



# Melinex® polyester film

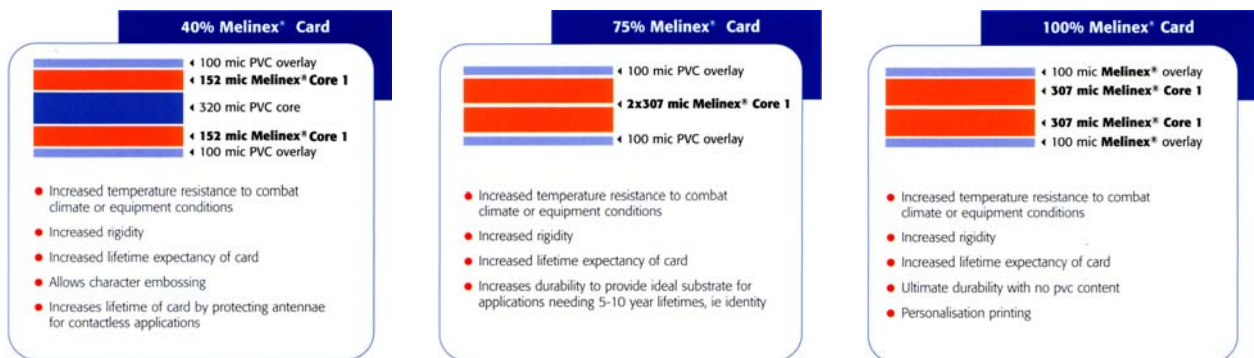
## Melinex® CORE & Protect Film Range Recommended Lamination Conditions

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### Background

Melinex® PETF offers an ideal solution whatever the requirements of the issuer. It can be incorporated into the card structure in a variety of ways to give the card the required physical properties and performance. Due to its compatibility with PETG and PVC it is possible to optimise cost versus performance by incorporating Melinex® PETF into the card in a variety of ways. 100% Melinex® PETF cards can be reserved for applications where ultimate performance is required:

Example card structures are illustrated below, PETG can be used as an alternative to PVC as appropriate:



### Suggested Lamination Conditions

Melinex® PETF has been designed to work in the standard PVC batch lamination process with only slight modifications to PVC conditions. The heatseal layer is activated at temperatures around 120 degC and a temperature range of up to 170 degC is possible without distortion of the laminated card.

Recommended lamination conditions as follows:

**HOT PRESS**                      140 degC to 150 degC for approx 20 minutes (150 – 200 psi on the actual sheet)\*

**COLD PRESS**                      Cool as PVC but at higher pressures (250 – 300 psi on the actual sheet)\*

*\* This refers to the pressure the laminate experiences, not the air pressure in the ram of the lamination equipment*

There are many different overlay suppliers and specifications, for details on recommended overlays and inks compatible with the range of Melinex® polyester films please contact our Technical Support Centre.