Matt Velvet Lexan™ Overlaminating Film 7738FL

Product Data Sheet

Updated : April 2004
Supersedes : July 2000

Description :

- 7738 FL offers the opportunity to achieve the attractive appearance of a sub surface screen printed Lexan™ nameplate with an economical overlaminate construction

Features :

- #400 "Hi-Tack" Acrylic Adhesive, offers premium adhesive performance to a wide variety of surfaces, excellent wet out, clarity, non yellowing..
- Lexan™ facestock offers decorative velvet appearance.
- Film liner offers superior graphic appearance.
- 3M brand Overlaminating Films are Underwriters' Laboratories Recognised (File MH11410).

Applications:

- Decorative, protective overlaminate on pressure sensitive labels
- An economical method of achieving the look of a sub surface Lexan™ nameplate.

Physical Properties
Not for specification purposes
(Calipers are nominal values)

Facestock	127 microns (5.0 thou) Velvet Lexan™
Adhesive	20 microns (0.8 thou) #400 Hi-Tack Acrylic
Liner	38 microns (1.5 thou) Clear Polyester
Shelf Life	12 months from receipt of material when properly stored at 22°C & 50 % Relative Humidity

Physical Properties
Not for specification purposes

Adhesion 180° Peel (ASTM D3330) 10 min Dwell		
Stainless Steel	2.6	24

180° Liner Release	Rate of Removal	Gram / 25mm Width
	2.3 m / min	16

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Environmental Performance

The properties defined are based on four-hour immersions at room temperature, unless otherwise noted. Samples were applied to stainless steel 24 hours prior to immersions and were evaluated one hour after removal.

Chemical Resistance

Chemical	Appearance
Isopropyl Alcohol	1.6 mm Edge Penetration
JP-4 Jet Fuel	No Change
10W-30 Engine Oil	No Change
Heptane	No Change
5% Sulphuric Acid	No Change
Temperature Resistance	
121°C (250°F) for 24 hours	No Change noted
-40°C (40°F) for 24 hours	No Change noted
Humidity Resistance	
24 hours at 38°C (100°F) at 100% relative humidity	No Change

Processing

Printing:
Facestock are not print treated. Liner backside has anti-block coating which makes it difficult to achieve good ink anchorage when printing on back of liner.

Die Cutting:
Rotary or flat-bed after lamination.

Special Considerations

For maximum bond strength, surface should be thoroughly cleaned and dried. A typical cleaning solvent is heptane or isopropyl alcohol.
CAUTION: Follow manufacturer's instructions when using solvents.

For best bonding conditions, application surface should be at room temperature or slightly higher. Low temperature surfaces, below 10°C (50°F), cause the adhesive to become firm and will not allow the adhesive to flow and develop intimate contact with the substrate.

Higher initial bonds are achieved through increased rub down pressure. Use maximum laminating pressure for best results.

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