

# TECHNICAL DATA

## ITEM : Soft Foam

PRODUCT DESCRIPTION	STRUCTURE
Polyurethane heat transfer film similar to the Nubuck leather made of surface buffing works.	<div>HOT MELT layer</div> <div>SKIN layer</div> <div>Pressure Sensitive Adhesive layer</div> <div>Carrier film layer</div>

TECHNICAL DATA					
No.	Classification	Type	Unit	Universal	Method
1	Hotmelt	Ester hotmelt	$\mu\text{m}$	70 $\pm$ 10	ASTM D3652
2	Skin	PU Resin		440 $\pm$ 20	
3	PSA	Silicone PSA		131 $\pm$ 5	
4	Carrier film	PET		100 $\pm$ 2	
5	Peel force	UTM T-Peel	gf/in	190 $\pm$ 110	ASTM D3330

TEST CONDITION & FUNCTIONAL DATA						
No.	Method	Test Machine	Test Condition			
1	CUTTING	Roland CAMM-1 (GS-24) Cutting only		BLADE (°)	60°	
				FORCE (gf)	150 ~ 220	
				OFFSET (mm)	0.325	
				SPEED (sec)	15	
2	WEEDING	Weeder		CUT SIZE	MIN	MAX
				4 mm	0 %	56 %
				6 mm	0 %	100 %
				8 mm	33 %	100 %
3	HEAT PRESS	Hotronix (XRF)		TEMP	150 $\pm$ 3°C	
				PRE HEATING	3 sec	
				TIME	15 sec	
				PRESSURE	34 $\pm$ 2 Psi	
4	PEEL OFF	Handling		HOT PEEL	x	
				WARM PEEL	x	
				COOL PEEL	○	
5	WASHING	Samsung Drum type (WD16J7100KW)		TEMP	Washing 60°C	Rinse 5~30°C
				CONDITION	Washing	Normal
					Rinse	2 Times
					Dehydration	Strong
					Drying	30 min
				TIME (108 min)	Washing	36
					Rinse	22
					Dehydration	10
					Drying	30
					Washing time	About 10
				CYCLE	5 Times	

STORAGE	Store at room temperature (temperature : $20 \pm 5^{\circ}\text{C}$ , humidity : $35 \pm 15\%$ ) and avoid exposure to direct sunlight.
CUTTING NOTES	You should always test cut prior to any production run. Hotmelt layer separation may occur depending on cutting blade condition and working conditions.
WEEDING NOTES	It is necessary to pay attention to the operator when removing the pattern after confirming the cutting condition.
PRESS & PEEL OFF	Use of test condition is recommended.
WASHING NOTES	Do be careful of damage due to washing conditions, and laundry products.