

FLEXcon® HX5000 with HOV-X Technology™ Technical Guide and Application Instructions

Film Features and Benefits:

- Low initial tack for optimal removability and repositionability.
- Ability to quickly align graphics with simple finger pressure.
- Smooth “snap-up” from substrate surface while aligning graphics.
- Effortless release of liner to avoid graphic distortion.
- Air egress release liner for easy bubble removal from applied graphics.
- Graphics can be overlapped for easier alignment.
- Strong bond after pressured application with squeegee or other tools.
- Ease of use, a novice or seasoned installer can have great results, easily.

Printability

- UV and solvent screen inks
- UV and solvent inkjet
 - For inkjet printing typical max limit=250%. When storing printed graphics, sheeted, stacked or in roll-form, consider leaving an unprinted margin (about ¼”) to allow for potential shrinkage of the film before trimming.
- Latex inks

UV Cured Inks

For any specific print technology inquiry, please contact your FLEXcon Technical Service Representative.

Suggest using flexible UV ink. Please review available flexible inks with your ink supplier.

1. Allow for post cure before die cutting. Certain UV inks will continue to (post) cure after the initial cure. The ink’s formulation specific to bond, durability and chemical resistance will continue to build and develop after the initial cure. Please be aware that some darker and opaque colors are more difficult to cure.
2. Watch for over-cured ink, as it will be brittle and it will chip and crack along the die-cut edge. Please check for bulb wattage, line speed, and flexibility of your ink.
3. Best packaging method is layflat sheets; however, size of graphic may dictate tubing. Suggest winding printed side out onto a 3” core to prevent tunneling.
4. Rolls should be stored at a minimum temperature of 40°F (10°C) and 50% relative humidity before installation.

FLEXcon® HX5000 with HOV-X Technology™ Technical Guide and Application Instructions Page 2

Solvent Inks

This product is printable on all solvent inkjet printers with the following cautions:

1. Be sure all solvents are completely dried out of film before die cutting. Do not wrap/roll film until all solvents have been completely dried. Refer to solvent dryness test:
 - o Place several printed sheets face to face under a 12" stack of media or under a weight of 2 pounds per square inch.
 - o After 10 minutes, remove the sheets and check for blocking or surface impressions. If blocking or surface impressions are noted, either increase the temperature or decrease the line speed, as additional drying is needed. Retest.
 - o Residual solvents left in the media will certainly cause application failure. The film will lose stability and become very elastic. The adhesive may also build in strength becoming more permanent than removable.
 - o Wind print side out onto a minimum of a 3" core to prevent tunneling.
 - o Rolls should be stored at a minimum temperature of 40°F (10°C) and 50% relative humidity before installation.

Latex Inks

- Print technology involves high heat 212°F+ (100°C+).
- Heat can distort film causing wrinkling.
- Some media may not be compatible - test for suitability.
- We offer wide web sample rolls of FLEXcon approved media for suitability testing.
- Wind print side out onto a minimum of a 3" core to prevent tunneling.
- Rolls should be stored at a minimum temperature of 40°F (10°C) and 50% relative humidity before installation.

Overlaminates

Overlaminating is recommended. HX5000 is designed to be paired with FLEXcon® BUSart™ OV5055 2-mil clear cast vinyl overlaminate for optimum performance. Please refer to product specific application sheet for additional information.

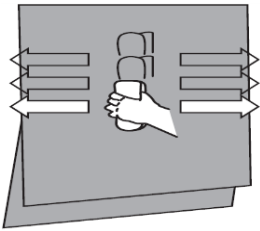
Application Environment/ Surface

- When possible, it is recommended to install indoors in a controlled environment.
- Wiping with solutions, such as isopropyl alcohol, is not required on most clean, dry surfaces.
- OEM Painted Metal - Smooth, Flat, Simple Curves, without rivets.

Please Note: Not recommended for paints that are uncured, aged, oxidized, or otherwise unsound or non-OEM

FLEXcon® HX5000 with HOV-X Technology™ Technical Guide and Application Instructions Page 3

Installation



- Printed graphic should be removed from its packaging, allowed to lay flat and acclimate to the room environment prior to installation.
- The minimum temperature is 40°F (10°C) with 50% relative humidity.
 - Avoid applying to an area directly near a heater or source of condensation.
- Dry application. Apply to a clean, dry surface. Condensation left behind the graphic will cause the graphic to lift.
- Once firm pressure is applied to the film, it will start to lose some of its low initial tack/slideability. Care should be taken not to excessively overwork the film - Avoid applying with pressure multiple times until the graphic is in its final position.
- Once aligned properly, firm pressure with a squeegee should be applied in overlapping strokes to fully adhere the graphic.
- Align and set the center top of the exposed adhesive area of the graphic, working the middle section of the graphic first. Use firm, even strokes as you work your way from the center to either side. Continue to slowly remove the paper liner, while squeegeeing horizontally with overlapping strokes, working from top to bottom and from center to sides. Be sure to squeegee the entire graphic surface to ensure adequate adhesion.
- When installing around rivets or other pieces of hardware, it is recommended to cut around the hardware edges to achieve optimal durability.
- Air bubbles can be removed by pushing down with finger pressure, starting at one edge of the bubble, and working through it.
- Overlapping seams are recommended when installing multiple graphic panels.
- Graphics should be installed from the rear to the front to help ensure seams are protected from outdoor elements.

FLEXcon® HX5000 with HOV-X Technology™
Technical Guide and Application Instructions
Page 4

**Environmental
Conditions/
Removability**

- Up to two-year outdoor durability.
- United States and Canada outdoor vertical surfaces.
- Film can be removed without heat or use of chemicals with little or no adhesive residue.
- HX5000 is removable up to one year from sound paint surfaces with little or no adhesive residue.
- Environmental conditions such as heat, humidity, condensation, air conditioning, exposure to chemicals and abrasion etc. can impact the installation, application life, and removability of the graphic.

For more information, please call 508.885.8296.

~ The typical performance data and recommendations for using FLEXcon products shall be used only as a guide. All purchasers of FLEXcon products shall be responsible for independently determining the suitability of the material for the purpose of its intended use. ~

08/21/19