

**TECHNISCHE INFORMATION  
INFORMATION TECHNIQUE**

Siegwerk Switzerland AG  
CH – 3282 BARGEN  
SWITZERLAND

**TECHNICAL INFORMATION  
INFORMAZIONE TECNICA**

Tel. +41 32 391 72 00  
Fax +41 32 392 51 07  
www.siegwerk.com



**SIEGWERK**

Issue: April 2009  
Replaces issue:06/08

- Product name:** **SICURA UV Coldfoil adhesive 71-000159-5** (41-LV-0504)
- Product description:** UV radiate curing cold foil adhesive for in-line foil stamping, radical curing.
- Printing process:** Wet offset printing unit which is equipped with a special lamination unit and following UV curing unit. Procedure is the wet lamination process.
- Substrates:**
- In line Corona-pretreated, orientated polypropylenes with min. 40 mN/m surface tension
  - In line Corona-pretreated, coextruded polypropylenes with min. 40 mN/m surface tension
  - Lacquered/primered polypropylenes (label material)
  - Selected acryl lacquered polypropylenes
- Further printing substrates after technical evaluation. At stamping on absorbent materials, it must be considered that due to increased applied quantity of adhesive, details can get lost at fine drawings while compensating the absorption rate.
- Stamping foil:** - gold and silver cold stamping foils especially recommended for the cold stamping process by the foil manufacturers.
- Dampening water quality:** - In general the common acidly adjusted fountain solution additives for UV Offset are suitable. In case of hard tap water a reverse osmoses unit is recommended. Once in a while isopropanol has to be added to the fountain water. For more detailed questions please contact the manufacturers of fountain solution additives.

***To observe:***

- *New material qualities must be checked before production print for processing suitability with the designated laminating adhesive printing inks combination, even if the suitability has been made sure on a comparable type of the same printing substrate group.*
- *The test compounds have to be checked after effected die-cutting (particularly at the edges), on liability and if necessary on resistance against order-specific requirements. Due to possible different material shrinking and other changes, these checks must be repeated at the earliest after one day..*
- *At every new order on well known material, but with new ink- and printing combinations, the above mentioned examinations must also be taken.*

*Please consult in cases of doubt our technique on time.*

Properties: - Pasty lacquer with high viscosity, runability similar to UV offset (coloured) printing inks

Remarks - *The application weight of this laminating adhesive is approx. 1.5 g/m<sup>2</sup> depending on printing stock surface and stamping design.*  
- *The power of the UV lamp should not be under 160 W/cm.*

Shelf life: This product has under normal conditions a shelf life of **at least 9 months**. Within this period the product is usable in conformity with the indications of this data sheet. Normal conditions mean:  
- storage in firmly closed, not yet tapped containers  
- temperatures not exceeding 20°C for weeks or 25°C for days  
The shelf life can be extended by cool storage below 15°C.

## HSE

### Product Safety

Intended Use

Food Packaging:

no

Compliance Management

Only intended for food packaging if the processing conditions rule out the possibility of set-off in the reel or stack and the design of the final printed article ensures reliable functional barrier properties to migration. The "Customer Guidance: Printing Inks for Food Packaging", in Appendix 2 "the Selection of the Ink Product" <http://www.siegwerk.com/en/customer-segments/sheetfed-uv/service.html> has to be observed.

Because of the differences in materials for printing, processing conditions and test criteria this Technical Information can only be of advisory character.

Our data reflect the latest state of our knowledge and are based on the characteristics established in the laboratory and on practical experience.

Your own tests with the original materials under the respective conditions are indispensable.

We disclaim any liability for applications for which this product is not foreseen.

RIn/AWe