



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, 41 and 56 gsm
- OPP thickness: 1.2, 1.6 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 block-free 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*) Core diameter: 15 cm/6 in. diameter
Length per roll : 3000 to 3500 LM (32 gsm), 3000 to 3400 (41 gsm) and 1500 to 2000 LM (56 gsm)
- 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 30 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



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