



Technical Information of 4films linea thermal

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Description: One side structure coated, other side EVA coated and corona treated biaxially oriented polypropylene based film for finishing high quality printing products – Processing with commercial thermal laminating machines

Characteristic: fine-linen matt



| Properties | Test Method/ Standard | Value | Unit |
|--|--------------------------|---------|--------------------|
| Thickness | DIN EN ISO 534 | 32 | µm |
| Substance/Grammage | ISO 536 | 20,5 | g/m ² |
| Yield | DIN 53375 | 48,78 | m ² /kg |
| Tensile Strength at Break MD | ASTM D882 | 79,5 | N/mm ² |
| Tensile Strength at Break TD | ASTM D882 | 134,7 | N/mm ² |
| Elongation at Break MD | ASTM D882 | 177 | % |
| Elongation at Break TD | ASTM D882 | 45 | % |
| Gloss Angle of Incidence/ Observation 60°/60° | ASTM D2457 | 10 - 12 | GU |
| Haze | ASTM D1003 | 91,9 | % |

Prior to each and any treatment or processing of the film, the customer is obliged to perform pre-tests under original production conditions in accordance with the form sheet Processing Recommendations. Damages resulting from the fact that the Customer did not or not properly carry out such mandatory pre-tests shall be borne by the Customer.

Explanation of Abbreviations:

| | | | |
|------------|---|-----|------------------------------|
| ASTM | American Standard Test Method | GE | Gloss Units |
| DIN | Deutsche Industrie Norm [German Industry Norm] | JIS | Japanese Industrial Standard |
| DIN EN ISO | German, European and International Standard | MD | Main Direction |
| | | TD | Transverse Direction |

Processing Recommendations

4films linea thermal

Prior to any treatment or processing of 4films-laminating films they must be tested in each case under the original conditions of production. Due to the great variety of processing machines and their adjustment parameters as well as the variety of materials on the market only recommendations are possible here.

4films linea thermal lamination film can be processed with a Kalander temperature of 105°C, but it is recommended to determine the appropriate Kalander temperature before use.

4films linea thermal lamination film should have preferably a temperature less than 30°C and humidity of 55 ± 5 % in storage areas. Storage at high temperatures or in a horizontal position should be avoided. The material should be consumed within three months of receipt.

To avoid damage or consequential costs, the customer has to ensure that when laminating with 4films-laminating films in the event of any defects in the film (eg wrinkling, stains, spots or other imperfections) the production has to be stopped immediately.

When using 4films-laminating films, it has to be verified throughout each job that a sufficient compound adhesion to the substrate to be laminated exists. In case of insufficient

compound adhesion, processing parameters such as pressure, machine speed and temperature should be varied.

In the case that the surface wettability of the substrate to be laminated is particularly poor, the customer might be required to improve the surface wettability beforehand, for instance, without limitation, by use of a corona treatment or to use another laminating procedure.

Prior to any treatment or processing of 4films-laminating film in following methods:

- .. UV varnishing
- .. hot foil stamping
- .. cold foiling
- .. adhesive bonding
- .. creasing
- .. grooving
- .. blind embossing
- .. die cutting
- .. pocket sealing
- .. pocket welding

it must take place before an suitability test to be used with the original materials under original conditions generally.

