

Description

ORALITE® retroreflective films series 6700 Engineer Prismatic Grade is a reflective, weatherproof, self-adhesive sheeting with excellent corrosion and solvent resistance. The product was specifically developed for the manufacture of traffic control, guidance, warning and information signs, which are intended for long term vertical outdoor use.

Product Construction

ORALITE® 6700 sheeting consists of sealed cells of air backed microprisms, using total internal reflection. The distinct shape of the sealing identifies the machine direction and the manufacturer of the sheeting, shown in figure 1.

Reflectivity

ORALITE® 6700 meets and/or exceeds the minimum coefficient of retroreflection (R_A) shown in Table 1 when tested in accordance with ASTM E810, "Standard Test Method for Coefficient of Retroreflection of Retroreflective Sheeting Utilizing the Coplanar Geometry". ORALITE® 6700 fully meets and/or exceeds the requirements of ASTM D4956 for Type I.

Daytime Color

ORALITE® 6700 conforms to the daytime color requirements in Table 2 when tested in accordance with ASTM D4956. ORALITE® 6700 is available in white, yellow, orange, green, red, blue, and brown.

Nighttime Color

ORALITE® 6700 conforms to the nighttime color requirements in Table 3 when tested in accordance with ASTM D4956 and ASTM E811. The sheeting shall be measured using CIE Illuminant A, an observation angle of 0.33° and an entrance angle of $+5^\circ$.

Adhesive

The adhesive is protected by a release liner which shall be removed by peeling, without soaking in water or other solvents. The adhesive produces such a bond that a 1" (50 mm) strip shall support a 1 ¼ pound (0.79 kg) weight for 5 minutes without the strip peeling for a distance of more than 2" (50 mm) when applied to a smooth aluminum surface as specified in the ASTM D4956, section 7.5 adhesion test.

Impact Resistance

Following application to a smooth surface aluminum rectangle, 0.040" x 3" x 6" [1.01mm x 75mm x 150mm], the specimen is conditioned for 24 hours at $73^\circ \pm 3^\circ\text{F}$ ($23^\circ \pm 2^\circ\text{C}$) and 50% relative humidity, subject the sheeting to an impact of a 2 lb (0.91 kg) weight with a 5/8" (16 mm) rounded tip dropped from a 10 in-lb (1.13 N-m) setting on a Gardner variable impact tester, IG-1120, as per ASTM D4956, section S2.2.1. The sheeting shall show no cracking or delamination outside the actual area of impact.

Flexibility

The sheeting is conditioned for 24 hours at 72°F [23°C] and 50% relative humidity. The release liner is removed and the sheeting is sufficiently flexible to show no cracking when bent in one second's time around a 1/8-inch [3.2mm] diameter mandrel with the adhesive contacting the mandrel.

Weatherability

ORALITE® 6700 meets the requirements of ASTM D4956, Section 6.4. The material is weather resistant and shows no appreciable cracking, scaling, pitting, blistering, edge lifting, or curling, or more than 1/32" (0.8 mm) shrinkage or expansion. Retroreflectivity measurements are conducted after outdoor weathering with an observation angle of 0.20° and entrance angles of -4° and $+30^\circ$. The minimum coefficient of retroreflection (R_A) after weathering is 80% of the Table 1 values.

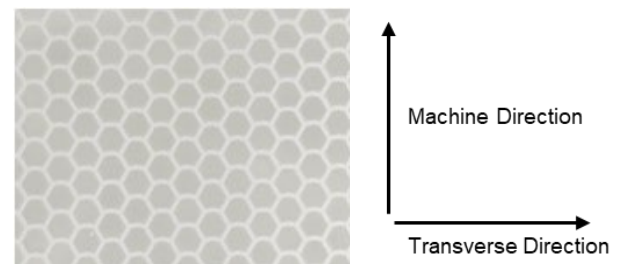
Solvent Resistance

ORALITE® 6700 meets the requirements of LS-300C solvent resistance, section 3.6.7, when tested as specified in Table VI, test method 4.4.6.

Specular Gloss

ORALITE® 6700 shall have a specular gloss of not less than 40 when tested per ASTM D523 at an angle of 85°

Sealing Pattern and Application Directions



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Shrinkage

A 9 inch by 9 inch [229mm by 229mm] specimen of the sheeting with liner is conditioned a minimum of one hour at 72°F [23°C] and 50% relative humidity. The liner is then removed and the specimen is placed on a flat surface with the adhesive side up. Ten minutes after the liner is removed and again after 24 hours, the specimen is measured to determine the amount of dimensional change. The specimen will not shrink in any dimension more than 1/32 inch [0.8mm] in 10 minutes and 1/8 inch [3.2mm] in 24 hours.

Application Instructions

The recommended application temperature to achieve best results is 65°F [18°C] or above.

Warranty

7-year limited warranty

Contact your ORAFOL Americas Inc. representative for details.

Table 1, Coefficient of Retroreflection (R_A)*

Observation Angle	Entrance Angle	White	Yellow	Orange	Green	Red	Blue	Brown
0.20°	-4°	70	50	25	9.0	14	4.0	1
	30°	30	22	7.0	3.5	6.0	1.7	0.3
0.50°	-4°	30	25	13	4.5	7.5	2.0	0.3
	30°	15	13	4.0	2.2	3.0	0.8	0.2

*all values have units of cd/ft² (cd/lx/m²)

Table 2, Color Specification Limits (Daytime)

Color	Chromaticity Coordinates†								Luminance Factor (Y%)	
	1		2		3		4		Min.	Max.
	x	y	x	y	x	y	x	y		
White	0.303	0.300	0.368	0.366	0.340	0.393	0.274	0.329	≥ 27	
Yellow	0.498	0.412	0.557	0.442	0.479	0.520	0.438	0.472	15	45
Orange	0.558	0.352	0.636	0.364	0.570	0.429	0.506	0.404	10	30
Green	0.026	0.399	0.166	0.364	0.286	0.446	0.207	0.771	3.0	12
Red	0.648	0.351	0.735	0.265	0.629	0.281	0.565	0.346	2.5	15
Blue	0.140	0.035	0.244	0.210	0.190	0.255	0.065	0.216	1.0	10
Brown	0.430	0.340	0.610	0.390	0.550	0.450	0.430	0.390	1.0	9.0

†The four pairs of chromaticity coordinates determine the acceptable color in terms of the CIE 1931 Standard Colorimetric System measured with Standard Illuminant D65.

Table 3, Color Specification Limits (Nighttime)

Color	Chromaticity Coordinates‡							
	1		2		3		4	
	x	y	x	y	x	y	x	y
White	0.475	0.452	0.360	0.415	0.392	0.370	0.515	0.409
Yellow	0.513	0.487	0.500	0.470	0.545	0.425	0.572	0.425
Orange	0.595	0.405	0.565	0.405	0.613	0.355	0.643	0.355
Green	0.007	0.570	0.200	0.500	0.322	0.590	0.193	0.782
Red	0.650	0.348	0.620	0.348	0.712	0.255	0.735	0.265
Blue	0.033	0.370	0.180	0.370	0.230	0.240	0.091	0.133
Brown	0.595	0.405	0.540	0.405	0.570	0.365	0.643	0.355

‡ The four pairs of chromaticity coordinates determine the acceptable color in terms of the CIE 1931 Standard Colorimetric System measured with Standard Illuminant A.



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Note:

All ORALITE® products are manufactured within an ISO 9001:2015 controlled manufacturing environment and batch traceability is possible on the basis of the roll number.

IMPORTANT NOTICE

When using ORALITE® sheeting, please comply with relevant national specifications. ORAFOL® recommends obtaining the current requirements from your local authority and ensure product conformance with such requirements. Please contact ORAFOL® for further information.

All ORALITE® products are subject to careful quality control throughout the manufacturing process and are warranted to be of merchantable quality and free from manufacturing defects. Published information concerning ORALITE® products is based upon research which the Company believes to be reliable, although, such information does not constitute a warranty. Because of the variety of uses of ORALITE® products and the continuing development of new applications, the purchaser should carefully consider the suitability and performance of the product for each intended use, and the purchaser shall assume all risks regarding such use. All specifications are subject to change without prior notice.

Surfaces to which the material will be applied must be thoroughly cleaned from dust, grease or any contamination which could affect the adhesion of the material. Freshly lacquered or painted surfaces should be allowed to dry for at least three weeks and to completely cure respectively. The compatibility of selected lacquers and paints should be tested by the user, prior to application of the material. The self-adhesive reflective material can only be used for dry application. The low tensile strength of the material can make the removability of the reflective film more difficult. Please review applicable application information published by ORAFOL®.

No warranty is given for purposes other than those listed in the Technical Datasheet or which are not processed according to ORAFOL's processing and handling instructions. The durability of the signs will depend on a variety of factors, including but not limited to substrate selection and preparation, compliance with recommended application guidelines, geographic area, exposure conditions and maintenance of the product and finished sign. Sign failures caused by the substrate or improper surface preparations are not the responsibility of ORAFOL®. Please refer to the full warranty document available at www.orafol.com for detailed information.



WARNING – This product can expose you to chemicals which are known in the State of California to cause cancer and birth defects or other reproductive harm. For more information, go to – www.P65Warnings.ca.gov

ORALITE® is a trademark of ORAFOL Europe GmbH



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