

# ORACAL® 1668

## Opaque Vinyl

### Short description

White special PVC film with glossy and matt surface and excellent opacity.

### Front material

Soft PVC Film, 0.1 mm

### Liner

One-sided siliconized kraft paper, 137 g/m<sup>2</sup>

### Adhesive

Polyacrylate Black, 0.019 mm

### Technical properties

#### RESISTANCE

|                        |                                                                                                             |                                                           |
|------------------------|-------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------|
| Durability             | with vertical outdoor exposure, normal Central European climate                                             |                                                           |
|                        | 2 Year(s)                                                                                                   |                                                           |
| Shelf Life             | 2 Year(s)                                                                                                   | in original packaging, at 20 °C and 50% relative humidity |
| Maximum shrinkage      | Maximum shrinkage along 0.4 mm<br>Maximum shrinkage across 0 mm                                             | bonded to steel   FINAT TM 14<br>FINAT TM 14              |
| Elongation at break    | Minimum elongation at break along 130 %<br>Minimum elongation at break across 150 %                         | DIN EN ISO 527                                            |
| Tensile strength       | Minimum tensile strength along 19 N/mm <sup>2</sup><br>Minimum tensile strength across 19 N/mm <sup>2</sup> | DIN EN ISO 527                                            |
| Seawater resistance    | no change                                                                                                   | after 100h/35°C   adhered to aluminum, DIN EN ISO 9227    |
| Temperature resistance | Minimum temperature -40 °C<br>Maximum temperature 60 °C                                                     | Short-term exposure up to 80 °C                           |

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### ADHESIVE PROPERTIES

|                |           |                                                            |
|----------------|-----------|------------------------------------------------------------|
| Adhesive power | 6 N/25 mm | after 24 h, on stainless steel   Average value, FINAT TM 1 |
|----------------|-----------|------------------------------------------------------------|

### PROCESSING

|                         |                           |
|-------------------------|---------------------------|
| Application temperature | Minimum temperature 10 °C |
|-------------------------|---------------------------|

### PRODUCT NOTE

After printing, ensure that the inks dry thoroughly so as not to impair the subsequent bond with the laminate. The substrate to be covered must be free of dust, grease or other contaminants that could impair the adhesive strength of the material. New coatings must be dry or fully cured. Application tests must be carried out with the intended paints to determine compatibility.

### IMPORTANT NOTES

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