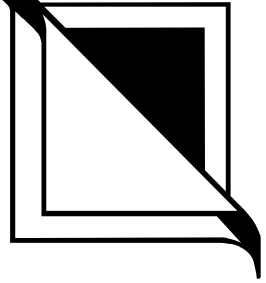


Destructible Security Film

ADHESIVE COATING GUIDE



The adhesives should have the following properties:

1. UV resistance.
2. Temperature resistance/good resistance to aging.
3. High peel adhesion and good shear cohesion.
4. Resistance to bleed and strike through. Harder adhesive formulations will be more resistant to adhesive bleed.

The compatibility with the specified end use is critical. Adhesive coating weight will depend on the nature of the surface to be labeled. In general, keep coat weights as low as possible, consistent with the end use, to prevent adhesive bleed. Adhesive testing on the product to be labeled is highly advisable. (See "Application Surfaces Requiring Caution") (from PSMA).

Release Paper/Backing Material

For most on-roll label stock, standard 67 gsm siliconized glassine backing will suffice, but heavier kraft backing papers may be required for lay-flat material, greater dimensional stability or quality backing print. Careful choice of release characteristics of the liner can help in avoiding bleed of adhesive.

Coating

We recommend that Grafix Destructible Security Film be transfer coated: a uniform coating of adhesive is usually applied from a trough via a roller coating system to the release paper. A uniform adhesive profile across the web is essential to avoid the unevenness in the coated roll.

Grafix Destructible Security Film film should be laminated under low tension in order to avoid web breaks and to avoid excessive curl. Where possible, it should be spliced onto a carrier while treading onto the coating machine before startup. A minimum path length and roller train should be used for Destructible Security Film up to the laminating nip. Excessive residual solvent content left in the adhesive may cause curling of the laminate; dry carefully and thoroughly.

Post-Coating

A period of time after lamination (dependent on coating method, warehouse conditions, etc.) May be required for the master sheet reel to reach equilibrium and stabilize. Slitting should only be undertaken with clean, sharp knives. Edge quality is most important for downstream processing. All rollers should be clean and the material should be wound up under only moderate tensions in order to minimize adhesive bleed, creasing and delamination.

During storage, exposure to extremes of humidity and temperature should be avoided. After initial equilibration, coated rolls should be wrapped in moisture-proof films, e.g., PE.

Shrinkage

A small degree of shrinkage of the Grafix Destructible Security Film face stock may occur during storage of coated product. Adhesive bleed can be minimized by choice of adhesive, coat weight, release liner and winding tension, as noted above.

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