

See "Rigid Material Application Notes" and manufacturer's website for specific, detailed guidelines and instructions.

## GENERAL INFORMATION

### MATERIAL DESCRIPTION

FOREX classic (a European product) is a white, large plastic sheet made up of PVC and PS. It has a fine, closed, homogenous cell structure with a smooth, silky mat surface which makes it an ideal material for high quality, longer-term interior and exterior applications; It is easily fabricated mechanically and can also be thermoformed for three-dimensional applications.

### RECOMMENDED APPLICATIONS

- POS/POP display
- Long-term interior signage
- Long-term exterior signage 3D applications
- 3D applications
- Exhibiton signs

## CAUTIONS

1. Be specific when ordering material as there are many similar materials and finishes, yet performance and results will vary significantly, even among like materials.
2. Be sure to measure dimensions of material prior to printing as they are not always consistent.
3. The following may cause adverse effects on ink adhesion and durability:
  - Failure to acclimate material to ambient conditions for at least 24 hours.
  - Failure to print under recommended ambient conditions.
  - Neglecting to remove the protective plastic layer.
  - Neglecting to properly clean the print surfaces. This will allow debris to be visible after printing. Ensure that 99% isopropyl alcohol is used for cleaning.
  - Using thinners or soaps which may leave a film residue which can affect adhesion. Additionally, cleaners containing silicone can interfere with adhesion and are not recommended.
  - Elevated UV exposure can affect PVCs printed with UV ink, causing brittleness in the printed areas of the sheet.
4. Ink adhesion increases at higher quality modes. (Quality 1 Uni > Production 1 Uni > Performance Uni).

**WARNING:** Be sure that material is completely flat. Bent edges may cause damage to printheads and/or other hardware. Tape down edges as necessary. Leaning may cause warping.

## PERFORMANCE TESTING RESULTS

See "Material Performance Testing Process" document for process explanation and test conditions.

### ADHESION TESTING

Tape Test: Level 5, Excellent  
Cross-Hatch Test: Level 0, Very Poor

### ABRASION RESISTANCE

Level 5, Excellent

### CHEMICAL RESISTANCE

Level 5, Excellent

### OUTDOOR DURABILITY

GerberCAT inks are outdoor durable for up to 3 years. Consult material manufacturer for durability of substrate. Testing of application in intended environment is advised.

## TESTED PRINT CONDITIONS

### AMBIENT TEMPERATURE

70°F (21°C)

### AMBIENT HUMIDITY

40%, non-condensing

### PRINTER RESOLUTION

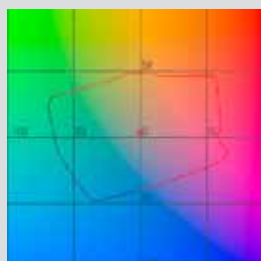
635 x 720 dpi

### PRINT MODE

Production 1 Unidirectional

## COLOR GAMUT

### 2-DIMENSIONAL



### 3-DIMENSIONAL



## MATERIAL HANDLING RECOMMENDATIONS

### STORAGE

1. Flat, horizontally only. Leaning will allow warping.
2. Cool, dry, clean area with stable temperature.
3. Don't store pallets on top of each other. The pressure of the over-laying pallets may cause buckling and permanent deformation of the sheets.

### SURFACE PREPARATION

1. Remove protective plastic layer and allow to outgas for 24 hours prior to printing.
2. Print surface should be free and clear of any surface contaminants (i.e. oils, dust, fingerprints, etc.) prior to printing.
3. Clean with 99% isopropyl alcohol, using a non-colored cloth. Best results have been obtained when applying the alcohol to the wiping cloth rather than directly to the material.
4. Any surface scratches on the substrate will have a tendency to telegraph through the graphic. In order to remove small scratches or dents, rapidly fan a heat gun over the affected area. Care must be taken not to leave the hot air in one place for too long, as the surface can be deformed.

### POST-PRINT

Ink cures enough to be touched immediately without adverse effect. Full cure occurs between 15 minutes and 24 hours dependent upon material and ambient conditions. Cutting, routing, or any additional undertakings should run flawlessly. If any flaking or cracking occurs, allow to sit 24 hours for full cure. Best cutting results are obtained with carbide-tipped router bits.

See manufacturer's website for more information.

## COLOR MANAGEMENT

### RECOMMENDED RENDERING INTENTS

CMYK Vector: Relative colorimetric  
CMYK Image: Perceptual  
RGB Vector: Relative colorimetric  
RGB Image: Perceptual

### MATERIAL PROFILES

The recommended profile can be downloaded from the corresponding materials page on the gspinc.com/applications webpage.

**CAUTION:** Failure to manage color settings consistently throughout the entire workflow, from image generation through final print, will result in guesswork and unpredictable and potentially unfavorable end results.

