



B2L “BOTTLE 2 LAMINATE” / PRESSING INSTRUCTIONS FOR MEMBRANE & VACUUM PRESSES

This 3D Forming Laminate is no ordinary PET but rather a special product made from recycled Water bottles. The product is considered green in that it recycles **2 water bottles per square foot** and they are therefore reused rather than simply dumping them in the landfills where it can take over 1000 years to decompose.

TEMPERATURE:

We recommend temperature between a range of 95°C and 105°C. Tests must be started on the higher temperature and cool down the temperature on 3°C each test until a satisfactory result.

Temperature caution:

- Very low temperature may cause bad quality forming
- Very high temperature may cause loss of glossy finish or lightening of color on corners
- Very high temperature may cause defects on the surface.

LAMINATE WARMING TIME:

Recommended warming time must be between from 35 up to 52 seconds. Tests must be started with 52 second of warming time and slow down 5 seconds on each test until a satisfactory result.

Warming time cautions:

- Long warming time may cause wrinkles and defects on the surface
- Long warming time may cause loss of glossy finish
- Short warming time may cause irregular forming, mainly on the corners

FORMING TIME:

The recommended forming time is a range from 30 seconds up to 40 seconds. Tests must be started on the longest forming time and reduce 2 seconds on each test until a satisfactory result

Forming time cautions:

- Short forming time may cause imperfection forming on low relief surfaces
- Long forming time cause fast wear of the molds and the machine working table

DISTANCE BETWEEN THE PIECES AND THE TABLE BOARD:

The distance recommended between the pieces and the table board is 3.5”; longer distance may cause failures on the forming corners.

IMPOTANT QUALITY CONTROL NOTE: It should be noted that pressing B2L requires experience by professional component manufacturers who are adept at pressing PET laminates. Unlike virgin PET Laminates, B2L may also require additional QC to ensure no recycle defects make it onto components or get shipped to your customer. In addition, heat strips should be used to ensure that proper heat is achieved according to your glue suppliers recommendation. Since B2L forming is done so at lower temperatures than typical PVCs this should be closely monitored.

