<b>AQUENCE GL 270</b>	Multi-way	High	Low	1	6	Wineries Distilleries	Suitable for difficult labels.
<b>AQUENCE GL 330</b>	Multi-way	High	Good	2	6	Breweries	Hybrid for advanced requirements.
<b>Starch-based labeling adhesive</b>							
<b>AQUENCE GL 3173</b>	Multi-way	High	Low	<1	9	Food production Instant coffee	Slow to medium machine speeds. Suitable for hot filling.

## CORE RANGE FOR Labeling Applications

### AQUENCE Waterbased Adhesives Plastic Labeling



	Wet tack	Shelf life (months)	Surfaces	Reference industries	Characteristics
<b>Plastic labeling adhesive</b>					
<b>AQUENCE LP 2065</b>	Medium	9	PET	Soft drinks	Multi-way and one-way PET. Suitable for tax stamps and patch labels.
<b>AQUENCE PET 1770</b>	High	12	PE, PP PET	Chemicals	Excellent running and cleaning properties. PSA effect.
<b>AQUENCE PET 21-22</b>	Medium	6	PET Glass	Breweries	Suitable up to high speed machines. Specialty: Good IWR on PET
<b>AQUENCE LP 100</b>	Low	6	PE, PP	Home Care Cosmetics Chemicals	High adhesion and heat resistance. Specialty: suitable for untreated HDPE

### TECHNOMELT Hotmelt Adhesives Plastic and Can Labeling



	Color	Optimal processing temperature	Softening point	Elongation capacity	Surfaces	Characteristics
<b>Rubber-based HM labeling adhesive</b>						
<b>TECHNOMELT EM 362</b>	Light yellow	130 – 150°C	62 – 74°C	Very good	PET	Standard for reel-fed wrap-around labeling.
<b>TECHNOMELT EM 325</b>	Whitish	120 – 160°C	68 – 80°C	Medium	PET	Petcycle approved solution.
<b>TECHNOMELT EM 328-21</b>	Yellow	120 – 160°C	68 – 72°C	Medium	PET	Petcycle approved solution.
<b>TECHNOMELT EM 132-22</b>	Yellow	120 – 140°C	62 – 74°C	Very good	PET	Suitable for high speed, e.dot/nozzle. Low consumption and application temperature.
<b>TECHNOMELT EM 360</b>	Yellow	140 – 180°C	83 – 95°C	Very good	Can/ Glass, PET	Troubleshooter. Specialty: Low migration through paper labels.
<b>TECHNOMELT EM 1051 E</b>	Water white	150 – 160°C	70 – 74°C	Very good	Can/PET	Specialty: Suitable for spin-spray application.

#### EVA-based HM labeling adhesive

<b>TECHNOMELT EM 270</b>	Amber	140 – 180°C	80 – 86°C	Low	Can	For labeling of very warm metal cans.
--------------------------	-------	-------------	-----------	-----	-----	---------------------------------------

## PRODUCTS

# Cleaner and Service



## TECHNOMELT Cleaner Melt-O-Clean

- For all types of hotmelts
- For machine surfaces, especially to remove residual adhesive, heavy grease and grime
- For filters, spray heads, nozzles, steel rollers
- Appearance: liquid
- Color: transparent
- Working temperature: Room temperature

### Available in the following packagings

12 x 0.5 l spray bottles  
4 x 4.5 l steel canister

## TECHNOMELT Cleaner Pure

- For all types of hotmelt
- Ideal for regular cleaning of machine surfaces
- High health and safety standards
- Suitable for food production sites
- Appearance: liquid
- Color: transparent
- Working temperature: Room temperature

### Available in the following packagings

12 x 1 liter spray bottles  
4 x 5 liter canister

## Recyclability and Recycled Content of Industrial Packaging

The world is in constant motion – and asking for new solutions. Our Packaging & Consumer Goods Adhesives business is at the center of this massive change towards a more sustainable future. Henkel's adhesives and coatings for packaging and labeling applications fully support your sustainability targets.

### Plastic Container



#### Reuse

- Wash and reuse of drums and canisters is generally possible [1], [2]

#### Recycling

- Plastic containers can be recycled into PE or PP plastic resin [2], [3]

[1] Dependent on product residues

[2] Dependent on locally available infrastructure

[3] Requires emptying and label removal before or during recycling process

### Intermediate Bulk Container (IBC)



#### Reuse

- Wash and reuse of entire IBC well established [1]
- Reuse of steel frames with new PE bottles very common

#### Recycling

- Frame: recycling of steel very common [2]
- PE bottle can be recycled, e.g. into IBC pallets / skids

#### Recycled content

- Recycled content in steel frame and plastic skids is common

[1] Dependent on product residues

[2] Metal stocks & recycling rates, United Nations Environmental Programme, 2011

### Paper Carton



#### Recycling

- Cardboard and paper very commonly recycled into new cardboard [1]
- High recycling rates for paper and cardboard of >60% [2], [3], [4]

#### Recycled content

- 50% of recycled content common in cardboard packaging [4]

[1] For coated cardboard dependent on local infrastructure

[2] 2019 ICFPA Sustainability Progress Report

[3] KEY STATISTICS 2018 European pulp & paper industry, CEPI

[4] Corrugated Packaging – A Recycling Success Story, CPA, 2016



**Contact us for more information:**

Henkel AG & Co. KGaA  
Henkelstraße 67  
40589 Düsseldorf | Germany

E-mail: [labeling@henkel.com](mailto:labeling@henkel.com)  
[www.henkel.com/consumerpackaging](http://www.henkel.com/consumerpackaging)