

TECHNICAL DATA

ITEM : Soft Puff (Metallic)

PRODUCT DESCRIPTION	STRUCTURE
METALLIC PU PUFF-series is thermally heat transfer metallic foil skin with polyester hotmelt adhesive.	<div>Hotmelt</div> <div>METALLIC PU PUFF</div> <div>Carrier Film(Protective film)</div>

TECHNICAL DATA					
No.	Classification	Type	Unit	Universal	Method
1	Total Thickness	METALLIC PU PUFF	μm	272 \pm 10	ASTM D3652
2	Adhesiver	Hotmelt		158 \pm 10	
3	SKIN	METALLIC PU		114 \pm 5	
4	Carrier film	PET		100 \pm 50	
5	Peel force	UTM 90°	gf/in		ASTM D3330

TEST CONDITION & FUNCTIONAL DATA						
No.	Method	Test Machine	Test Condition			
1	CUTTING	Roland CAMM-1 (GS-24) Cutting only		BLADE (°)	RB455(45°)	
				FORCE (gf)	80~120	
				OFFSET (mm)	0.25~0.3	
				SPEED (sec)	15	
2	WEEDING	Weeder		CUT SIZE	MIN	MAX
				4 mm	0 %	0 %
				6 mm	0 %	0 %
				8 mm	60 %	100 %
3	HEAT PRESS	Hotronix (XRF)		NUMBER	1st	2nd
				TEMP	150 \pm 3°C	150 \pm 3°C
				PRE HEATING	3 sec	-
				TIME	5-10 sec	10-15 sec
				PRESSURE	45 \pm 2 psi	45 \pm 2 psi
4	PEEL OFF	Handling	1st	HOT PEEL	X	
				WARM PEEL	X	
				COOL PEEL	O	
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. -1st press (150°C, 5-10sec, 45psi) - COOL PEEL -2nd press after peel off carrier. (150°C, 10-15sec, 45psi)
WASHING NOTES	Do be careful of damage due to washing conditions, and laundry products.