



## PCFORGED

### PRODUCT DESCRIPTION:

Film composed of a 110- $\mu$ m, clear, structured, cast PVC, which is coated with a pressure-sensitive acrylic adhesive. Designed to be cold laminated on mass-coloured or digital printing films; it can also be directly applied to smooth 2D or moderated 3D surfaces. Forged carbon surface finish.

### FILM FEATURES:

• Thickness	(Indicative value) <b>110 <math>\mu</math>m</b>	
• Tensile strength	(Average values) <b>min. 15 N/25 mm</b>	Method <b>HEXNFX41021</b>
• Elongation at break	(Average values) <b>min. 50 %</b>	Method <b>HEXNFX41021</b>
• Shrinkage 168 hours at 70 °C (158 °F)	(Average values) <b>&lt; 0,8 mm</b>	Method <b>HEXRET001</b>

### LINER:

- Silicone-coated PE paper 145 g/m<sup>2</sup> with grey «THE CAST by HEXIS» print.
- Stable under hygrometric variations

### ADHESIVE PROPERTIES:

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

• Peel strength test at 180°; Measurement support glass	(Average values) <b>12 N/25 mm</b>	Method <b>HEXFTM001</b>
after 20 minutes of application	(Average values) <b>14 N/25 mm</b>	Method <b>HEXFTM001</b>
after 24 hours of application	(Average values) <b>19 N/25 mm</b>	Method <b>HEXFTM009</b>
• Initial tack	(Average values) <b>0,5 N/25 mm</b>	Method <b>HEXFTM003</b>
• Release		
• The adhesive is resistant to most chemicals (alcohol, diluted acids, oils).		

### ADHESIVE:

- Solvent-based acrylic adhesive.
- Immediate and permanent adhesion, optimal after 24 hours of contact.

### USER'S INSTRUCTIONS:

- Dry application method
- Recommended minimum application temperature: +10 °C (+50 °F)
- Operating temperature range: -40 °C to +90 °C (-40 °F to +194 °F)
- UV protection.
- For modifying/improving/protecting:
  - a plotter or wrap vinyl: apply the PCFORGED film to unstructured films only using a cold laminator or via direct application. The compound can be cut using a plotter, except in combination with a full wrap film. After cutting, it is possible to transfer with the HEX860 tape.
  - a digital printing film: apply the PCFORGED film to solvent, eco-solvent, latex or UV inkjet printed films only.
  - any other type of substrate: only apply to a surface in good condition or to a properly prepared substrate.

*Due to the wide variety of existing substrates, the application of film to an unsuitable and/or not adequately prepared surface or coating may result in media lifting from the substrate or damage to the substrate when the film is removed. The application and removal of the film are at the judgement and risk of the installer. HEXIS will not, under any circumstances, be liable for any damages or deteriorations caused by the installation or removal of a vinyl film.*



- For film cleaning, only use a non-abrasive sponge or soft cloth with soapy water.

*A film applied to surfaces exposed to frequent mechanical stress will be subject to repeated abrasion that will reduce more or less rapidly its lifespan (change of the film's and/or the complex's appearance, peeling off, etc.).*

## OPERATING RECOMMENDATIONS:

- Before applying this laminate to a HEXIS digital printing film, which has been printed with solvent inks, it is recommended to respect the following optimal drying time for the inks:
  - 48 hours if the printed film is cast,
  - 24 hours if the printed film is calendered.
- For more information on the application method of the PCFORGED film, please refer to its Application Guide under the «Professionals» heading, in the «Laminates» category on our website [www.hexis-graphics.com](http://www.hexis-graphics.com).

## STORAGE:



Storage period before use  
**1 year**



Storage temperature  
**+15 °C to +25 °C (+59 °F to +77 °F)**



Relative humidity during storage  
**with relative humidity of 50 %**



Storage area  
**in a dust-free environment**



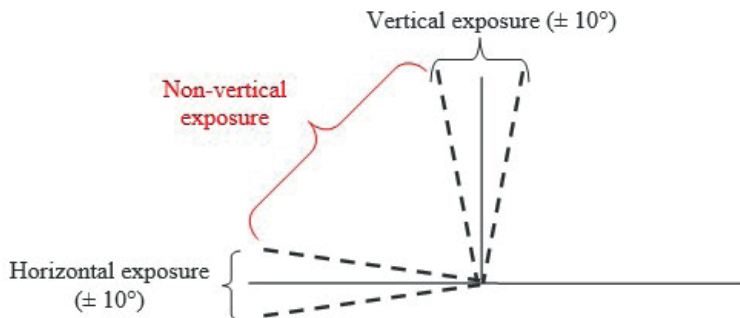
Storage method before use  
**in its original packaging**



Orientation of rolls before use  
**vertically**

## DURABILITY: (climat Europe centrale)

- Vertical outdoor exposure, upon substrate:  
Without mechanical stress: up to 3\* years.
- \*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 in an upright position of  $\pm 10^\circ$  and in 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  $45^\circ$  inclination may 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.

- Indoor exposure, upon substrate: up to 5 years.

*This durability may vary depending on frequency, type of cleaning and mechanical stress (friction, impacts etc.) to which the film is exposed.*

*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](http://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](http://www.hexis-graphics.com).