

Guidelines for Using HoloLam Plus® (U.S. Patent No. 7,544,266 B2)

Orange Peel

The unwanted "orange peel" textured surface look can be improved by lowering your normal lamination temperatures by 20°F/10°C and allowing for a longer lamination cycle time (by 5 to 10 minutes). We have also learned that the cap sheet material used and the texture of its adhesive coat has a great deal to do with creating a textured appearance. If you encounter this problem, and you have already lowered temperatures and increased cycle times, try a different cap sheet material.

Lower Peel Adhesions (Of Laminated Cards)

HoloLam Plus has a quick cure bonding system that achieves much higher peel values.

- Some users of HoloLam Plus have experienced lower peel strengths between the PVC core layers of the laminated card. There can be many reasons for this. Not enough heat, or not enough time are two obvious reasons.
- Although we have heard of successful use of cap sheets without an adhesive applied with HoloLam Plus, we highly recommend that cap sheets with adhesives be used in conjunction with HoloLam Plus sheets.
- HoloLam Plus sheets have a print treatment. Some clients are applying a primer coat to the HoloLam Plus sheet before printing. Alternatively, HoloLam Plus with CFC's proprietary topcoat can take the place of primers/print adhesives.

Sheet Handling

Depending upon plant and weather conditions, sheet handling issues may occur. To minimize this condition, handlers can apply a primer coat to HoloLam Plus, or alternatively purchase HoloLam Plus with CFC's proprietary topcoat that can take the place of primers/print adhesives. The use of static tinsel or brushes, and/or de-ionized air with the air nozzles in the stacks has also been successful in reducing processing issues. Another helpful hint is to have your staff wear gloves when handling HoloLam Plus sheets which can minimize these sheet handling occurrences.

Laking

To eliminate laking, a PVC supplier recommends that the pressure of the cooling cycle should be two times higher than that of the heat cycle but that the pressure in the cooling cycle not be raised until a full two minutes expires once the cooling cycle begins.

NOTE: Instructions given herein are approximate and adjustment may be required in adapting materials for use in any specific application. The data presented is a result of careful and extensive research. However, since the actual conditions under which the materials may be used are beyond our control, no warranty of any kind, expressed or implied, concerning the use of the products is made. Date: 10/08/09.