










ADHESION GUIDE

Proper print adhesion is easy to accomplish when using the Revolution 360°T UV printer in conjunction with the Pyrobond 4GL system. The team of IDS print experts has put together this handy set of instructions for some of the most popular substrates. Simply locate your material's column and follow the steps in order as you move down the respective column.

	METAL	GLASS	POWDER COAT
MATERIAL PREP			
 Material Prep	n/a	n/a	Wipe with 100% Acetone
PRE-TREATMENT PROCESS			
 PyroBond 4GL Set Distance	The substrate should be approximately 3-6mm from the blue flame		
 PyroBond GL4 Treatment	Each product should get flamed 4 turns propane 3 turns Pyrosil®	Each product should get flamed 3 turns propane 2 turns Pyrosil®	Each product should get flamed 3 turns propane 2 turns Pyrosil®
 Manual Wipe Prior to Printing	P4 BUY P4 wipe removes irregularities & residue	P5 BUY P5 wipe removes irregularities & residue	P4 BUY P4 wipe removes irregularities & residue
READY TO PRINT			
 Printer UV Lamp Settings: W+CMYK	Power between 5 & 7 recommended	Power between 3 & 5 recommended	Power between 5 & 7 recommended
 Printer UV Lamp Settings: Varnish	Power between 3 & 7 recommended	Power between 3 & 5 recommended	Power between 3 & 7 recommended
 POST CURE LAPS	7 Laps 7 Power for both lamps	7 Laps 5 Power for both lamps	7 Laps 7 Power for both lamps
NOTES	When adjusting the flame heads on the Pyrobond 4GL system, pay close attention to where the flame separates from blue to red/orange. The goal of the Pyrobond 4GL treatment is to get the fog to clear from the substrate. This ensures a proper Pyrosil® coating. Use the P5 wipe on glass! P4 vs P5 Wipe: The P5 wipe has a higher alcohol content than P4 to evaporate unnecessary residue from glass substrates.		



REVOLUTION 360T HIGH-SPEED ROTARY UV-LED PRINTER

PyroBond 4GL PYROSIL/FLAME PRETREATMENT SYSTEM

