



## TECHNICAL INFO N° 2

### MACcrystal CONVERTING ADVICES

During the first converting process of this type of construction, taking care of the following converting advices will help you to reduce both scrap level and makeready time.

#### 1. WEB TENSION

Considering the specific nature of this self-adhesive material (Polyester onto Polyester), a specific care must be taken at the web tension during all the converting steps.

A too tight tension will cause adhesive bleeds on the roll edges.

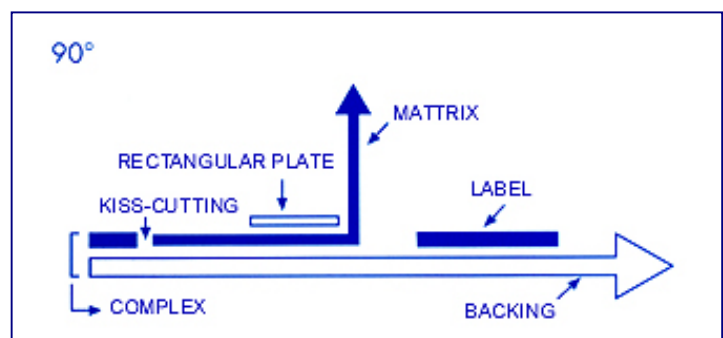
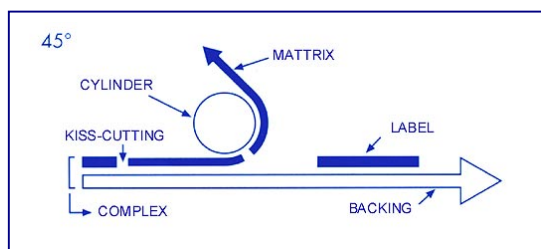
A too loose tension will cause windings problems.

The perfect web tension calibration will have to be found in function of the specific needs of your equipment.

#### 2. MATTRIX STRIPPING

The ideal mattrix stripping angle is 90° (it will be easier to use a rectangular mattrix stripping plate instead of a cylindrical mattrix stripping cylinder - see sketch).

Under that specific angle, the higher the speed, the easiest the mattrix will strip off the web.



#### 3. « KISS-CUTTING »

It's of tremendous importance to use state of the art dies (sharp dies with no adhesive residues and don't use silicone spray to lubrify the dies) which have been especially engineered for PET die-cutting (single bevel, at 20°). Please contact your cutting tools supplier for more information in function of your specific equipment.

#### 4. INKS

Inks formulated for PET or eventually for PVC are suitable.