

## MACal® 8300 PRO

### PRODUCT DESCRIPTION

MACal 8300 PRO is a calendered soft vinyl film coated with a permanent acrylic adhesive.

MACal 8300 PRO is designed for trouble-free computer cutting and fast weeding, even for small letters and fine lines.

#### Face material:

Calendered vinyl film, 70 µm thick, cadmium-free.

#### Adhesive:

Permanent acrylic adhesive.

#### Liner:

Highly stable 135 gsm white kraft paper with orange backprinting.

For white vinyls the liner is coated with a blue silicone coating to improve the contrast with the film colour. This added contrast ensures a clear view during the weeding process therefore improving productivity.

### TYPICAL USE

MACal 8300 PRO is a medium term marking film designed for indoor (exhibition stands) or outdoor applications (vehicle marking, window graphics, and general signage).

### PROCESSING

Clean, quick, trouble-free cutting with most plotters. Adjustment of the cutting depth is important: if the cut is too deep this could result in the paper splitting and coming away with the adhesive when the vinyl is transferred to Application Tape.

For matt products: we recommend the use of a high tack application tape in order to ensure a good transfer of all letters. The transfer of the cut vinyl onto the Application Tape should always be performed by removing the liner from the pressure-sensitive material (i.e. with the PVC face downwards onto the working surface) and not by lifting off the Application Tape.

MACal 8300 Pro can be applied with the dry application method on curved surfaces. On flat surfaces the dry or the wet application method is suitable.

### SHELF LIFE

2 years when stored at 15 to 25°C and 50 % relative humidity.

### APPLICATION METHOD

MACal 8300 Pro must be applied following the instructions in the Signage Films section of the Technical Bulletins page called "Marking films: application guide", available from the resource section at: [www.mactacgraphics.eu](http://www.mactacgraphics.eu)

To ensure application suitability, always test the proposed construction under actual application and end-use conditions before going into full production.

### PHYSICAL PROPERTIES (TYPICAL VALUES)

#### Thickness (mm)

Film + Adhesive	0.095	ISO 534
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#### Face Material Data, 23°C

Tensile Strength	> 23 N/15mm	DIN ISO 527-3
Elongation at break	≥ 150 %	DIN ISO 527-3

#### Adhesive data, 23°C (N/25 mm), brushed stainless steel

Peel 20 min	14	FTM 1
Peel 24 hours	18	FTM 1
Peel 1 week	19	FTM 1

#### Dimensional stability

Shrinkage (48 hours at 70°C)	< 0.3 mm	FTM 14
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#### Temperature ranges

Minimum application temperature	+ 10°C to + 40°C
Service temperature range	- 40°C to + 70°C

#### Flammability

Applied to aluminium	Self-extinguishing	ISO 3795
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#### Solvent and chemical resistance

Resistant to most oils and grease, fuel, aliphatic solvents, weak acids, salts and alkalis.

### EXPECTED DURABILITY\*

Central Europe Zone 1

Black and White	5 years	ISO 4892-2.
Colours	4 years	ISO 4892-2.

\*For more information, refer to "Mactac Warranty Bulletin - Expected Durability of Mactac Graphics Films".

Note: Exposure to severe temperatures, ultraviolet light, and/or conditions in Southern European countries, tropical, sub-tropical or desert regions will cause more rapid deterioration. This also applies to polluted areas, high altitudes and south-facing exposure. No durability warranty is given for horizontal exposure.

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