

Avery[®] Technical Bulletin 1.05

Procedures for Polycarbonate (Lexan[®]) Preparation

Purpose

Polycarbonate (Lexan[®]) absorbs moisture, hence, needs to be thermally treated in an air circulating oven to ensure all gasses and or water vapour has been removed prior to pressure sensitive decal application. Decals applied over non-treated polycarbonate create a barrier for evaporating vapours and can result in bubbling and adhesion loss of such pressure sensitive decals.

Polycarbonate Caliper	Duration of Exposure	Temperature Setting
0.23 cm	4 hours	121°C
0.32 cm	4 hours	121°C
0.38 cm	8 hours	121°C
0.47 cm	12 hours	121°C
0.64 cm	24 hours	121°C

Place the polycarbonate sheeting vertically in an air-circulating oven at 121°C that provides a minimum separation between sheeting of 2.5cm.

After the conditioning as stated above, the polycarbonate sheeting can be applied with pressure sensitive film stock for up to 12 hours without re-conditioning in a 50 ±5% RH and 23 ±2°C environment.

For further information, contact your local Avery Graphics representative.