


<p><b>Version</b> October 2016</p>	<p><b>Processing Instructions</b> <i>PVC Media for Screenprinting</i></p>	
--	---	--

## General

Intercoat is using high-quality soft-pvc-films for their produced screen printing media. The properties of the PVC film may change depending on the temperature and other environmental influences. To ensure proper processing of the products, we recommend following these processing instructions.

## Batches and serial numbers

Material properties can slightly vary between different batches. Hence, if a job requires the usage of multiple laminate rolls, it is strongly recommended to use only rolls from the same batch.

XY/ABCDE-FG (example. 34/123245-01)

If the first 7 digits match, the rolls have been produced from the same batch. Please check in advance whether the rolls can be used together.

Traceability of the rolls is ensured by serial numbers on labels, which attached to the roll cartons. Design of labels allows to remove small stickers with information about material and serial numbers. These can be attached to roll core and to production documents. As traceability is impossible without information about the serial number, it is recommended to keep sticker with serial numbers for internal documents.

## Storage and processing instructions

The rolls are fixed in a box with end-caps, which enable hanging storage in a box. We recommend storage of the box standing on the sides. If roll is stored lying on the film surface weight of the rolls can lead to matt patches on the film surface.

For storage, a dry and cool room-climate with a relative humidity 40% to 55% at a temperature of 10 ° C to 23 ° C is recommended. Products must stored out of direct sunlight.

Please follow the specified storage instructions in the data sheets.

Phenomena like curling or waving edges occur by swelling of paper fibres, which can be attributed to improper storage conditions.

High-quality PE-coated kraft papers, like the Diamond Technology Liners D17 and D18-liner offered by INTERCOAT, show a lower sensitivity to climate variability.

Please follow the specified storage instructions in the data sheets.

## Printing and converting

The print media should be allowed to sufficiently acclimatize to temperature inside production areas prior to printing (min. 24 hours). Temperature fluctuations in production area should be avoided, as this can lead to curling and weaving edges. It is recommended to use only appropriate inks suitable for printing of PVC materials. Appropriate tests should be done in advance to check for compatibility between printed media, color and method are performed. In multi-color printing pay attention that the individual color layers are fully cured (Exception: wet-on-wet printing). Residual solvent from the printing ink can lead to a change of film properties (eg. Embrittlement). This should be especially considered when applying a varnish on top of printed image.

## Drying


The solvent contained in the - ink must evaporate after printing. Therefore, freshly printed media should be spread out in a well-ventilated place before further processing. The drying time depends on the ambient temperature. At a temperature of about 23 ° C, we recommend a drying time of at least 24 hours.

Insufficiently dried films shrink after printing. If the film is sticked without proper drying, it is expected to shrink on the substrate and delamination at the edges may occur. Plotting in printed area may lead to shrinkage of cut contours if drying time is insufficient. If the printed film is laminated, insufficient drying can affect adhesive strength and durability. In addition, blistering can occur by residual solvents.

## Application

Values for peel adhesion given in the technical datasheets are determined according to FINAT Test method 1, unless otherwise specified. Substrates used for measurement is glass and adhesion is allowed to built up for 24 hours before measurement.

The adhesive strength is dependent on the substrate on which the film is applied. The surface must be dry, clean and free of oil, grease, silicone and other impurities. We recommend the usage of suitable surface cleaners that evaporate without any residuals, e.g. isopropanol. Before application cleaner should completely dry out. Residues due to improper cleaning can affect the adhesive strength and durability and may lead to blistering.

<b>Version</b> October 2016	<b>Processing Instructions</b> <i>PVC Media for Screenprinting</i>	
--------------------------------	---	--

Minimum application temperature specified in the datasheet must be considered.

Within the first 24 hours after application, the adhesion between the film and the substrate builds up. We recommend that temperature exceeds the minimum application during built-up process.

If the film is applied wet, it must be ensured that the water between film and substrate is removed quickly and without any residue. We recommend using a scraper. Wet-application in outside areas shall be carried out at minimum temperatures of +18°C.

By wet-application whitening of the adhesive layer may occur, which can occur more or less for water-based acrylic adhesives and cannot be considered as a quality defect. Haze will disappear within 24 to 48 hours.

If whitening of adhesive layer is not desired, we recommend the use of products that are equipped with our Diamond Air Technology Liner D17. We recommend using only dry-application.

### **Removeability**

For removal of repositionable films minimum substrate temperature of +20°C is recommended. Films should be removed starting from one corner and pulling with constant force under an angle of 180°.

### **Notice**

These processing instructions are based on our long experience and knowledge as film specialist and manufacturer of self-adhesive materials. However, not all relevant aspects are described here and professional knowledge and skill of sign-makers are presupposed.

Please note that due to the large number of possible influencing factors appropriate tests must be carried out in advance for each application.

No legally binding warranty or certain qualities can be derived from this information.

This document is valid from October 2016

### **AMC AG DIVISION INTERCOAT**

Boschstraße 12

D - 24568 Kaltenkirchen

[www.intercoat.de](http://www.intercoat.de)

[info@intercoat.de](mailto:info@intercoat.de)