



## European Technical Approval ETA-13/0248

English translation prepared by DIBt - Original version in German language

Handelsbezeichnung  
*Trade name*

ORALITE 6910 Brilliant Grade lasierend bedruckt mit ORALITE 5018  
Screen Printing Ink  
*ORALITE 6910 Brilliant Grade screen printed with ORALITE 5018  
Screen Printing Ink*

Zulassungsinhaber  
*Holder of approval*

ORAFOL Europe GmbH  
Orafolstraße 2  
16515 Oranienburg  
DEUTSCHLAND

Zulassungsgegenstand  
und Verwendungszweck  
*Generic type and use  
of construction product*

Mikroprismatisches retroreflektierendes Folienmaterial  
*Microprismatic Retro-reflective Sheetting*

Geltungsdauer:  
*Validity:* vom  
*from*  
bis  
*to*

17 May 2013  
17 May 2018

Herstellwerk  
*Manufacturing plant*

Orafol Europe GmbH  
Orafolstraße 2  
16515 Oranienburg  
Deutschland

Diese Zulassung umfasst  
*This Approval contains*

14 Seiten  
*14 pages*

## I LEGAL BASES AND GENERAL CONDITIONS

- 1 This European technical approval is issued by Deutsches Institut für Bautechnik in accordance with:
  - Council Directive 89/106/EEC of 21 December 1988 on the approximation of laws, regulations and administrative provisions of Member States relating to construction products<sup>1</sup>, modified by Council Directive 93/68/EEC<sup>2</sup> and Regulation (EC) N° 1882/2003 of the European Parliament and of the Council<sup>3</sup>;
  - *Gesetz über das In-Verkehr-Bringen von und den freien Warenverkehr mit Bauprodukten zur Umsetzung der Richtlinie 89/106/EWG des Rates vom 21. Dezember 1988 zur Angleichung der Rechts- und Verwaltungsvorschriften der Mitgliedstaaten über Bauprodukte und anderer Rechtsakte der Europäischen Gemeinschaften (Bauproduktengesetz - BauPG) vom 28. April 1998<sup>4</sup>, as amended by Article 2 of the law of 8 November 2011<sup>5</sup>;*
  - Common Procedural Rules for Requesting, Preparing and the Granting of European technical approvals set out in the Annex to Commission Decision 94/23/EC<sup>6</sup>.
- 2 Deutsches Institut für Bautechnik is authorized to check whether the provisions of this European technical approval are met. Checking may take place in the manufacturing plant. Nevertheless, the responsibility for the conformity of the products to the European technical approval and for their fitness for the intended use remains with the holder of the European technical approval.
- 3 This European technical approval is not to be transferred to manufacturers or agents of manufacturers other than those indicated on page 1, or manufacturing plants other than those indicated on page 1 of this European technical approval.
- 4 This European technical approval may be withdrawn by Deutsches Institut für Bautechnik, in particular pursuant to information by the Commission according to Article 5(1) of Council Directive 89/106/EEC.
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- 6 The European technical approval is issued by the approval body in its official language. This version corresponds fully to the version circulated within EOTA. Translations into other languages have to be designated as such.

<sup>1</sup> Official Journal of the European Communities L 40, 11 February 1989, p. 12  
<sup>2</sup> Official Journal of the European Communities L 220, 30 August 1993, p. 1  
<sup>3</sup> Official Journal of the European Union L 284, 31 October 2003, p. 25  
<sup>4</sup> *Bundesgesetzblatt Teil I 1998*, p. 812  
<sup>5</sup> *Bundesgesetzblatt Teil I 2011*, p. 2178  
<sup>6</sup> Official Journal of the European Communities L 17, 20 January 1994, p. 34

## II SPECIFIC CONDITIONS OF THE EUROPEAN TECHNICAL APPROVAL

### 1 Definition of the product and intended use

#### 1.1 Definition of the construction product

The product consists of a retro-reflective sheeting on the basis of microprisms, which consist of optical elements, where the retro-reflection is created by total internal reflection on prisms. The microprisms are moulded in a transparent polymer enclosed in air capsules and provided with an adhesive, which can connect the sheeting with a substrate. The sheeting has a smooth surface and a regular structure visible on the surface forming the air capsules and serving to identify the orientation.

The product is delivered as reflective sheeting, the types of which are stated in Table 1.

Trade name	Component	Colour/code		Properties
ORALITE 6910 Brilliant Grade	Self-adhesive retro-reflective sheeting on the basis of microprisms	White	6910-010	Sheeting thickness (without protective paper and adhesive): 0.23 mm  Roll measurements: 1.22 m x 50 m, or customized dimensions
ORALITE 5018 Screen Printing Ink	Glazing screen printing ink	Yellow	5018-020	Fast-curing solvent- containing single component system  Consumption: approx. 800 ml / 55 m <sup>2</sup> , closed surface
		Red	5018-030	
		Blue	5018-050	
		Green	5018-060	
		Orange	5018-035	
		Brown	5018-080	

Table 1 "ORALITE 6910 Brilliant Grade screen printed with ORALITE 5018 Screen Printing Ink" reflective sheeting types

#### 1.2 Intended use

The construction product described here is used to manufacture signal aspects of fixed, vertical traffic signs (see also EN 12899-1). The further intended applications are all other traffic signs and traffic installations, route guidance with retro-reflective elements and variable message signs.

However, the intended application excludes the manufacture of road marking elements according to EN 1436. The intended sign support material is aluminium.

Within the framework of this approval the following product properties were assessed in consultation with the manufacturer:

- Chromaticity coordinates and luminance factor
- Coefficient of retro-reflection (Case A)
- Impact resistance
- Durability:                    Visibility after artificial weathering

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The provisions made in this European technical approval are based on an assumed intended working life of the reflective sheeting of 10 years, provided that the conditions laid down in sections 4.1, 4.2, and 5.1 as well as in the related product data sheets for the manufacture, packaging, transport and storage are met. The indications given on the working life cannot be interpreted as a guarantee given by the manufacturer, but are to be regarded only as a means for choosing the right products in relation to the expected economically reasonable working life of the works.

**2 Characteristics of the product and methods of verification****2.1 General**

The identification of the product and the judgement of the qualification for the intended use of the reflective sheeting were performed on the basis of the assessment procedures agreed within EOTA.

The European technical approval for the product was evaluated and issued on the basis of the information/data and test results specifying the product in detail which are deposited with Deutsches Institut für Bautechnik. Changes during the production process of the product or its components which could include considerable modifications in the information/data deposited have to be communicated to Deutsches Institut für Bautechnik in advance. The notification has to be made before changes in the properties are made on the product so that Deutsches Institut für Bautechnik can check to what extent the planned modification has effects on the properties tested in this European technical approval and, thus, can decide whether further assessment and/or alterations shall be carried out.

The properties of the product which are not described in the European technical approval shall correspond to the relevant values laid down in the documentation to the European technical approval, examined by Deutsches Institut für Bautechnik.

**2.2 Properties of the Product "ORALITE 6910 Brilliant Grade screen printed with ORALITE 5018 Screen Printing Ink"****2.2.1 Release of dangerous substances**

The product complies with the provisions of Guidance Paper H ("A Harmonized Approach Relating to Dangerous Substances Under the Construction Products Directive", edition 2002) about the dangerous substances. A letter of confirmation by the manufacturer is available.

Note: In addition to the specific clauses relating to dangerous substances contained in this European technical approval, there may be other requirements applicable to the products falling within its scope (e.g. transposed European legislation and national laws, regulations and administrative provisions). In order to meet the provisions of the Construction Products Directive, these requirements need also to be complied with, when and where they apply.

**2.2.2 Visibility of "ORALITE 6910 Brilliant Grade screen printed with ORALITE 5018 Screen Printing Ink"**

The properties of the product set out in clause 1.2 were tested for the granting of this European technical approval.

Detailed information on the test results is deposited with Deutsches Institut für Bautechnik.

For the preparation of the specimens, the test specimens of the reflective sheeting were applied by the manufacturer on a plane aluminium plate with a thickness of 2.0 mm ( $\pm 0.05$  mm).

**2.2.2.1 Chromaticity coordinates and luminance factors**

The determination of the chromaticity coordinates and the luminance factors (see Table 2) was based on the following conditions:

The chromaticity coordinates (x, y) and the luminance factor ( $\beta$ ) were measured according to CIE Publication 15.2 "Colorimetry", edition 1986, by using the 45/0 geometry and calculated for the spectral radiance of the illuminant D65 as well as for the colorimetric standard observer according to CIE 1931 (2°).

The orientation of the specimen in the measuring system was shown by an orientation mark, with the orientation mark being at 90° to the optical plane of incidence. In doing so, the optical plane of incidence was formed from the right angle between the surface of the sample and the incident ray of light from the source of light on the sample surface.

Colour		Chromaticity coordinates				met / not met	Luminance factor Class
		1	2	3	4		
Yellow onto White	x	0.494	0.470	0.513	0.545	met	B2
	y	0.505	0.480	0.437	0.454		$\geq 0.24$
Red onto White	x	0.735	0.700	0.610	0.660	met	B2
	y	0.265	0.250	0.340	0.340		$\geq 0.03$
Blue onto White	x	0.130	0.160	0.160	0.130	met	B2
	y	0.090	0.090	0.140	0.140		$\geq 0.01$
Green onto White	x	0.110	0.170	0.170	0.110	met	B2
	y	0.415	0.415	0.500	0.500		$\geq 0.03$
Orange onto White	x	0.631	0.560	0.506	0.570	met	B2
	y	0.369	0.360	0.404	0.429		$\geq 0.14$
Brown onto White	x	0.455	0.523	0.479	0.558	met	B2
	y	0.397	0.429	0.373	0.394		0.03 - 0.09

Table 2 Chromaticity coordinates and luminance factors

2.2.2.2 Coefficient of retro-reflection (Case A)

The determination of the specific coefficients of retro-reflection  $R_A$  – Case A (see Table 3 et seq.) was based on the following conditions:

The coefficient of retro-reflection  $R_A$  was measured according to the CIE Publication N° 54.2 "Retro-reflection by using the CIE illuminant A". During the measurement any of the recommended apertures could be used. The measurements were carried out at a specific observation angle  $\alpha$ , entrance angle  $\beta$ , rotation angle  $\epsilon$  and orientation angle  $\omega_s$ . In doing so, the entrance angle  $\beta$  was determined via its component  $\beta_1$  with  $\beta_2 = 0^\circ$ . The rotation angle  $\epsilon$  and the orientation angle  $\omega_s$  were to be set also equal to zero.

Geometry of measurements		Colour					
$\alpha$	$\beta_1$ ( $\beta_2 = 0$ )	Yellow onto White	Red onto White	Blue onto White	Green onto White	Orange onto White	Brown onto White
12'	+ 5°	119	31.5	14	31.5	70	8.4
	+30°	70	17.5	7.7	17.5	42	5.95
	+40°	49	10.5	5.6	8.4	20.3	3.5
20'	+ 5°	84	17.5	9.8	14.7	45.5	5.6
	+30°	49	9.8	5.6	8.4	28	3.5
	+40°	42	9.1	4.9	7.7	14	2.1
2°	+ 5°	2.1	0.7	0.14	0.35	1.05	0.14
	+30°	1.05	0.28	#	0.21	0.7	#
	+40°	0.7	0.21	#	0.14	#	#
met/ not met		met	met	met	met	met	met

Table 3 Minimum coefficient of retro-reflection; Class R2 Europe  
#means value exceeding zero, but not clearly measurable and therefore not applicable for evaluation

Geometry of measurements		Colour				
$\alpha$	$\beta_1$ ( $\beta_2 = 0$ )	Yellow onto White	Red onto White	Blue onto White	Green onto White	Orange onto White
0.33°	+ 5°	136.5	42	13.3	21	105
	+20°	108.5	33.6	11.2	16.8	84
	+30°	77	23.1	7.7	11.9	58.1
	+40°	14	4.2	1.4	2.1	10.5
1.0°	+ 5°	16.1	4.9	1.75	2.45	12.6
	+20°	14	4.2	1.4	2.1	10.5
	+30°	9.1	2.8	1.05	1.4	7
	+40°	1.4	0.7	#	#	1.4
1.5°	+ 5°	7	2.1	0.7	1.05	5.25
	+20°	5.6	1.75	#	0.7	4.55
	+30°	4.2	1.4	#	#	3.15
	+40°	0.7	#	#	#	0.7
met/ not met		met	met	met	met	met

Table 4 Minimum coefficient of retro-reflection; class R3B Germany  
# means value exceeding zero, but not clearly measurable and therefore not applicable for evaluation

### 2.2.2.3 Rotational symmetry

The rotational symmetry of the coefficient of retro-reflection was determined under the same conditions as the coefficient of retro-reflection (Case A, see 2.2.2.2). With an observation angle  $\alpha = 0.33^\circ$  and an entrance angle  $\beta_1 = 5^\circ$  ( $\beta_2 = 0^\circ$ ) the ratio between the minimum and the maximum coefficient of retro-reflection during rotation of  $\epsilon$  was determined in  $25^\circ$  steps from  $-75^\circ$  to  $+25^\circ$ . The ratio shall not be greater than 2.5:1. The product satisfies this requirement.

Coefficient of retro-reflection ( $\text{cd} \cdot \text{lx}^{-1} \cdot \text{m}^{-2}$ ) - rotational symmetry		
Colour	Ratio	met / not met
Yellow onto White	1.6	met
Red onto White	1.8	met
Blue onto White	1.3	met
Green onto White	1.2	met
Orange onto White	1.5	met
Brown onto White	1.6	met

Table 5 Rotational symmetry

### 2.2.3 Impact resistance

The determination of the impact resistance was based on the following conditions:

The test was performed according to EN 12899-1:2001. For this purpose a weight of 450 g with a contact radius of 50 mm falls from a height of 220 mm onto the specimen. The specimen shall be reinforced such that the open surface is 100 mm x 100 mm.

Product	Colour		met / not met
Microprismatic reflective sheeting ORALITE 6910 Brilliant Grade screen printed with ORALITE 5018 Screen Printing Ink	Yellow	6910-010 & 5018-020	met: There were no damages.
	Red	6910-010 & 5018-030	
	Blue	6910-010 & 5018-050	
	Green	6910-010 & 5018-060	
	Orange	6910-010 & 5018-035	
	Brown	6910-010 & 5018-080	

Table 6 Impact resistance

### 2.2.4 Durability of "ORALITE 6910 Brilliant Grade screen printed with ORALITE 5018 Screen Printing Ink"

For the assessment of the durability an artificial weathering was carried out.

The artificial weathering was performed according to ISO 4892-2:1994. For that purpose the specimens were weathered for a period of 2000 hours using the following parameters:

Weathering parameters	Air-cooled lamp	Water-cooled lamp
Irradiation cycle/dark phase cycle/spray cycle	Continuous light with spray on the test specimens for 18 min every 2h	Continuous light with spray on the test specimens for 18 min every 2h
Black standard temperature only during irradiation	(65 ± 3)° C with blackpanel thermometer	(65 ± 3)° C with blackpanel thermometer
Relative humidity	(50 ± 5) %	(50 ± 5) %
Irradiance (W/m <sup>2</sup> ) controlled in the - range over 300 nm to 400 nm - range over 300 nm to 800 nm	60 550	60 630
<p>NOTE: 1 - The water used for spraying the test specimens should not contain more than 1ppm silica. Higher proportions of silica can leave residues on the test specimens and cause different results. Water with the required purity can be obtained by distillation or by a combination of deionization and osmosis.</p> <p>NOTE 2 - During irradiation, the aforementioned values should be reached. Changes in the age of the filter and the transmissivity, and changes in the calibration generally mean that the irradiation defect is of the order of 10%.</p>		

Table 7 Artificial weathering test parameters

After the artificial weathering the following tests were carried out:

- Determination of the chromaticity coordinates
- Determination of the luminance factors
- Determination of the specific coefficients of retro-reflection

After the artificial weathering the specific coefficients of retro-reflection with an observation angle of  $\alpha = 0.33^\circ$  (or  $\alpha = 0.2^\circ$ ) and of  $\alpha = 1.0^\circ$  (if specified for new material) and the illumination angles  $\beta_1 = 5^\circ$  and  $30^\circ$  ( $\beta_2 = 0^\circ$ ) must not be less than 80% of the required specific coefficients of retro-reflection in mint condition.

#### 2.2.4.1 Chromaticity coordinates and luminance factors after artificial weathering

Colour		Chromaticity coordinates				met / not met	Luminance factor Class
		1	2	3	4		
Yellow onto White	x	0.545	0.487	0.427	0.465	met	B2 $\geq 0.24$
	y	0.454	0.423	0.483	0.534		
Red onto White	x	0.735	0.674	0.569	0.655	met	B2 $\geq 0.03$
	y	0.265	0.236	0.341	0.345		
Blue onto White	x	0.078	0.150	0.210	0.137	met	B2 $\geq 0.01$
	y	0.171	0.220	0.160	0.038		
Green onto White	x	0.007	0.248	0.177	0.026	met	B2 $\geq 0.03$
	y	0.703	0.409	0.362	0.399		
Orange onto White	x	0.631	0.560	0.506	0.570	met	B2 $\geq 0.14$
	y	0.369	0.360	0.404	0.429		
Brown onto White	x	0.455	0.523	0.479	0.558	met	B2 0.03 – 0.09
	y	0.397	0.429	0.373	0.394		

Table 8 Chromaticity coordinates and luminance factors after artificial weathering

2.2.4.2 Specific coefficients of retro-reflection after artificial weathering

Colour	met/not met * (met: ≥ 80% of the values required in mint condition)
Yellow onto White	met
Red onto White	met
Blue onto White	met
Green onto White	met
Orange onto White	met
Brown onto White	met

Table 9 Coefficient of retro-reflection (Case A) after artificial weathering  
\*assessment was made for the classes which were met in mint condition

**3 Evaluation and attestation of conformity and CE marking**

**3.1 System of attestation of conformity**

According to the Decision 96/579/EC of 24.06.1996<sup>7</sup>, amended by the Decision 1999/453/EC<sup>8</sup>, system 1 of the attestation of conformity shall apply. This system of attestation of conformity is described in the following:

System 1: Certification of the conformity of the product by an approved certification body on the basis of:

- (a) Tasks for the manufacturer:
  - (1) factory production control;
  - (2) further testing of samples taken at the factory by the manufacturer in accordance with a prescribed test and control plan;
- (b) Tasks for the approved body:
  - (3) initial type-testing of the product;
  - (4) initial inspection of factory and of factory production control;
  - (5) continuous surveillance, assessment and approval of factory production control.

Note: Approved bodies are also referred to as "notified bodies".

<sup>7</sup> Official Journal of the European Communities L 254 of 08.10.1996  
<sup>8</sup> Official Journal of the European Communities L 178 of 14.07.1999

## 3.2 Responsibilities

### 3.2.1 Tasks for the manufacturer

#### 3.2.1.1 Factory production control

The manufacturer shall exercise permanent internal control of production (production of the retro-reflective sheeting on the basis of microprisms, transparent colour laminate, screen printing ink). All the elements, requirements and provisions adopted by the manufacturer shall be documented in a systematic manner in the form of written policies and procedures, including records of results performed. This production control system shall ensure that the product is in conformity with this European technical approval.

The manufacturer may only use components stated in the technical documentation of this European technical approval. A quality control on the incoming materials and material components bought will be conducted before these can be used. The manufacturer shall only use materials and/or material components which are entered in the relevant documents of the receiving control according to the test and control plan.

The factory production control shall be in accordance with the "Test and control plan of 05.02.2013 relating to the European technical approval ETA-13/0248 issued on 17 May 2013", which is part of the technical documentation of this European technical approval. The test and control plan is laid down in the context of the factory production control system operated by the manufacturer and deposited with Deutsches Institut für Bautechnik.<sup>9</sup>

The results of the production control are recorded and evaluated. The records include, inter alia, the following information:

- Designation of the product, of the basic materials and of the components,
- type of surveillance and check,
- information on the production time frame of the products and time for testing the products and the materials and material components,
- results of the surveillance and of the control and, if necessary, details for comparison with the requirements demanded,
- signatures of the persons responsible for the factory production control.

The records shall be made available to the responsible inspection bodies during the continuous examination. On demand these shall be made available to Deutsches Institut für Bautechnik.

Details concerning extension, type and frequency of the controls and surveillance which are necessary in the context of factory production control shall be in conformity with the test and control plan which is part of the technical documentation of this European technical approval.

#### 3.2.1.2 Other tasks for the manufacturer

The manufacturer shall, on the basis of a contract, involve bodies which are approved for the tasks referred to in section 3.1 in the field of the micro-prismatic retro-reflective sheetings for traffic signs in order to undertake the actions laid down in section 3.2.2. For this purpose, the test and control plan referred to in sections 3.2.1.1 and 3.2.2 shall be handed over by the manufacturer to the approved bodies involved.

<sup>9</sup> The test and control plan is a confidential part of the European technical approval and only handed over to the approved bodies involved in the procedure of attestation of conformity. See section 3.2.2.

### 3.2.2 Tasks for the approved bodies

The approved bodies shall perform the following tasks in accordance with the provisions laid down in the test and control plan:

- initial type-testing of the product.
- initial inspection of factory and factory production control,
- continuous surveillance, assessment and approval of factory production control.

The approved bodies shall retain the essential points of their actions referred to above and state the results obtained and conclusions drawn in a written report.

The approved certification body involved by the manufacturer shall issue an EC certificate of conformity of the product stating the conformity with the provisions of this European technical approval.

In cases where the provisions of the European technical approval and its test and control plan are no longer fulfilled the certification body shall withdraw the certificate of conformity and inform Deutsches Institut für Bautechnik without delay.

### 3.3 CE marking

The CE marking shall be affixed on the packaging or on the papers enclosed when delivering the product. The letters "CE" shall be followed by the identification number of the approved certification body and be accompanied by the following additional information:

- the name and address of the producer (legal entity responsible for the manufacture),
- the last two digits of the year in which the CE marking was affixed,
- the number of the EC certificate of conformity for the product,
- the number of the European technical approval,
- Product designation "ORALITE 6910 Brilliant Grade screen printed with ORALITE 5018 Screen Printing Ink"
- Information on the product characteristics stated in section 1.2.

## 4 Assumptions under which the fitness of the product for the intended use was favourably assessed

### 4.1 Manufacturing

The European technical approval is issued for the product on the basis of agreed data/information, deposited with Deutsches Institut für Bautechnik, which identifies the product that has been assessed and judged. Changes to the product or production process, which could result in this deposited data/information being incorrect, shall be notified to Deutsches Institut für Bautechnik before the changes are introduced. Deutsches Institut für Bautechnik will decide whether or not such changes affect the approval and consequently the validity of the CE marking on the basis of the approval and if so whether further assessment or alterations to the approval shall be necessary.

### 4.2 Installation

It is the task of the manufacturer to see to it that all persons involved will be informed about the Specific Conditions of this European technical approval.

The sign bases foreseen shall consist of aluminium.

The use of the products is subject to national provisions.

The choice and the preparation of the sign support material, as well as the generally applicable rules on the bonding of the product "ORALITE 6910 Brilliant Grade screen printed with ORALITE 5018 Screen Printing Ink" which are fully described in the current versions of the publications and the technical documentation by the holder of the European technical approval, shall be observed taking account of the national provisions on the use of the product.

### 4.3 Application

#### Screen printing ink

- We recommend the screen printing stencil be a polyester-quality mesh with a mesh number of 61 - 64.
- We recommend squeegee rubbers with a Shore hardness of 65-75. Squeegees should always be inspected and surface ground if necessary. Squeegees should be approx. 7-10 cm wider than the print image.
- We recommend an average squeegee speed of approx. 0.75 m/s during printing, with the squeegee angled at 30° to the print surface. The snap-off distance, i.e. the distance between the mesh and the sheeting surface, should be set to approx. 10 mm.
- Optimal air temperature for the printing process is 20° C - 24° C, with optimal humidity at 20 – 50 %.
- Always be sure to use thinner only up to a maximum volume of 3% when working with ORALITE 5018 in order to maintain required specification values for colour shading and reflection.
- When overlapping colour layers, note that the bottom colour layer should be not cured and that the overprinting process should take place within 12 hours after the first printing.
- Printed traffic signs are ready for delivery after an overall drying time of 48 hours, if they were processed according to the drying conditions specified above, at an ambient temperature of 20° C and an average relative humidity of 40% to 60%. Prints of both colour series are fully cured after approx. 8 days.

#### Cutting, stamping, plotting

- ORALITE Series 6910 Brilliant Grade sheetings can be processed with a standard paper cutter. When doing so, the blank holder should be set at its lowest pressure and the sheeting should also have additional protection from pressure. We recommend limiting the stacking height to 40-50 sheets.
- A standard cutting plotter with a tangential knife, preferably one with a flat bed design, should be used as a plotter system.
- In addition to ORALITE reflective sheeting, this system can also be used to process non-reflective ORALITE sheeting.

Adhesive bonding and lamination

- ORALITE reflective sheetings should always be dry when being bonded!
- Sheeting should not be bonded at air temperatures and material temperatures below 15° C. Optimal bonding temperature is 21° C. Sheetings should be stored for at least 48 hours in the facilities in which they will be processed.
- In order to ensure sheeting will achieve a good bond, the substrate to be bonded should be dry and free of dust, oils, grease, silicone and other impurities. If solvent is required to prepare the substrate, the user shall wait until the solvent (e.g. isopropanol) has completely evaporated before bonding. When bonding sheeting to metallic substrates, it is advantageous to lightly grind the surface.

**5 Indications to the manufacturer**

**5.1 Packaging, transport and storage**

ORALITE 6910 Brilliant Grade should be stored in a cool, dry area, protected from direct sunlight. We recommend temperatures in the range from 20° C to 24° C and a relative humidity of 40% to 60%.

Rolled goods should be transported and stored in their original cartons. Rolls come provided with side mounts as standard. These prevent roll surfaces from coming into contact with the carton, preventing the formation of pressure marks and surface damage. Care should also be taken that partially processed rolls are never stored or transported without side mounts.

It is recommended that a horizontal suspension system (e.g. paternoster, shelf) be used when rolls are removed from their original carton to make them ready for processing. It is not generally expected that technical sheeting properties will be negatively affected even if rolls are stored vertically in a freestanding manner. No matter how rolls are stored, side mounts should always be used during storage in order to prevent sheet edges from being broken. However, practice has shown that this method of storing rolls makes sheeting more difficult to handle. Unprinted and printed film sheets come delivered in packaging that is specially designed to the dimensions of the sheet, with a count of 50 sheets per carton.

When sheets are stored outside this carton, care should be taken that individual sheets lie freely on a flat, stable substrate, without edges bumping into each other or overlapping. Sheets may be stacked one on top of the other. No more than 50 sheets should be stacked together in order to observe permissible weight loading limits.

The company responsible for processing sheeting shall ensure that these processing conditions are readily available to the employees concerned.

Dr.-Ing. Karsten Kathage  
Vice President

*beglaubigt:*  
Sterling