



# FLAT LAMINATION & WRAPPING USER GUIDE

Premeer is a product of Interprint

## Premeer Product Description

Premeer is printed and coated oriented polypropylene film (OPP)

- OPP basis weights: 41 and 56 gsm
- OPP thickness: 1.6 and 2.0 mils before coating
- Printing Process: Rotogravure, 4 units; water-based organic pigments, excellent light stability, Low VOCs
- Coating Process: In-line roll coater, polymerized by Electronic Beam (EB)  
*Coating is a blend of oligomer and monomer acrylate polymers.*
- Packaging: 4 individually wrapped 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 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

## Wrapping Parameters

- Wrapping lines, straight/simple application: Vorwood (with EVA glue)
- Wrapping lines, curved/complex application: Barbaran, Fitz (with PUR hot melt glue)
- Glues: Liquid EVA (PA 310 by H.B. Fuller) PUR hot melt glue (Helmitin, Kleiberit)

## 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 than 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

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