

## MACal® 8300 PRO

### PRODUCT DESCRIPTION

MACal 8300 PRO are calendered soft vinyl films coated with a permanent acrylic adhesive.

MACal 8300 PRO is designed for trouble-free computer cutting and fast weeding, even for small letters and fine lines.

**Face Material:** Calendered vinyl film, 70 µm thick, cadmium-free.

**Adhesive:** Permanent acrylic adhesive.

**Liner:** Highly stable 135 gsm white kraft paper with Mactac backprinting.

For white vinyls, the liner is coated with a blue silicone coating to improve the contrast with the film colour.

NB : CONTRAST ensures a clear view during the stripping process therefore improving productivity.

### TYPICAL USE

MACal 8300 PRO is a medium term marking film designed for indoor (exhibition, stands) or outdoor applications (Vehicle marking, window graphics, signs, ...)

### PROCESSING

#### Computer cutting

Clean, quick, trouble-free cutting with most plotters. Adjustment of the cutting depth is important : if the cut is too deep this could result in the paper splitting and coming away with the adhesive when the vinyl is transferred to Application Tape.

#### Weeding

Easy and fast weeding even for small letters and fine lines.

#### Application

The transfer of the cut vinyl onto the Application Tape should always be performed by removing the liner from the pressure-sensitive material (i.e. with the PVC face downwards onto the working surface) and not by lifting off the Application Tape.

MACal 8300 PRO can be applied with the dry application method on slightly curved surfaces. On flat surfaces, the dry or the wet application method is suitable.

### Edge sealing and varnishing

Where exposure to chemicals and solvent spillage is likely to occur, edge sealing of decals with a varnish will prevent edge lift. Correct varnishing of decals gives greater protection, and extends the use-life against prolonged effects of weathering, abrasion and other effects such as frequent cleanings.

### Important remark

All surfaces to which the material will be applied must be thoroughly cleaned from dust, grease or any contamination.

The compatibility of paints and lacquers should be tested by the end-user, prior to use.

### SHELF LIFE

2 years when stored at 15 to 25°C and ± 50 % relative humidity (in the original packaging).

### PHYSICAL PROPERTIES (TYPICAL VALUES)

#### Average Values Test Method

Thickness		
Film + Adhesive (µm)	95	ISO 534
Face Material data, 23°C		
Tensile Strength (N/15mm)	>25	DIN ISO 527-3
Elongation at Break (%)	150	DIN ISO 527-3
Adhesive data, 23°C		
Peel adhesion 180° on mirror stainless steel (N/25mm)		
- 20 min. residence	14	FTM 1
- 24 hour residence	18	FTM 1
- 1 week	19	FTM 1
Dimensional stability		
Shrinkage (48hrs at 70°C applied on aluminium)	Max. 0.3mm	FTM14
Temperature ranges		
Application	Min. +10°C	
End-use	-40°C to +70°C	

<b>Flammability</b>		
Sample mounted on aluminium	Self extinguishing	EN 13501-1
<b>Solvent and chemical resistance</b>		
Resistance to most:	Water, water and detergent, alcohols	unaffected
	Oil, gasoline, gasoline-oil	affected (lifting around edges)

## EXPECTED DURABILITY

Central Europe Zone 1

Black & White	5 years	<b>ISO 4892-2</b>
Colours	4 years	<b>ISO 4892-2</b>

Note : Exposure to severe temperatures, ultraviolet light, and/or conditions in Southern European countries, tropical, sub-tropical or desert regions will cause more rapid deterioration. This also applies to polluted areas, high altitudes and south-facing exposure. No durability warranty is given for horizontal exposure.

## DISCLAIMER

For more information on the durability and exposure please visit the “Mactac Technical Bulletin TB 7.5 Outdoor Durability of Mactac Graphics - Self-adhesive films” on the [www.https://www.mactacgraphics.eu](http://www.mactacgraphics.eu) website.

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