

## MACal® 9800 CAST

### PRODUCT DESCRIPTION

MACal 9800 CAST are polymeric stabilized cast vinyl films coated with a durable permanent adhesive giving excellent dimensional stability.

MACal 9800 CAST is designed for computer cutting and fast weeding, even for small letters and fine lines.

**Face Material:** Polymeric stabilized cast vinyl, 66 µm thick, cadmium-free. MACal 9800 CAST SL have a white tie-coated face at the back.

**Adhesive:** High quality clear solvent based permanent acrylic adhesive.

**Liner:** Highly stable 135 g/m<sup>2</sup> 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 9800 CAST is designed for long term interior and exterior marking applications (vehicle marking, window graphics, signs...). MACal 9800 CAST provides ideal conformability over

flat to curved surfaces with rivets and simple corrugations. MACal 9800 CAST SL are intense, vibrant colours for eye-catching markings.

### COLOR MATCHING

Customer colour matching service is provided by MACtac. This colour matches can be requested from a minimum quantity of 10 rolls (500 lm).

### 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.

MACal 9868-100 Cast Silver requires special attention when converting, small letters (<2cm) are not recommended.

### Application

For matt products: we recommend the use of a high tack application tape in order to ensure a good transfer of all letters (for example MACTransfer 100 High grade). 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 9800 CAST can be applied with the dry application method on curved surfaces. On flat surfaces the dry or the wet application method is suitable.

### Edge sealing

Where exposure to chemicals and solvent spillage is likely to occur, edge sealing of decals with a varnish will prevent edge lift.

### 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.

### PHYSICAL PROPERTIES (TYPICAL VALUES)

#### Average Values Test Method

Thickness			
Film + Adhesive (µm)	9800 Cast - 95	-	ISO 534
	9800 Cast SL - 100		
Face Material data, 23°C			
Tensile Strength (N/15mm)	> 24		DIN ISO 527-3
Elongation at Break (%)	> 150		DIN ISO 527-3
Excluding Metallic colours and colour matching			

<b>Adhesive data, 23°C (N/25 mm)</b>		
Peel adhesion 180° on mirror stainless steel		
- 20 min. residence	11	FTM1
- 24 hours residence	13	FTM1
- 1 week residence	13	FTM1
<b>Dimensional stability</b>		
Shrinkage (1 week at 70°C applied on Aluminium)		
MACal 9800 Cast	Max. 0.2mm	FTM14
MACal 9800Cast SL	Max. 0.5mm	FTM14
<b>Temperature ranges</b>		
Application (°C)	+8	Minimum
End-use (°C)	-40 to +90	
<b>Solvent and chemical resistance</b>		
Resistance to most:	oils and grease, fuel, aliphatic solvents, weak acids, salts and alkalis	

**EXPECTED DURABILITY**

Central Europe (Zone 1)

Black & white	10 years	ISO 4892-2
Colours	8 years	ISO 4892-2
Metallics	5 years	ISO 4892-2

*Note : Exposure to severe temperatures and ultraviolet light, as well as conditions in southern European countries, and also in tropical, sub-tropical or desert regions, will cause a more rapid deterioration. This also applies to polluted areas, high altitude, horizontal and south-facing exposure.*

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