

Hot-Stamping KYDEX® Thermoplastic Sheet

TB - 151-C

General Information

Hot-stamping is a good alternative to silk screening or screen printing. The Hot-stamping process can be used to imprint an image on to the KYDEX® sheet or to imprint and “inked” image onto the material. Unlike other plastics, there should be no cracking or chipping when working with KYDEX® sheet.

The finished appearance of the imprint depends on three factors: force, temperature, and time. Material gauge does not effect the imprinted results. Most stamping machines are operated by hand, and therefore, force is difficult to measure and control. Temperature is easier to measure and adjust. KYDEX® sheet can be imprinted in the temperature range of 121 to 177°C (250 to 350°F). At the lower temperatures: 121 to 135°C (250 to 275°F), heavy force for 5-8 seconds will result in a satisfactory imprint. At higher temperatures, use light force for only 1-2 seconds.

Optimum settings: 149°C (300°F), moderate force, 2 seconds.

Allow for variation among hot-stamping machines; it is best to experiment on a sample before stamping the final product. If you do not have a sample of KYDEX® sheet, you can practice on paper if you are stamping with ink.

General Guidelines:

- If KYDEX® sheet is sticking to your equipment, lower the temperature. If there is no imprint, increase temperature.
- KYDEX® sheet should not be exposed to temperatures exceeding 204°C (400°F).
- When using a hand-operated machine, do not ‘jerk’ handle down. Bring the handle down until it touches the surface of the KYDEX® sheet, then do a quick and firm press.
- KYDEX® sheet should be imprinted on its secondary surface, or on a ‘smoother’ pattern for best visual results.

SEKISUI SPI

ISO 9001 and 14001 Certified

Customer Service

6685 Low St, Bloomsburg, PA 17815 USA

Phone: 800.325.3133, +1.570.389.5810

Outside the US: +1.570.389.5814

Fax: 800.452.0155, +1.570.387.7786

Email: info@sekisui-spi.com

Technical Service

Phone: 800.682.8758

Fax: +1.570.387.8722

Outside the US: +1.570.387.6997

techservice@sekisui-spi.com

sekisui-spi.com

Because we cannot anticipate or control the many different conditions under which this information and our products may be used, we do not guarantee the applicability of the accuracy of this information or the suitability of our products in any given situation. Users should conduct their own tests to determine the suitability of each product for their particular purposes. Data in the physical property table represents typical values and are to serve only as a guide for engineering design. Results are obtained from specimens under ideal laboratory conditions. Right to change physical properties as a result of technical progress is reserved. THE PRODUCTS DISCUSSED ARE SOLD WITHOUT WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE, EITHER EXPRESSED OR IMPLIED, EXCEPT AS PROVIDED IN OUR STANDARD TERMS AND CONDITIONS OF SALE. Buyer assumes all responsibility for loss or damage arising from the handling and use of our products, whether done in accordance with directions or not. In no event shall the supplier or the manufacturer be liable for incidental or consequential damages. Also, statements concerning the possible use of our products are not intended as recommendations to use our products in the infringement of any patent. Consult local code and regulatory agencies for specific requirements regarding code compliance, transporting, processing, recycling and disposal of our product. Product not intended for use as a heat resistant surface. Texture, product grade and other conditions may cause variations in appearance.

This information supersedes all previously published data.