



# MagnaCryl 4505S Cold Foil Adhesive for Film

## Product Information Sheet

MagnaCryl 4505S is a U.V. curable cold foil adhesive designed to be applied via flexo press running at speeds between 150 and 300 fpm. It was designed print on film substrates and to adhere pattern printed foil in a specific pattern quickly and easily.

### Typical Properties, Uncured

<b>Appearance</b>	Clear or Blue
<b>Viscosity</b>	700 cps

### Directions For Use On A Flexo Press

Note: Successful use of this product will vary depending on the available power of the U.V. light, the speed of the press and the distance between the UV light and the foil/substrate contact point.

1. Make sure that the surface to be coated is clean and oil free.
2. Apply a film to surface using an analog roller. Film thickness depends on users needs but should not exceed 1 mils.
3. Cure under an ultra violet lamp. Cure time depends on the power and the location of the ultra violet light source. The adhesive will be 'sticky' after passing the UV light. The press configuration should be arranged so that once the adhesive has passed the UV light, it does not come in contact with any surface except the foil as the image quality will suffer.
4. Immediately after curing, foil must be brought in contact with the substrate via a 90 durometer nip roller.
5. Always test all inks and other issues to confirm quality level is acceptable. Refer to drawing of web path.

### Processing Techniques

1. An analog roller of 300 lines is suggested as a starting point for running this material.
2. We recommend the use of a doctor blade.
3. We recommend running your press between 150 and 300 fpm. The best results have been obtained at approximately 100 to 125 fpm with 1 400 watt UV bulbs.
4. We recommend API foil as a source of foil supply.
5. We recommend using as sharp an angle as possible when lifting the foil away from the substrate to maintain sharp lines on your image.

**Technical Services:** Please contact the Beacon Chemical Technical Services department at 914-699-3400 with any further questions.

**Handling:** Prevent contact with skin, eyes and clothing. Refer to MSDS for further recommendations.

