

Processing instructions for postforming.

Feelz City 2D PET

The postforming of Feelz City 2D PET to different substrates is an industrial complex process. Hereby some important factors to consider, which have a direct influence on the desired processing result. The necessary handling, as well as the described storage below, are basic requirements for perfect postforming.

Preparation for postforming:

The foil is supplied as standard in roll form and hanging in plastic side panels. The foil rolls and the substrate to be laminated, should be conditioned at room temperature (20°C +/-3°C) 48 hours before the postforming process.

Postforming Process:

Postforming can be divided into the following work steps:

1. PUR hot melt adhesive is applied to the foil
 2. The substrate is wrapped with the foil
-
1. Application of PUR hot melt adhesive to the back of the foil
 - The PUR hot melt adhesive is generally melted in a drum melter. The required adhesive temperature can be found in the manufacturer's data sheet. The adhesive is applied to the foil as a thin film using a wide slot nozzle. Hereby you have to observe the recommended application amount from the adhesive manufacturer. The amount of adhesive depends on the substrate. Various adhesives from different manufacturers have been successfully tested with the relevant processing parameters, these can be requested from the technical team.
 2. Wrapping the substrate with the foil
 - The foil and substrate are connected with pressure rollers. The pressure rollers are to be adapted to the shape of the substrate.
 3. Treatment after postforming
 - After postforming, the foil will be cut to length according to the substrate size and if necessary, the overlapping foil trimmed from the edges. For further processing, the coated substrate must be stored for at least 24h at room temperature (>20°C). Storage below room temperature (<20°C) will result in insufficient adhesion between the foil and the substrate.