TECHNICAL BULLETIN 5.4

Processing tips for Avery® DOL™ films

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Introduction

Overlaminating of printed images with transparent films is necessary to provide maximum performance of finished images: it provides gloss, colour depth and protection.
Inkjet/printed images require overlaminates for protection against UV radiation, abrasion and moisture.

Overlaminates also enhance the colours of the image and provide it with the required finish: e.g. a gloss finish for outdoor use and a matt or lustre (semi-gloss) finish to avoid unwanted light reflections when used indoors.

The information provided in this document can also be found on our website, www.academy.averygraphics.com. This website also contains instructional How-to videos and additional theory modules.

Lamination

1. Prior to lamination make sure that
   - rollers of the laminator are clean and not damaged
   - rollers are parallel to each other
   - rollers are set at the correct temperature and pressure
   - material is laminated in the centre of the laminator, in case the materials are narrower than the laminator.

2. To operate the laminator, the following settings are recommended:

Avery DOL Range vs. settings	Pressure (psi)	Speed (m/min)	Roller temperature(°C)[1]
DOL 1030 / 1130 DOL 1460 / 1480	50-70	0 - 2.5	20
DOL 1000 / 1100 / 1800 DOL 2000 / 2100 / 2200 DOL 2800 / 2900 DOL 3000 / 3100 / 3200 DOL 4000 / 4100[2] DOL 4300 DOL 5900 / 6000 / 6100[3]	50-70	50-70	20-35

[1] Roller closest to the laminate
[2] Both DOL 4000 and DOL 4100 only in conjunction with Avery Perforated Window Films
[3] Only in conjunction with Avery Floor Marking films

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