

Matrix Series Settings and Procedures

Application	Temperature	Heated Roller Pressure	Pull Roller Pressure	Speed
Single Side Gloss Lam	115 - 120	0.6	0.25	3 - 5
Single Side Soft Touch Lam	120 - 125	0.6+	0.25	2 - 3
Double Sided Gloss	115 - 120 Top 130 - 140 Bottom	0.6+	0.25	2 - 3
Double Sided Soft Touch	120 - 125 Top 130 - 140 Bottom	0.6+	0.25	2 - 3
Foil onto Soft Touch	105 - 115	0.3	0.25	1.5 - 4
Foil onto Coated Stock	110 - 120	0.3 - 0.4	0.25	1.5 - 3
Foil onto Uncoated Stock	120 - 135	0.4 - 0.6+	0.25	1 - 3

1. Temperatures, Speeds, and Pressure

These are recommended starting points.

General rule of thumb, the darker and heavier the coverage, the hotter, slower, and more pressure you want to apply.

- 2. Change over from film to foil
 - Turn off burster on display, enter set up, and go to mode without burster.
 - Slit film just above heated roller.
 - Place in offset idler and lead film directly from roll over idler and track to hot lam.
 - Lead foil back around rear idler and back to rewind.
 - Make sure the perf wheel is up and the exit wheels are out of the way so foil runs smoothly.
 - In order to revert to laminate, reverse steps above.



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