

MACal® 9800 CAST

PRODUCT DESCRIPTION

MACal 9800 CAST are polymeric stabilized cast vinyl films coated with a durable permanent adhesive giving excellent dimensional stability.

MACal 9800 CAST is designed for computer cutting and fast weeding, even for small letters and fine lines.

Face material:

Polymeric stabilized cast vinyl, 66 µm thick, cadmium-free. MACal 9800 CAST SL have a white tie-coated face at the back.

Adhesive:

Clear solvent based permanent acrylic adhesive.

Liner:

Stable 135 gsm white kraft paper with grey backprinting. For white vinyls the liner is coated with a blue silicone coating to improve the contrast with the film colour.

NB : CONTRAST ensures a clear view during the stripping process therefore improving productivity.

TYPICAL USE

MACal 9800 CAST is designed for long term interior and exterior marking applications (vehicle marking, window graphics, signs...).

MACal 9800 CAST provides ideal conformability over flat to curved surfaces with rivets and simple corrugations.

MACal 9800 CAST SL are intense, vibrant colours for eye-catching markings.

COLOR MATCHING

Customer colour matching service is provided by MACTac. This colour matches can be requested from a minimum quantity of 5 rolls (250 lm).

PROCESSING

Computer cutting

Clean, quick, trouble-free cutting with most plotters. Adjustment of the cutting depth is important: if the cut is too deep this could result in the paper splitting and coming away with the adhesive when the vinyl is transferred to Application Tape.

MACal 9868-100 Cast Silver requires special attention when converting, small letters (<2cm) are not recommended.

SHELF LIFE

2 years when stored at 15 to 25°C and ± 50 % relative humidity (in the original packaging).

APPLICATION METHOD

For matt products: we recommend the use of a high tack application tape in order to ensure a good

transfer of all letters (for example MACTransfer 100 High grade).

The transfer of the cut vinyl onto the Application Tape should always be performed by removing the liner from the pressure-sensitive material (i.e. with the PVC face downwards onto the working surface) and not by lifting off the Application Tape.

MACal 9800 CAST can be applied with the dry application method on curved surfaces. On flat surfaces the dry or the wet application method is suitable.

IMPORTANT REMARK

All surfaces to which the material will be applied must be thoroughly cleaned from dust, grease or any contamination. The compatibility of paints and lacquers should be tested by the end-user, prior to use.

EDGE SEALING

Where exposure to chemicals and solvent spillage is likely to occur, edge sealing of decals with a varnish will prevent edge lift

SOLVENT AND CHEMICAL RESISTANCE

Resistant to most oils and grease, fuel, aliphatic solvents, weak acids, salts and alkalis.

PHYSICAL PROPERTIES (TYPICAL VALUES)

| Face Material Data, 23°C | Average values | Test method |
|---------------------------|----------------|---------------|
| Tensile strength (N/15mm) | > 24 | DIN ISO 527-3 |
| Elongation at break (%) | 150 | |

Excluding Metallic colours and colour matching

Thickness - Face film + adhesive (µm)

| | | |
|--------------|-----|---------|
| 9800 Cast | 95 | ISO 534 |
| 9800 Cast SL | 100 | |

Adhesive data, 23°C (N/25 mm)

| | | |
|--------------------------------|------------|-------|
| Peel on mirror Stainless Steel | 20 minutes | FTM 1 |
| | 24 hours | |
| | 1 week | |
| | | |

Dimensional stability

| | | |
|---|--|--------|
| Shrinkage (1 week at 70°C applied on aluminium) | Max. 0.2 mm Max 0.5 mm for 9800 Cast SL | FTM 14 |
|---|--|--------|

Temperature ranges

| | |
|----------------------------------|------------------|
| Minimum application temperature | + 8°C |
| Service temperature range of use | - 40°C to + 90°C |

EXPECTED DURABILITY*

Central Europe Zone 1

| | | |
|---------------|----|-------------|
| Black & white | 10 | ISO 4892-2. |
| Colours | 8 | |
| Metallics | 5 | |

Note : Exposure to severe temperatures, ultraviolet light, and/or conditions in Southern European countries, tropical, sub-tropical or desert regions will cause more rapid deterioration. This also applies to polluted areas, high altitudes and south-facing exposure. No durability warranty is given for horizontal exposure.

Important notice Information on physical and chemical characteristics and values in this document are based upon tests we believe to be reliable and do not constitute a warranty. They are intended only as a source of information and are given without guarantee and do not constitute a warranty. Purchasers should independently determine, prior to use, the suitability of this material to their specific use.

All technical data are subject to change. In case of any ambiguities or differences between the English and foreign versions of this document, the English version shall be prevailing and leading.

Disclaimer and warranty

MACal 9800 CAST range is available only in the following countries: Germany, Austria, Switzerland, Belgium, Holland, Luxemburg.

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