

Matrix Series Settings and Procedures

1. Temperatures, Speeds, and Pressure

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

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.