

TECHNICAL GUIDELINES: *THERMAL FILMS*

– Temperature

MSFL Thermal films (Gloss & Matt) can be laminated with the temperature range of 95 to 115 deg C. *Optimum conditions may be selected based on the lamination speed (Dwell time) and dimensional stability

– Pressure

Nip pressure can be varied between 4 – 6 kg / sq.cm

– Speed/Dwell time

Dwell time is inversely proportional to the laminator speed .The speed of lamination machine mainly depends upon the diameter of heated drum / roller.

Machine speed can be varied as 20 – 60 m/min

– Important Note:

Above is the general guidelines, therefore user has to optimize the above parameters according to the type of laminator (especially. diameter of heated roll) & performance of laminated sheet with respect to adhesion & aesthetics.

It is important to make sure that the printed surface is well dried before lamination. In case of dark/solid colour inks used on the paper board, it is always recommended to optimize the parameters based on the results after lamination.
