



# FLAT LAMINATION

## USER GUIDE

Premeer is a product of Interprint

## Premeer® Product Description

### Premeer is printed and coated oriented polypropylene film (OPP)

- OPP basis weights: 32 and 56 gsm
- OPP thickness: 1.2 and 2.0 mils before coating  
*Coating will add 0.3 to 0.7 mils depending on surface properties desired.*
- Premeer Product Grades: Good, Better and Best quality
- Printing Process: Rotogravure, 4 units; water-based organic pigments, excellent light stability, No VOCs
- Coating Process: In-line roll coater, polymerized by Electronic Beam (EB)  
*Coating is a blend of oligomer and monomer acrylate polymers.*  
*Functional additives are available to enhance surface characteristics upon request.*
- Premeer is sold in roll form ready for lamination:  
Width: 127 cm/50 in. and 157 cm/62 in. *(custom dimension available on request)*  
Roll diameter: 56 cm/22 in. *(custom dimension available on request)*  
Length per roll : 4800 LM (32 gsm) 3000 LM (56 gsm) Core diameter: 15 cm/6 in. diameter
- Packaging: 4 individually wapped rolls per shipping skid stacked in a suspended mode *(2 rolls on 2 rolls)*
- Handling/Storage: Standard lift truck with long fork, dry storing conditions: 10° – 30° C
- Approved waste disposal: Incineration for power generation or regular landfill

## Flat Lamination Parameters

- Type of laminators:  
3 press (Harlan, Hymmen), 2 press (Harlan, Dubois), 1 press (Black Bros TB60, Fitz, Walco)
- Type of board: Particleboard, MDF, Thin MDF, Thin HDF, plywood, luan plywood, hardboard cardboard, sheet rock, Dragon board
- Speed range: 15 m/min. to 50 m/min.
- Temperature of board entering into the press: 25° – 35° C
- Glue: Liquid high solid EVA  
*There are many EVA suppliers available like PA 310 from H.B. Fuller (old Forbo)*
- Evaluations: Typical bond strength 4 PLI using cross hatch test Grain rise: visual
- Stability of the laminated board: No warping of single face lamination

## Post Lamination Machining

- Sawing: Rip saw (Homag, Holtzer, Gibben) with scoring saw
- Blades: Use same type of blades as foil paper (Gladu Super Plus Saw Blade)  
*Note: It is a different saw blade then for melamine as it runs cooler, cleaner with no chipping*
- CNC/Drilling: For a cleaner cut without chipping, a double helix design tool bit is recommended (Gladu compression bits)

## Contact



**Interprint, Inc.** 101 Central Berkshire Blvd., Pittsfield, MA 01201  
www.interprint.com www.premeer.com (413) 443-4733