

ORACAL® Series 641 Economy Cal

Easy Weeding. Water-Based Adhesive.

Value and Performance

An economy film that offers great performance, ORACAL® Series 641 features 4-year outdoor durability and the lowest shrinkage of any economy film (<.016). Plus, its water-based permanent adhesive allows for easy weeding. Available in 59 vivid colors, this 3-mil film is an excellent choice for shorter-term indoor and outdoor applications like banners, directional signs, POP displays and window graphics (not recommended for vehicle graphics).

ORACAL® Series 641 Economy Cal Features and Benefits

- | | |
|--|---|
| ✓ 59 brilliant colors | = Large selection of high-impact colors |
| ✓ Water-based adhesive system | = Easy weeding |
| ✓ 84-lb. Silicone coated liner | = Excellent weeding and release values |
| | = Blue liner for white provides superior contrast for cutting and weeding |
| ✓ Consistent and homogeneous pigment mix | = Color remains the same in daylight and nighttime conditions |
| ✓ 100% splice-free rolls, every time | = No production downtime |
| ✓ Quality certified ISO 9001 | = Unmatched consistency |
| | = Colors remain consistent throughout the entire roll as well as roll-to-roll |
| ✓ Revolutionary batch ID system | = Provides outstanding quality control |
| ✓ Compatible with thermal transfer imaging equipment | = Unlimited creative possibilities |

ORACAL® Series 641 Economy Cal

Description

Soft PVC film with a high-gloss surface. Available in 60 brilliant colors.

Release Paper

84# Silicone coated paper with special release characteristics that provide excellent weeding and release values. Customized blue silicone paper liner for white provides superior contrast for cutting and weeding.

Adhesive

Polyacrylate dispersion, permanent

Applications

Ideal for the creation of short- and medium-term markings, inscriptions and decorations. Not recommended for vehicle graphics. Gloss finish is thermal-transfer compatible.

Technical Data

Thickness (without protective paper and adhesive)	2.75 mil
Dimensional Stability	Adhered to steel, no measurable shrinkage in cross direction; in length, < .016"
Temperature Resistance	Adhered to aluminum, -40°F to +176°F, no variation
Adhesive Power (FINAT TM-1, after 24 h, average)	Adhered to stainless steel: 3.7 lb/in ²
Resistance to Cleaning Agents	After 72h adhered to aluminum at room temperature, resistant to most oils and greases, weak acids, salts and alkalis
Tensile Strength (DIN EN ISO 527) Along Across	Min. 19 MPa Min. 19 MPa
Elongation at Break (DIN EN ISO 527) Along Across	Min. 130% Min. 150%
Seawaterability (DIN 50 021)	Adhered to aluminum, no variation after 48h/73°F
Shelf Life (68°F/50% relative humidity)	2 years
Minimum Application Temperature	50°F
Available Lengths Available Widths (inches)	50-yard rolls 24, 48, 15 punched, 30 punched
Minimum Life Expectancy (based on accepted application procedures on vertical surfaces)	4 years – black and white 3 years – colors, transparent, metallic

Attention

Surfaces to which the material will be applied must be cleaned thoroughly of dust, grease or any contaminants. Freshly lacquered or painted surfaces should be allowed to stand for at least three weeks after complete curing. The compatibility of selected lacquers and paints should be tested by the end-user prior to use.

The statements in this information sheet are based upon our knowledge and practical experience. This data is intended only as a source of information and is given without any guarantee and does not constitute a warranty. Due to the wide variety of possible uses and applications, customers should independently determine the suitability of this material for their specific purpose, prior to use.

