



## Dragon Foils Limited

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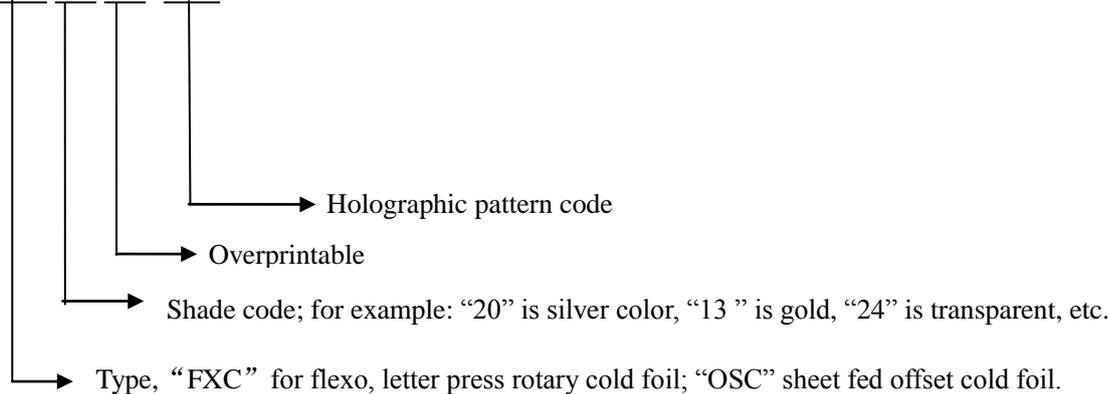
# Flexo Cold Foils Technical Data Sheet (FXC Series)

## 1. Main Characteristics:

- Can be used for regular labels, shrink-sleeves labels, in-mold labels (IML) and plastic tubes material in roll.
- High gloss, smooth transfer.
- Good adhesion to various substrates like coated paper, PE, PP, PET etc.
- Overprintable with strong ink adhesion.
- Suitable for applications from fine lines and large areas.
- Good release property, pin-hole free.

## 2. Product Code:

FXC 20 /OP -01D



## 3. Printing Machine

- Flexo: Mark Andy, Omet, Nilpeter, Gallus, Gidue, Weigang, ETI, etc.
- Letter press: Labelman, Taiyo, Label Long, Label Source, Shengan etc.

## 4. Adhesive

- Flexo: Flint Xsys UVH00007 ; Zeller U0821 ; Supercolor UVLT00271.
- Letterpress: Toka VP varnish; UV161 varnish; Supercolor UV 001, etc.

## 5. Anilox Roll

Anilox adjustment is needed according to the size of the cold foiling pattern, absorption of the substrates, specific machine and the actual running job.

Please find some recommendations as below, and some adjustments are still needed based on specific jobs.



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Substrate	Solid area stamping	Solid area & fine details stamping	Fine details stamping
PE	300-500Lines/Inch ( 120-200 Lines/cm)  5.69-3.31BCM	500-650Lines/Inch(200-250 Lines/cm)  3.31-2.34BCM	600-800Lines/Inch (240-310 Lines/cm)  2.66-1.96BCM
BOPP	260-440Lines/Inch (100-170 Lines/cm)  6.8-3.74BCM	400-550Lines/Inch (150-220 Lines/cm)  4.1-3.01BCM	500-660Lines/Inch(200-260 Lines/cm)  3.31-2.34BCM
Coated Paper	120-300Lines/Inch (50-120 Lines/cm)  15.66-5.69BCM	300-440Lines/Inch (120-170 Lines/cm)  5.69-3.74BCM	400-550Lines/Inch (160-220 Lines/cm)  4.1-3.01BCM

For the letterpress machine, the adhesive quantity should be adjusted according to the definition and requirement of the pattern.

### 6. UV Lamp Requirement

- Printing speed is 40-60m/min for gold and silver, 20-30m/min for color cold foil; UV lamp power density should be 180-200W/cm
- Recommended capacity is 7 KW
- Halogen lamp is preferred.

### 7. Important Notes

- Surface tension of filmy substrates above 38 Dyne is recommended. Corona treatment or a primer is recommended before cold foiling if surface tension is low, such as in substrate like PP/PET.
- For uncoated and semi-coated papers a primer is recommended before cold foiling to achieve an ideal foiling result.
- 65~70 Shore A photopolymer plate is recommended.
- Recommended hardness of the pressure roll is around 90 Shore A. Try to reduce the pressure when the cold foiling results are good.
- The distance between the laminating and the UV curing unit should be less than 1 meter to avoid the separation of the cold foil and the substrate before curing.
- Adjust the foil's tension, too high or low tension will lead to wrinkles & creasing.
- Adjust the stripping angle; generally, the steep stripping angle can improve the property of



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definition.

- Cold foiling speed:  
Gold and silver: 50-70m/min for the flexo, 40-60m/min for the letter press. In good condition, speed can reach more than 80m/min.  
Color cold foil: 20-30m/min for the flexo, 15-30m/min for the letter press. In good condition, speed can reach 40m/min.
- Use the product within one year after shipped on board date.
- Keep the product in its original package and away from high temperature, high humidity and sunlight exposure.
- Highest temperature for storage is 35°C and humidity 60%.
- Highest temperature for transport is 50°C.
- Jumbo rolls should be suspended horizontally and avoid direct contact with the ground or other items.

The above technical information is the best experience we have so far, necessary adjustments are needed according to an actual run. Please make enough necessary tests on different machines, substrates, adhesives, patterns before large volume production run.