

MACal[®] 8100 Colours – PERMANENT

Technical Data Sheet

DESCRIPTION

Face stock :

Soft calendered PVC films, ~ 90 µm, cadmium-free, dull or gloss finish.

Gloss colours

Macal[®] 8101 Orange
 Macal[®] 8103 Golden Yellow
 Macal[®] 8105 Dark Yellow
 Macal[®] 8109 LightYellow
 Macal[®] 8139 Blue
 Macal[®] 8149 Green
 Macal[®] 8159 Red
 Macal[®] 8189 Black

Dull colours

Macal[®] 8108 Yellow
 Macal[®] 8138 Blue
 Macal[®] 8188 Black

Adhesive : Permanent, acrylic water based.

Liner : Coated Kraft paper, ca. 140 gr/sqm.
 Secury 13 (without breaklines).

Laminate : ca. 260 gr/sqm.

PHYSICAL AND CHEMICAL CHARACTERISTICS (TYPICAL VALUES)

Quick tack : 12 N/25 mm	FTM 9, on glass
Peel 20 min. : 8 N/25 mm	FTM 1, on glass
Peel 24 h. : 16 N/25 mm	FTM 1, on glass
Resistance to shear : > 30 h	FTM 8, on glass
Dimensional stability (applied) : max. 1.0 %	FTM 14, alu

Dimensional stability on the backing paper (unapplied) :
 max. 1.0 % Measured after 72 h at 60°C

Temperature range :

Minimum application temperature : + 5°C
 Service temperature range : - 20°C to + 70°C

Flammability : Self-extinguishing ISO 3795

Toy labelling : 8138-8139-8188-8189 are in compliance with EN 71/3

Marine test BS5609 : passed.

Solvent resistance : No effect.

Applied to stainless steel, exposed to :
 oils, greases, aliphatic solvents, alcohols.

Petrol resistance :

If extended contact, edge-lifting will occur.
 Repeated (each 10 min.) petrol spraying.

Chemical resistance : No effect.

Mild acids. Mild alkalis.

Shelf life : stored at 50 ± 10 % RH at 15 - 25°C.

2 years for as long as the material is being stored in its original packaging.

Durability : 2 years.

Middle European exposure conditions, vertical exposure. Exposure to severe humidity, ultra-violet light or conditions found in tropical, subtropical or desert regions will cause more rapid deterioration than under conditions existing in "normal" temperate climates.

PRINTING METHODS

Screen printing.

For UV offset and conventional offset, please contact your ink supplier.

During printing, it is important that drying is carefully exercised to ensure removal of printing inks solvents since certain solvents if retained can lead to plastification problems with subsequent application troubles and poor weathering properties.

We recommend to maintain an unprinted area of 3-4 mm on the edges of the printed decal to avoid edge lifting.

For solvent digital printing, we recommend the use of MACTac IMAGin JT 5000 products.

APPLICATIONS AND USES

Stickers for advertising and promotional campaigns, emblems and printed labels for in- and outdoor use.

GENERAL REMARK : factors affecting adhesion

Adhesion failure problems can be avoided by :

- *Where possible, always test the proposed construction under actual application and end-use conditions because a 100 % multi-purpose adhesive for all substrates does not exist.*
- *Being familiar with factors which adversely affect adhesion :*
 - *Labels or stickers should not be applied onto dusty, dirty, oily or oxidized surfaces.*
 - *Mould release agents on blow-moulded plastic surfaces inhibit adhesion.*
 - *Adhesion failure may occur on substrates with low surface tension, such as polyethylene or polypropylene. Rubber based adhesives stick better to low energy surfaces than acrylics.*
 - *Avoid the use of relatively rigid facestocks on highly curved or small diameter surfaces.*
 - *Do not use pressure-sensitive materials outside the recommended service temperature range, or do not apply below the minimum application temperature.*