

Practical Information

Production Procedures for Solvent, Eco-Solvent Digitally Printed Graphics



Storage and Processing Conditions

The self-adhesive products ORACAL®, ORAJET®, ORAGUARD®, ORABOND®, ORALITE®, and ORAMOUNT® are supplied in rolls and should at all times be stored either suspended or standing on end on the roll blocks provided. Never store them horizontally on the material side. For storage and processing, they should be kept in a cool, dry place protected from sunlight. Relative air humidity between 50% and 60% and temperature between +64°F and 72°F should be ensured. Direct sunlight, storage beside radiators, etc. should be avoided. Please observe the shelf life instructions contained in the technical data sheet available for each film at www.oracal.com.

Printing the Graphic

Digital printing materials should be handled with a high degree of care. Lint-free gloves should be used to prevent surface damage. Check surface quality before printing. **Be sure to load the correct media profile for your job, based on your specific combination of media, ink, printer, and RIP software. Each series of ORAJET® digital media requires different print and RIP software parameter settings because of its individual qualities.** Check the [Support section](#) of the [ORACAL website](#) for a wide selection of FREE color profiles.

Laminating the Printed Graphic

Why Laminate?

Lamination of inkjet prints is recommended to ensure longer lifespan at optimum quality (gloss, color, physical damage). ORAGUARD® laminate films enhance the desired appearance of the graphic (gloss, semi-gloss, matte). They also provide excellent protection against fading from exposure to UV rays.

Outgas Procedures

ORACAL® recommends allowing printed films at least 24 hours at 70°F to dry (outgas) before applying a laminate to avoid delaminating or adhesive failure (48-72 hours preferred). Note the following considerations:

- 24 hours of dry (outgas) time should be considered the minimum before applying lamination. (Prints with very little ink coverage would fall into this category.)
- If the print is heavy in ink saturation, (darker, rather than lighter) a longer outgas time of 48-72 hours is preferred for the print to dry before lamination.

Troubleshooting Trimmed/Plotted Printed Graphics

Why is my printed graphic edge curling and shrinking?

Graphics that are trimmed or plotted directly through the ink within 24 hours after printing can begin to show signs of curling or shrinking around the perimeter once applied to the substrate.

Why does this occur?

The freshly printed (uncured) solvents used in the inks to print the graphic are migrating around the cut line and irritating the perimeter of the adhesive layer. This in turn causes the edges of the material to curl up or shrink either on the release liner or once applied to the substrate.

What should I do to reduce the risk of edge curling?

In a well-ventilated area away from the print room, stand the roll on end and loosely unwind the material from around the core. There should be adequate space between each wrap around the core for air to properly circulate. This will allow the solvent gasses to properly escape from the graphic.

DO NOT leave the graphic rolled up tightly around the core after printing. This will cause the solvent gasses in the inks to be trapped and potentially migrate to the adhesive layer of the material, resulting in poor adhesion properties once applied to the intended substrate.

It is a good idea to allow a minimum of 24 hours at 70°F (48-72 hours preferred) for the inks to dry (outgas) before trimming or plotting through the ink.

For questions not covered in this bulletin, please contact Oracal Product Technical Support at 1-888-672-2251, ext.168 or 176, or email techsupport@oracal.com.

General Information

This information is based on our knowledge and experience. We have not explained all aspects of application. Specialized or occupational knowledge and competence of a professional sign maker are presupposed. Because of the diversity of potential influencing factors during application and use, we recommend customers test our products when the films will be used for special applications. No legally binding warranty of certain qualities can be derived from our information.

Oracal USA, Inc.
1100 Oracal Parkway
Black Creek, GA 31308
www.oracal.com