



TECHNICAL BULLETIN

Working with PVC Shrink Films

Handling and Storage:

- Store at ambient room temperature of 72 degrees Fahrenheit.
- Do not expose the film to temperatures over 115 Fahrenheit for extended time.
- Store in original plastic sleeve and carton. If no carton, cover with black plastic to avoid yellowing.
- Do not expose to humidity over 65%.

Printer Heater Settings:

Preferred heat settings:

Pre: 36c (97f)

Print: 36c (97f)

Post: 46c (114f)

Cure Time:

- Cure time is very important for the PVC shrink films. Printer manufacturers recommend a 24-hour cure time before handling and processing prints. Because the ink solvent carrier softens the PVC film it is very important to cure it properly.
- If you peel the film from the liner before it is completely cured the images will severely wrinkle as it finishes curing. We recommend an overnight cure time.
- Do not cure on a roll. Separate the prints and allow image exposure to air.

Minimum Cure time for 8507: 4-6 hours

Minimum Cure time for 8514: 4-6 hours

Minimum Cure time for 8527: 6-8 hours

Removing from the liner:

The PVC shrink film is the most difficult product to manufacture that we have. It is a fine balance between holding on to the liner and falling off. Cut shrink images larger than print area. Start the peel in a corner. When peeling, best practice is to peel briskly over itself. Trim to size leaving a narrow strip of clear film on the bottom and a 1-2" clear strip on top. This allows for trimming after shrunk on the container.

Shrink temperature:

Best practice for any shrink film is a hot air tunnel, Steam cabinet or hot water bath.

The films will start shrinking around 170 f. Optimum shrink temperature is 200 f.



Working With Shrink Films

General Information:

1. The PVC shrink films are the most difficult of the medias to achieve a consistent release from the liners. Refer to the “shrink sleeve tips” tech bulletin for getting the film started to release from the liner.
2. All of the shrink films shrink the highest on the width of the rolls, art orientation is very important.
3. The 8507 PVC film is a 60% (approx.) shrink ratio. It is well suited for most applications except high contour shapes and trigger spray bottles.
4. The 8527 PVC film is the same film as 8507 but with a different coating on it and a slightly higher shrink ratio (66%). The 6% extra shrink typically handles higher contour shapes except trigger spray bottles.
5. For very high contour shapes we have a PETG shrink film with a 70%(approx.) shrink ratio. It is more difficult to work with when shrinking. A hot water bath works much better than a heat gun.
6. Any of the PVC shrink films require at least 4-6 hours of curing time for the print to “degas” and properly dry. Ideally overnight.
7. The PETG film can be worked with when the print is dry to the touch.
8. Recommended heater settings: pre: 36c, print: 36c, post 46c.

Seaming:

1. When seaming, never overlap a seam onto printed ink. The printed ink keeps the solvent from bonding the films. It is a good idea to have at least 3-4mm of clear unprinted film on one end of the sleeve to tuck under the other end.
2. The seaming pen tip needs to be very wet before using. On a pc of thick paper push the pen down to depress the plunger tip and allow the solvent to flow into the tip. You can seam when the tip makes a small puddle on the paper.
3. When applying the seaming solution to the film, press the pen down to open the plunger while drawing the seam to allow continuous flow. Otherwise you will start out wet but dry out or not deposit enough by the time you get to the other end.
4. You want to depress the seaming pen plunger tip (#2 above) each time before seaming to flush out dissolved plastic from the pen tip. If the tip becomes clogged with dissolved plastic it will not seam properly and you should replace it.
5. Your other option is to use some sort of “super glue” or cyanoacrylate instant adhesive. One that dispenses drops works best. You place small drops approx. 3-4 mm apart across the seam. When you place the sleeve ends together the drops will flow out and be continuous. Any thing that seeps out can be wiped away. It is important to place a scrap of paper under the seam, so the glue does not stick the seam to the inside of the sleeve.



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Shrinking:

1. For most application you can use a heat gun to shrink onto the bottle. The films start shrink around 170f. 200 f is a good heat setting
2. The PVC films are the most forgiving when shrinking and allow you to touch up irregularities such as “smiles” better than the PETG.
3. Using a hot water bath will give you the fastest and most consistent shrink at 200f.
4. If you make the shrink sleeve as close to the bottle shape as possible and still be able to slide it over the bottle you will maximize the shrink capability. A loose sleeve will waste 3-5% of the sleeves maximum shrink capability taking up air space.
5. For trigger spray bottles, leaving an extra 1-2” over the top will aid in getting the art to final shape. Trim the excess and touch up if needed.

It can be tricky the first few times but once you have done a few the technique becomes more natural.

Shrink Sleeve Seam Sealing & Shrinking Instructions

Tools You Will Need For Assembly

- Cutting Board
- Exacto Knife
- Seam Sealing Pen or Cyanoacrylate Adhesive
- Steel Straight Edge
- Scotch Tape
- Blue Tape

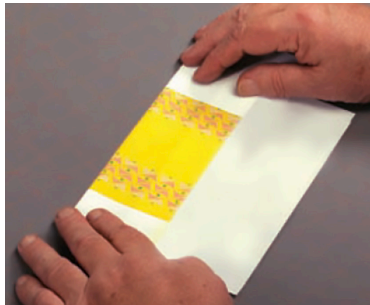
1.

Fold over opposite edge to middle of the shrink sleeve. Be sure edges are parallel.



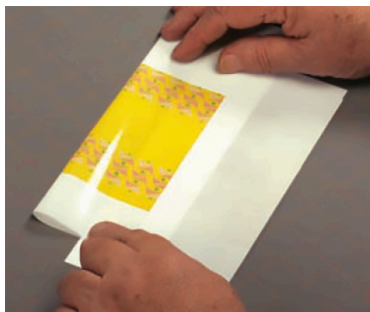
2.

Flatten edge of fold by creasing with finger.



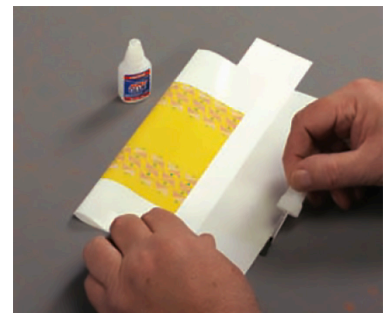
3.

Place a strip of bond paper under edge of seam. This prevents seam adhesive from attaching image.



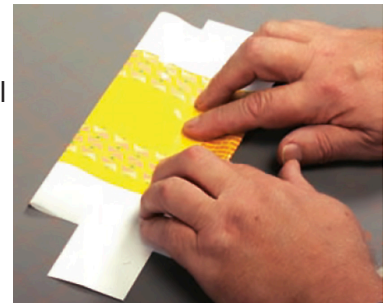
4.

Apply an even amount of Seam Sealing Adhesive to clear area of sleeve.



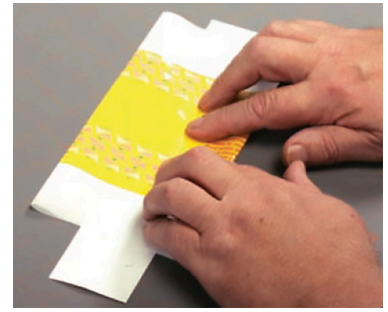
5.

Fold over seam and seal seam. Be sure seam seals by running your finger across seam. Allow a few seconds for the seam to dry.



6.

Trim top and bottom of shrink sleeve.





Shrink Sleeve Seam Sealing & Shrinking Instructions continued

7.

Place the shrink sleeve over the container and shrink by applying even heat with a heat gun or hairdryer. A hot water bath or shrink tunnel will give you the fastest and most consistent shrinking. 200 degrees fahrenheit is a good heat setting.





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JetComp Shrink Sleeve Tips

When the shrink sleeve film seems hard to lift off the carrier sheet.

Sometimes, when you trim out a shrink sleeve, the trimming action itself causes the trimmed edge to “pinch together” with the liner. In this case, you need to slice into the edge of the shrink sleeve film with an Xacto blade As shown below. Once a corner is lifted, the sleeve will readily peel off the liner.

