



TECHNICAL DATA SHEET - DIGITAL PRINTING - LAMINATE - PERMANENT ADHESIVE PC300

30- μ m, transparent, UV-treated polyurethane film, which is coated with a pressure-sensitive acrylic adhesive. Product developed for cold-laminating HEXIS digital printing films. This ultra-soft and ultra-conformable laminate, specially suitable for application to 3D surfaces, protects your prints by providing them with enhanced mechanical resistance to abrasion compared with standard PVC laminates. Glossy surface finish.

FILM FEATURES:

	<u>Indicative value</u>	
• Thickness (μ m):	30	
	<u>Average values</u>	<u>Standard</u>
• Tensile strength (N/25 mm):	min. 50	HEXNFX41031
• Elongation at break (%):	min. 200	HEXNFX41031
• Shrinkage 168 hours at 70 °C (158 °F) (mm):	< 0.4	HEXRET001
• UV absorption (%):	\geq 90	NF EN 410

LINER:

- Silicone-coated PET liner 75 μ m.
- Stable under hygrometric variations.

ADHESIVE PROPERTIES:

(Measured average values at publication of the technical data sheet)

	<u>Average values</u>	<u>Standard</u>
• Peel strength test 180° on glass (N/25 mm):		HEXFTM001
after 20 minutes of application	9	
after 24 hours of application	11	
• Initial tack (N/25 mm):	9	HEXFTM009
• Release (N/25 mm):	0.3	HEXFTM003

ADHESIVE:

- Solvent-based, acrylic adhesive.
- Immediate and permanent adhesion.

USER'S INSTRUCTIONS:

- Protection of digital printing films.
- UV protection.
- During the lamination, make sure that the tensions and speeds of each film (digital printing film and PC300) are the same. The tension of the laminate should be kept as low as possible during the lamination process in order to minimise the elongation of the PC300 film.
- Recommended minimum application temperature of the compound: +10 °C (+50 °F).
- Operating temperature range: -40 °C to +90 °C (-40 °F to +194 °F).
- For film cleaning, only use a non-abrasive sponge or soft cloth with soapy water.
- In the case of an already painted substrate, the compound must only be applied to undamaged original paintwork. If the paintwork is not original and/or damaged, the application and the removal are at the judgement and risk of the installer.

OPERATING RECOMMENDATIONS:

- For any lamination, coating or other of a HEXIS digital printing film, optimal drying time for the inks is:
 - 48 hours for a cast film;
 - 24 hours for a calendered film.

STORAGE:

- Shelf life (before application):

The shelf life of this film is 1 year when stored upright in its original packaging in a dust-free environment at a temperature ranging from +15 °C to +25 °C (+59 °F to +77 °F) with relative humidity of 50 %.

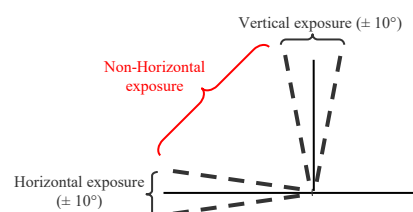
DURABILITY: (Central European climate)

- Vertical outdoor exposure:
Without mechanical stress: up to 7* years.
With mechanical stress: depends on the type and frequency of the stresses.

*Time during which the film retains a correct surface finish, from a conventional viewing distance. (A slight and gradual change in colour and gloss is a natural and inevitable phenomenon inherent in the natural breakdown of the materials).

Note: The durability indicated in this document:

- concerns only the laminate and not the finished visual or graphic.
- is inherent to an upright position of $\pm 10^\circ$ and to the product's geographical exposure position. Any other position accentuates climatic influences and an alteration in gloss or colour, or even a slight dusting may appear. Southern exposure, with a 45° inclination can divide the durability of the film by 2, and horizontal exposure by 2.8. Application to the vehicle bonnet is particularly severe, due to the horizontal exposure and the heat from the engine.
- is confirmed by UV ageing tests and vertical natural outdoor weathering.



- Vertical indoor exposure:
up to 9 years (for surfaces or areas not subject to frequent handling or high visitor frequency).

A film applied to surfaces exposed to mechanical stress will be subject to repeated abrasion that will reduce more or less rapidly its lifespan (change of appearance, peeling off, etc.).

To find the indicative durabilities of the films for any other exposure and geographical area, please refer to the "Conversion rules for indicative durabilities according to geographical area" chart available under Durability, on the "Professionals" pages on our site www.hexis-graphics.com.

NOTES:

Due to the great variety of substrates and the growing number of new applications, the installer must check the suitability of the medium for each application.

The measuring methods for the standards quoted above served as the basis for the development of our own measuring methods, which are available on request. Please feel free to contact us to get the latest instructions in use.

All the published information is based on measurements regularly performed in the laboratory. It does not however constitute a binding guarantee. The seller cannot be held liable for indirectly related damages and assumes no liability for claims that are higher than the replacement value of the purchased product. All specifications are subject to potential changes without prior notice. Our specifications are automatically updated on our website www.hexis-graphics.com.