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unlimited créations

### HEAT-BURNISHING EFFECT (THERMO)

This kind of printing can easily be achieved on our "LYNEL THERMO" qualities. We recommend using a temperature between 140 and 180°C, with a strong pressure and medium pressuring time.

In our case, we have carried in-house tests on a Heidelberg stamping machine (TA4, 26 x 38, magnesium 70 cliché, Makrolon 0.75 counterpart). We have reached the best results in following conditions :

Temperature 160°C, pressure 30 to 40 tons/cm<sup>2</sup>, 0.3 to 0.6 seconds pressuring time.

### HOT-FOIL STAMPING RECOMMENDATIONS

The key to hot-stamping onto our materials rests above all in the choice of foil. It is therefore desirable to establish and test the appropriate recommendations with your foil supplier.

The general conditions we recommend are as follows :

- Temperature : between 90 and 140°C
- Printing time : approx. 0.5 sec
- Pressure : approx. 200 kg/cm<sup>2</sup>
- Best results are reached when our materials are hot-foiled as supplied, and not after lamination or chemical treatment.

Here are 4 foil references that we tested and for which we found excellent results :

- OG Series by Foilmark, US (ITW Group, more information at [www.itwfoils.com](http://www.itwfoils.com))
- BS 32 GGN by SKC, Korea (newly ITW Group)
- 4001 SG & 4084 SGM by Astor Universal (API Group, more information at [www.apigroup.co.uk](http://www.apigroup.co.uk))
- Luxor or Alufin HC, AS & ASM by Kurz (more information at [www.kurz.de](http://www.kurz.de))
- For pigmented foils, we recommend references COLORIT V900 by Kurz.

Results can be different depending on design to be stamped. According to our trials, the most versatile foil reference is LUXOR HC by Kurz.

Of course, many other references may give similar results, and we would welcome any foil for our testing here, to examine in our laboratories the compatibility of the films you wish to use with our materials.

These recommendations apply to most of our materials, especially our DAINEL, LYNEL & EDO ranges.