



PERFORMANCE GUIDE

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Approved by J. S.

PRODUCT: LF3640 RAYZor
Cast Gloss Overlaminating Film

PERMACOLOR®

The **Permacolor** system is a series of pressure sensitive products for mounting and protecting in the imaging industries. Pressure sensitive **Permacolor** provides fast, efficient processing through cold roll lamination techniques without the need for heat, drying or messy coating operations.

PRODUCT DESCRIPTION

LF3640 is a 1.5-mil clear **gloss**; highly conformable cast PVC film. The product is coated on one side with a clear permanent, acrylic pressure sensitive adhesive and supplied with a 1.2-mil polyester release liner. LF3640 is designed for use with JT5629PD, JT5628PD, JT5929P, JT5928P, JT5929BFD, and JT5529BFD in long-term outdoor, marine, fleet or vehicle markings on flat, curved, corrugated and riveted surfaces. Additional UV protection is built into the overlaminating film to help extend the life of your graphic by resisting color fade caused by ultraviolet light.

<u>PHYSICAL PROPERTIES</u>	<u>TYPICAL VALUES*</u>	<u>TEST METHOD</u>
Thickness, inches (mm)		
Film plus adhesive	0.0025 (64)	ASTM D-645
Total product	0.0039 (100)	
Peel Adhesion, lb. /in. (N/25mm)		PSTC-1
180° on Stainless Steel - 20 min	3.0 (13.1)	
- 24 hr.	3.7 (16.5)	
Quick Tack on SS, lb. /in² (N/25mm)	2.5 (11)	FTM - 9
Dimensional Stability, (in.)		FTM - 14
48 hours @ 158°F	max 0.01	10" x 10" Sample bonded to aluminum.
Gloss, (60°)	80 min	
Temperature Ranges,		
Minimum Application:	40°F (+4°C)	
End Use:	-50°F to 225°F (-45°C to 107°C)	
Adhesive pH	Neutral	TAPPI-529

DURABILITY:

The outdoor durability is 5 - 7 years outdoors and 7+ years indoors. While all Permacolor overlaminating films have UV resistance built in to help extend the life of your image, the durability of the image is mainly dependent upon the quality of the inks (see technical data sheets given by the ink manufacturers) and pressure sensitive media being used.

CHEMICAL RESISTANCE:

Salt Water Spray

100 hours @ 5% solution no change

Water Immersion

100 hours immersed @ RT no change

Other immersion tests show:

- | | |
|----------------------------------|-----------|
| 1) Gasoline (30 min.) | No effect |
| 2) Water and Detergents (24 hrs) | No effect |
| 3) 10% HCL (10 min) | No effect |
| 4) 10% NH OH (10 min) | No effect |

ASTM B 117-03

Additionally, this product has good resistance to detergents, alcohol and some aliphatic solvents for short periods of time. Not recommended for contact with ketones, esters, aromatic solvents and chlorinated hydrocarbons.

RECOMMENDATIONS:

- 1) We recommend you work in a controlled environment (> 72°F (23°C) and 50% RH), and condition the media in the printing room 24 hrs. before printing.
- 2) Ensure print is perfectly dry. Material should have 24 hrs drying time, open to the air, prior to lamination or transportation. Laminate through a professional laminator at 3 - 5 ft/min. Slight mottling may occur from being in the roll too long. This will go away with a little time (typically 24-hrs) in the sun. If this is not possible, simply heat the top roll on your laminator to a temperature of no more than 120°F (50°C) to remove. Caution: heating this film will allow it to stretch easier; special care with film tension will be required!
- 3) Since this is a very thin cast vinyl film, it is very easy to stretch, keep film face tension as low as possible to reduce this possibility.
- 4) Where exposure to harsh chemicals, solvents or high pressure wash is anticipated we recommend you seal the edges with varnish, heavy duty car wax or silicone in order to avoid penetration of these liquids into the adhesive.
- 5) To allow for easy transportation, IMAGin laminated with LF3600 Series can be rolled up, with the image out, with a minimum diameter of 7 inches (18cm). When an overlaminates does not protect the image, make sure the print is completely dry and protected in a plastic bag. During transportation or storage, avoid exposing them to extreme temperature and humidity changes.
- 6) Always test the combination of inks, media and laminating films prior to commercial use. Slight surface mottling may appear in this high gloss film while in the roll form due to the softness of the film itself. This will disappear after one to two days after lamination all by itself. However, if waiting is not an option, a small amount of heat (100° - 120°F) during the laminating process will remove the mottling immediately. Use care not to stretch the film during this process. Always maintain as little film tension as possible to minimize this possibility.

SHELF LIFE

Two years when stored at 75°F (24°C) and 50% relative humidity or less. Note: MACtac recommends that rolls be stored on end or suspended from the core.

** Values given are typical and are not necessarily for use in specification.*

CALL 1-800-401-5005 for additional product information

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