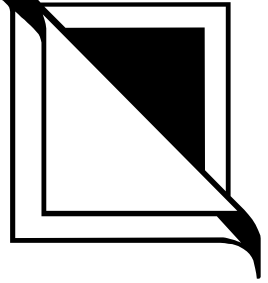


# Destructible Security Film

## PRINTING & DIE CUTTING GUIDE



### Label Design

1. Ensure all corner radii are 5mm or greater.
2. Gutters between labels in the machine direction should be at least twice the width in the cross direction to avoid waste skeleton breaks.
3. Long labels should lead with the shorter dimensions.
4. Label shape should be as simple as possible, i.e., squares, rectangles and circles. T-shapes, tadpole and butterfly shapes are possible, but reduced running speeds may be necessary to facilitate matrix stripping.

### Printing

Grafix Destructible Security Film can be printed by conventional techniques including letterpress, flexo and screen processes. Whenever printing Destructible Security Film for the first time, or with different inks and/or machines, we strongly recommend carrying out proofing trials. When using ink systems, the use of primers and/or over-varnishes may be necessary to achieve high levels of tape adhesion and scratch resistance. See our data sheet for guidance or contact Grafix, Inc.

### Die Cutting

1. Flatbed or rotary dies can be used. It has been found that a standard "vinyl" bevel is suitable. Single bevels should be to the outside at about 20 degrees. As with printing trials, a pre-press die cutting/stripping trial is recommended. Cutting edges must be sharp and free from nicks. Avoid cutting through into the release liner, as this can cause problems in matrix stripping owing to Destructible Security Film's destructible nature.
2. A stripping roller has been found to perform better than a "stripping bar".
3. Where slit edge quality is causing problems, machines capable of slitting the back (approx. 5-10mm in from each edge) to support the edge of the film matrix during stripping, will be of benefit.
4. Assist rollers may alleviate breaks at high speed due to flexing of the die cylinder.
5. Low temperatures increase the brittleness of the film and are to be avoided during die cutting.

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