



RESOURCES, INC.

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Product Specification: High Grade Vacuum Forming Foils
Code # HV

Product Description: High Vacuum Foils
Available Roll Widths: 25 inch & 50 inch width
Available Films: 25mic & 38 micron PET Matte or Gloss
Substrates: ABS, PS, Rigid PVC

Features

Specially formulated for deep draw thermoforming. Excellent heat resistance.
1000 ~ 1500 hrs accelerated UV light exposure
High UV opacity and fade resistant.

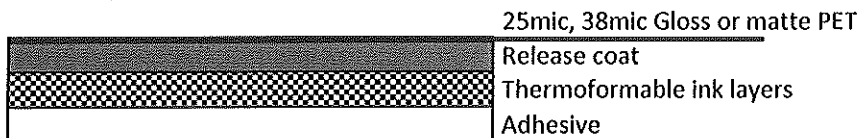
Recommended Stamping Conditions

Application Process	Roll-On Process
Application Temperature Range	160 c ~ 190 c / 320 - 375f
Type of Roller	Silicone Rubber (75 durometer)
Stamping Speed	4 ~ 5 m/min (12' - 15' /minute)

Testing Programs

Programs	Result
• Hardness by scratch test(ASTM D3363 reference)	No effect (2H Pencil)
• Adhesion test	No pull on tape (3m/ #600)
• Printing definition	No effect
• Acetone test	Minimal degradation
• House cleaner and alcohol test (Window cleaner,etc)	No effect
• Oxidation Test (45~50C / 85~90% of humidity)	No effect
• ISO 11507/4892-3 Light Fastness	1000 ~ 1500hrs Q-Lab
• Flake test	No flaking
• etc : Special Testing Required	Deep draw molding

Make Up Structure



STORAGE CONDITIONS

The foil shelf life is directly related to the storage conditions. When possible, keep the foil in a controlled atmosphere of between 65 - 75°F and a relative humidity of not more than 65%. Cool dry conditions are best when controlled atmosphere is not available. Do not store foil in direct sunlight, near open windows, near heat or conditions of dampness – Do not allow the foil to become physically wet. If long term storage is required over 9 months, material should be polybagged and sealed.

The data presented is the results of extensive research, however, since the actual conditions under which this foil is used is beyond our control, adjustments to these recommendations may be required to achieve optimum results. Test results represented are internal quality audits for this product and do not imply a warranty of any kind.