



TECHNICAL DATA SHEET - DIGITAL PRINTING - LAMINATE - PERMANENT ADHESIVE XT480

Film composed of a 480- μ m, calendered, monomeric PVC and coated with a pressure-sensitive acrylic adhesive. For cold-laminating digital printing films intended to be used as kits for medium-term decoration on motorcycles, ATVs, jet-ski etc. Glossy surface finish.

FILM FEATURES:

	<u>Indicative value</u>	
• Thickness (μ m):	480	
	<u>Average values</u>	<u>Standard</u>
• Tensile strength (N/25 mm):	min. 100	HEXNFX41021
• Elongation at break (%):	min. 100	HEXNFX41021
• Shrinkage 168 hours at 70 °C (158 °F) (mm):	< 1.5	HEXRET001

LINER:

- Silicone-coated Kraft paper 87 g/m² with grey HEXIS print.
- Stable under hygrometric variations.

ADHESIVE PROPERTIES:

(Measured average values at publication of the technical data sheet)

	<u>Average values</u>	<u>Standard</u>
• Peel strength test 180° on glass (N/25 mm):		HEXFTM001
after 20 minutes of application	29	
after 24 hours of application	34	
• Initial tack (N/25 mm):	39	HEXFTM009
• Release (N/25 mm):	0.3	HEXFTM003
• Resistance to solvents: the adhesive is resistant to most chemicals (alcohol, diluted acids, oils).		

ADHESIVE:

- Solvent-based, acrylic adhesive.
- Immediate and permanent adhesion.

USER'S INSTRUCTIONS:

- Recommended minimum application temperature: +10 °C to +35 °C (+50 °F to +95 °F).
- Range of film operating temperatures: -30 °C to +60 °C (-22 °F to +140 °F).
- It is recommended to use it in combination with the digital printing film XTPRINT as medium-term "motorcycle kit" (duration of several competitions).
- Resistance against mechanical stress (impact of gravel, scratches etc.) or water splashing due to extreme sports such as trials, rallies or surface water sports.
- In the case of an already painted substrate, self-adhesive media must only be applied to undamaged original paintwork. If the paintwork is not original and/or damaged, the application and the removal are at the judgement and risk of the installer.

OPERATING RECOMMENDATIONS:

- Before applying this laminate to a calendered HEXIS film intended for solvent-based digital printing, it is recommended to respect the optimal drying time for the inks of 24 hours.

STORAGE:

- Shelf life (before application):

The shelf life of this film is 1 year when stored upright in its original packaging in a dust-free environment at a temperature ranging from +15 °C to +25 °C (+59 °F to +77 °F) with relative humidity of 50 %.

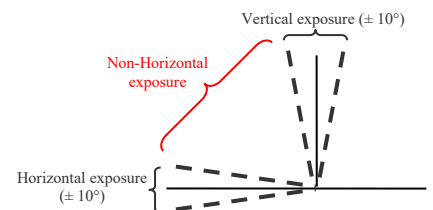
DURABILITY: (Central European climate)

- Vertical outdoor exposure:
Without mechanical stress: up to 2* years.
With mechanical stress: depends on the type and frequency of the stresses.

*Time during which the film retains a correct surface finish, from a conventional viewing distance. (A slight and gradual change in colour and gloss is a natural and inevitable phenomenon inherent in the natural breakdown of the materials).

Note: The durability indicated in this document:

- concerns only the laminate and not the finished visual or graphic.
- is inherent to an upright position of $\pm 10^\circ$ and to the product's geographical exposure position. Any other position accentuates climatic influences and an alteration in gloss or colour, or even a slight dusting may appear. Southern exposure, with a 45° inclination can divide the durability of the film by 2, and horizontal exposure by 2.8. Application to the vehicle bonnet is particularly severe, due to the horizontal exposure and the heat from the engine.
- is confirmed by UV ageing tests and vertical natural outdoor weathering.



To find the indicative durabilities of the films for any other exposure and geographical area, please refer to the "Conversion rules for indicative durabilities according to geographical area" chart available under Durability, on the "Professionals" pages on our site www.hexis-graphics.com.

NOTES:

Due to the great variety of substrates and the growing number of new applications, the installer must check the suitability of the medium for each application.

The measuring methods for the standards quoted above served as the basis for the development of our own measuring methods, which are available on request. Please feel free to contact us to get the latest instructions in use.

All the published information is based on measurements regularly performed in the laboratory. It does not however constitute a binding guarantee. The seller cannot be held liable for indirectly related damages and assumes no liability for claims that are higher than the replacement value of the purchased product. All specifications are subject to potential changes without prior notice. Our specifications are automatically updated on our website www.hexis-graphics.com.