



ISO 9001 Certified  
The Chemistry of Customer Attention

**Adhesives and Coatings Company**  
80 Wheeler Point Road Newark, NJ 07105  
TEL: (973) 344-1483 FAX: (973) 344-4767  
<http://www.craigadhesives.com>

## **A Brief Guideline for Cure Through Cold Foiling**

---

- ❖ **Use smooth non-absorbent substrates for best results**
- ❖ **Use cold foil specially designed for wet lamination or curing through the foil. Other foils will not allow UV light to penetrate to cure adhesive. These can be found through the following companies.**
  - **AMagic** <http://www.amagicfoils.com/>
  - **Kurz** <http://www.kurzusa.com/>
  - **API** <http://www.apigroup.com/>
- ❖ **Use 1034CFAB (blue tinted) or 1034CFAC for film substrates.**
- ❖ **Clean anilox, plates, nip rollers thoroughly to prevent voids, fish eyes, and other blemishes.**
- ❖ **If using paper, use 1034CFAH, which is higher in viscosity to aid in preventing absorption.**
- ❖ **Paper should be coated, matte, super-calendared, etc.**
  - **Please be aware that even these papers have varying levels of absorption even among the same type and supplier.**
  - **Absorbent substrates such as offset, kraft, etc. papers should be avoided as desired results may not be able to be achieved.**
- ❖ **Foil unwind speed should be the same as web speed.**

The information contained herein is to the best of our knowledge true and correct and any suggestions are made without guarantee, express or implied, since the conditions of use are beyond our control. *Craig Adhesives & Coatings* disclaims any liability incurred in connection with the use of these data or suggestions. Nothing contained herein shall be construed as a recommendation to infringe on any existing patents covering any material or its use.

- ❖ **Use in a laminating station.**
  - **Make sure foil is brought in at a 45 degree angle or greater.**
  - **Use 90 durometer or greater nip roller after print station.**
- ❖ **Keep flat and cure as soon as possible after nipping**
- ❖ **Do not strip foil at bottom roller or the foil may “bunch up” at the idler roller.**

**This list only highlights the parameters that are involved when working with this application. If further information is needed, please feel free to contact Craig Adhesives and Coatings.**