

TECHNICAL DATA SHEET – DAO CAST KG8000 Series

Range of products consisting of a 50- μ m, very high performance cast vinyl, which is coated with a pressure-sensitive solvent-based acrylic adhesive.

FILM FEATURES:

	<u>Average values</u>	<u>Standard</u>
• Thickness (μ m):	50	
• Tensile strength (N/25 mm):	min. 15	HEXNFX41021
• Elongation at break (%):	min. 90	HEXNFX41021
• Shrinkage after 168 hours at 70 °C (mm):	< 0.3	HEXRET001

LINER:

- Silicone-coated kraft paper of 137 g/m² with grey “THE CAST by HEXIS” print
- Stable under hygrometric variations

ADHESIVE PROPERTIES:

(Average values measured at data sheet editing time)

	<u>Average values</u>	<u>Standard</u>
• Peel on glass at 180° (N/25 mm):		HEXFTM001
after 20 minutes of application on glass	17	
after 24 hours of application on glass	19	
• Initial tack (N/25 mm):	17	HEXFTM009
• Release (N/25 mm):	0.25	HEXFTM003
• Solvent resistance: the adhesive is resistant to most chemical agents (alcohol, petrol, diluted acids, oils and fuels).		

ADHESIVE:

- Solvent-based acrylic adhesive
- Immediate and permanent adhesion, suitable for wet application only on flat surfaces

USER'S INSTRUCTIONS:

- Minimum application temperature recommended: +7 °C (+45 °F)
- Operating temperature range: from -40 °C to +90 °C (-40 °F to +194 °F)
- Product only suitable for rolling devices and rolling vehicles.
- In the case of already painted substrates, self-adhesive media must only be applied onto undamaged original paintwork. If the paintwork is not the original and/or is damaged, the application and the removal are at the installer's own judgement and own risk.

RECOMMENDATIONS:

- The colour of the films is controlled by HEXIS in order to ensure faithful reproduction of the colour tints. Nevertheless, should your project require the use of several rolls of a single colour reference, HEXIS recommends to use only one batch number of this colour.
- For further information on the application method of the KG8000 film, please refer to the Application Guide available on the "Professionals" pages, category "Sign vinyl" on our website at www.hexis-graphics.com.

STORAGE:

- Shelf life (before application):

The shelf life of this film is 2 years if it is stored unopened in its original packaging at a temperature ranging from +15 °C to +25 °C (from +59 °F to +77 °F), with relative humidity between 30 % and 70 %.

INDICATIVE DURABILITIES:

- The pigments (colouring) of the PVC influence the durability of the colours. An estimate of such a durability is obtained by accelerated ageing tests of the CAST KG8000 films under UV rays and by outdoor exposure.

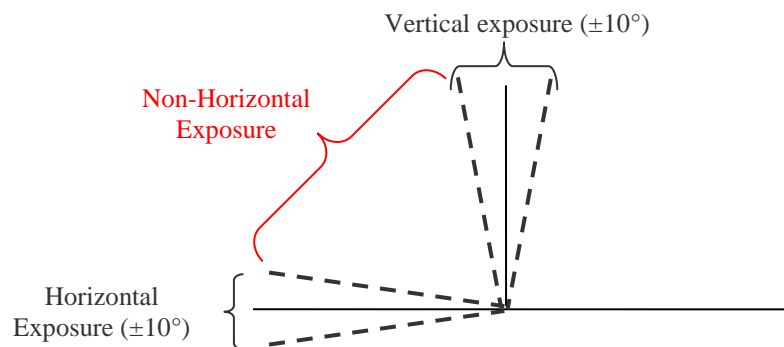
Tinge	Indicative durability (years) ⁽¹⁾ Vertical exposure (±10°) Central European climate
White, black gloss	10
Colours, other tinges	8
Metallics	4

Chart I: vertical durabilities⁽¹⁾ Central Europe

- The results indicated above are notably obtained from outdoor vertical exposure ($\pm 10^\circ$ angle). The durability conditions indicated in Chart 1 are inherent to this position up to a few degrees. Any other position accentuates the climatic impacts and may further the appearance of gloss and colour alteration, even a slight dusting phenomenon may occur. Application on a vehicle bonnet/hood is particularly severe, because of the combination of a horizontal exposure and the heat coming from the engine.
- To estimate the durabilities for non-vertical exposure, divide the durabilities in Chart 1 by the factors given in Chart 2.

Exposure	Division factor ⁽¹⁾
	Central European climate
Non-vertical exposure	2
Horizontal exposure ($\pm 10^\circ$)	2.8

Chart 2: Division factors



- The real durability of a product depends on a large number of parameters, including, among others, the quality and the preparation of the substrate, the exposure (environment, climate, exposure angle), the film maintenance, and the degree of pollution.

To find the indicative durabilities of the films for the country of exposure, please refer to the "Conversion rules for indicative durabilities according to geographical area" chart available under Durability in the "Professionals" pages of our website at www.hexis-graphics.com.

Note:

(1) The durabilities indicated in this document do not constitute a warranty. They are an estimate of the duration during which the film keeps a correct appearance at the customarily observation distance.

A slight and progressive modification of the colour and brightness is a natural and unavoidable phenomenon inherent to the natural degradation of materials.

Because of the great variety of substrates and the growing number of new applications, the installer must check the suitability of the media for each application.

The measuring methods for the standards quoted above served as basis for the development of our own measuring methods which are available on request. Please feel free to contact us to get the latest instructions in use.

All information released originates from laboratory measurements on a regular basis. However, it does not constitute a binding warranty. The seller is not held accountable for indirectly related damages beyond the replacement value of the purchased product. All specifications are subject to potential changes without prior notice. Updates of our specifications are automatically available on our website at www.hexis-graphics.com.