

Guidelines

TSS802 PET TD Shrink Film



DESCRIPTION

High Shrink film Sarafil TSS802 is a monoaxially oriented co-polyester ready-to-shrink film designed for outer sleeve labelling applications on plastic, glass and metal containers of various sizes and shapes. Once heated the film shrinks up to maximum 78% at 100°C in one direction (Transverse Direction). The film has on one side an acrylic coating to provide an enhanced printability indicated by the last digit of the code, "I" or "O": TSS802I (coated Inside) - TSS802O (coated Outside).

PRINTING

Printing technique: the film is suitable for all most common technologies.

Processing recommendations:

It is recommended to print on the pre-primed coating side.

Tensile strength in Machine Direction is lower than in cross direction, since the film has not been oriented in this direction. Therefore, for a safe processing it is recommended to maintain a gentle unwinding/winding tension, particularly during the start up of the press, the turreting, the splicing and even more when temperatures of inks drying units are set at high levels (never exceeding 50°C). This accuracy will reduce the risks of film elongation or breakage during the printing process.

Extra care for a good drying is strongly required to avoid that solvent is retained after printing, leading to unpleasant odor and/or embrittlement of the film.

Inks: check with your ink supplier the most suitable series to be used with PET shrink films.

SEAMING

Seaming technique: all most common seaming tools can be used.

Processing recommendations: it is recommended to use THF or 1,3-Dioxolane. They can also be mixed gradually. Customer needs to always check quality and performances of the seaming prior to process it industrially.

After a controlled evaporation time, the film is pinched together to form a continuous tube or 'lay-flat'. Pressure applied by the nip rollers is very important and should be carefully controlled as high pressure can cause problems, in particular the edges of the tube may be deformed and it may result difficult to re-open it during the sleeving process or crease marks might be visible on the finished sleeved article.

Solvent quality should be carefully considered as impurities can lead to a variety of defects. Excessive use of solvent can lead to a risk of welding internally or externally of the lay-flat.

Seaming check: 48 hours after seaming a careful check should be conducted to ensure that adhesion is as expected and no 'whitening' or "embrittlement" in the seamed area occur.

Tension: recommend to maintain the sealing tension as low as possible.

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SLITTING

Processing recommendations: the reel slitting operation can be performed at any stage of the converting process. In case this is done just after a printing or seaming process, wait at least 48 hours in order to be sure that inks curing and/or solvent drying processes have been definitively terminated.

The reels slitting must be performed with appropriate well-sharpened “rotary” cutter blades. Failure to do so, for example by using fixed razor blades, may cause the formation of a thick and raised edge. Because of the heat sensitivity of shrinkable polyester films, the high temperature which might develop progressively during a non-rotatory cutting process could activate the shrinkage of the film on the cut edges.

STORAGE & HANDLING

Film rolls are packed by suspending in paper core, side ply and pallet. Need to ensure that rolls are always in suspension position inside packing.

Store reels with original packing till the time of use. If the whole reel is not used at once, please repack it similarly to the original one.

Ideal storing temperature condition of the film is $25^{\circ}\text{C} \pm 5^{\circ}\text{C}$. It is strongly recommended to avoid temperatures less than 10°C or over 30°C .

Store the film in an environment whereas RH (Relative Humidity) is not exceeding 55%.

Avoid direct sunlight exposition.

Store reels on the ground floor and on a flat surface.

Do not expose the film to rapid temperature changes.

24 hours prior to processing the film (printing, seaming, slitting or shooting for labelling containers), bring the reels in the same environment of the processing equipment to condition them at the same ambient temperature.

Use a suitable fork-lift equipment when you move the reels.

Do not drag or roll the film reels on the floor.

Prevent any kind of severe impact on film reels.



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TPL Transparent Paper Ltd.

Headquarter: Thurgauerstrasse 40, P.O. Box, 8050 Zürich/Switzerland, Tel. +41 44 308 92 92, info@tpl.ch, www.tpl.ch
Sales office: Via Campagna 26, P.O. Box, 6934 Bioggio/Switzerland, Tel. +41 91 610 44 55

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