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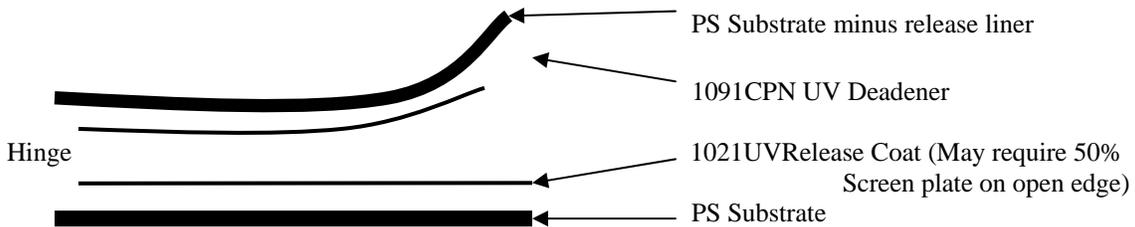
## Adhesives and Coatings

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### Coupon or Booklet Construction--Two Pressure Sensitive Substrates



- 1- Print
- 2- Apply 1021 UV Release Coating using a 2-4 bcm anilox on printed pressure sensitive substrate and cure
  - If Booklet construction, leave one edge uncoated to create a hinge
- 3- Apply 1091CPN UV Deadener using a 6-10 bcm anilox onto 1021 and cure
  - Leave hinge edge uncoated
  - Leave seal/re-seal edge either partially or completely uncoated depending on desired effect
- 4- If desired, reverse print onto 1091CPN
- 5- Bring in second pressure sensitive substrate with release liner stripped and join to bottom layer.

When peeled apart, the 1021 and 1091CPN will split leaving a protective UV coating on both sides.

**Caution: Age finished product at 120°degrees Fahrenheit for 24 hours, then re-evaluate for desired properties.**

If product does not perform as desired, please consult troubleshooting guide on page 2 or call your Technical representative or Shannon Cook at (910) 352-2289.

# **Troubleshooting Guide**

## **For Coupon/Booklet Construction – 2 PS substrates**

- 1. Reverse print not good—Try the following in order. These all ensure proper flow and coverage of 1091CPN over 1021.**
  - a. Make sure 1091CPN was applied with a higher volume anilox than 1021.
  - b. Increase amount of 1091CPN
  - c. Decrease amount of 1021
  - d. Decrease lamp power on 1021
  - e. Add flow additive A1905A in 3% increments (maximum of 9%) to 1091CPN to increase imprintability.
- 2. Hinge is not aggressive enough.**
  - a. Make sure 1021 and 1091 were not printed in this area.
  - b. Try a different pressure sensitive substrate with a more aggressive adhesive.
  - c. Widen the hinge area.
- 3. Re-seal is not aggressive enough.**
  - a. Apply a screen pattern on open edge. 50% is typical, but others may be experimented with to achieve desired results.
  - b. Try a tighter release version of 1021, such as 1021TR. This is only recommended as a last resort due to potential for “lock up” with some adhesives. Please age finished product at 120°degrees Fahrenheit for 24 hours, then re-evaluate for desired properties.
- 4. When peeled apart, it is still tacky where deadener was applied.**
  - a. Check nip pressure. Increase if necessary.
  - b. Increase the amount of 1091CPN—This usually solves this problem.
  - c. Ensure that 1091CPN is cured properly—This is typically not the problem, but it is a possibility.
  - d. Use a more aggressive adhesive.
- 5. Construction will not peel apart.**
  - a. Make sure that all products are applied in proper sequence. See diagram above.
  - b. Ensure that 1021 is properly cured.
  - c. If using 1021TR, switch to an easier releasing version such as 1021C or 1021DF.