

FOAMSEAL

PVC Foam Backstripping



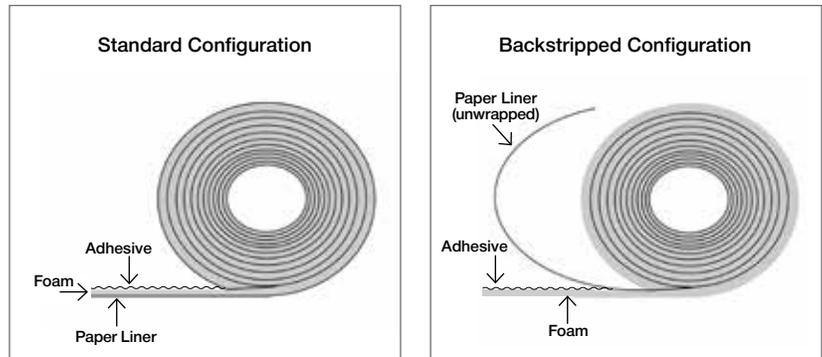
Length around Core

Due to the aggressive adhesive supplied on our PVC Foam, if supplied on a fiber core you will lose the foam that is around the core of the roll (about 9 inches). We at Novagard have incorporated this loss into the length that is supplied on each roll/log. In other words, we supply extra length on each roll/log to compensate for this loss. You will not receive less usable footage than that which is stated.

Solution to Loss in Yield and Growing Foam

A suggested solution to eliminate these challenges is to laminate a second release liner to the adhesive side of the foam material, and remove the release liner that is supplied with the material, referred to as the casting sheet. This has to be done while the material is unwound and in a flat position. Novagard does not offer this service.

Novagard manufactures Foam Seal PVC foam with the adhesive side exposed. The length is determined with the foam used in this manner. When the use requires the adhesive side to be against the paper, the product has to be reverse wrapped so the uncoated foam is exposed. This causes a loss of yield in length. The reason for this loss is that the configuration of the foam is changed because the foam is compressed onto a shorter length of liner. The loss will be equal to the outer circumference of the material minus 9 inches. Backstripping is also known as reverse wrapping.



Die Cutting the Foam Seal Product: Always remember that our PVC foam is manufactured with the adhesive exposed. You are unable to die cut the material in this configuration. You must reverse wrap the material (See drawing above). However, reverse wrapping causes a loss of yield in length. The reason for this is that when you reverse wrap you are changing the configuration of the material. The material will now appear to have the release liner covering the adhesive. What has actually taken place is that by reverse wrapping the material you have compressed the material onto a shorter length of liner thus causing a loss in yield. This loss in yield is equal to the length of circumference around the roll minus the 9 inches of liner you are gaining from the unusable inner core wrap. When ordering or pricing die cut material, include these characteristics in your planning process.

Dimensional Changes in Die Cut Parts: Once a part is die cut from a reverse wrapped roll of PVC foam, the parts are subject to dimensional change, sometimes referred to as “growing foam”. Foam has a characteristic referred to as “foam memory” or foam set; when stored in a specific orientation it maintains a dimensional memory of that orientation and when freed of constraints it tries to return to that orientation. In reverse wrapped rolls, the substrate is on the adhesive side acting as the dimensional constraint. Since the product is wound up and stored in roll form, the adhesive side of each wrap/layer is shorter than the cast side. When you flatten the material to die cut you compress the longer cast surface to the same length as the adhesive/substrate surface. After the part is die cut and the substrate liner removed, the cast side of the foam will try to return to its longer original length stretching the adhesive side and making the foam appear to “grow”. The opposite effect (shrinkage) can be seen if uncoated foam is unrolled in its natural configuration and die cut. In this case the constraining substrate is on the longer cast surface. When the material is flattened for die cutting the non-cast side is stretched. Removing the substrate after die cutting allows the cast side to shrink as the non-cast side returns to its shorter length. These dimensional changes can increase as the thickness of the foam increases. If possible, the die should be configured so the largest dimension is cut in the cross machine direction. This will minimize the dimensional change.

NOVAGARD
SILICONE | HYBRIDS | FOAM

5109 Hamilton Avenue
Cleveland, OH 44114 USA
(216) 881-8111 | (800) 380-0138
(216) 881-6977 fax
novagard.com

ISO 9001:2015 QMS (with Design)
IATF 16949:2016 QMS (with Design)
Certified Women's Business Enterprise
Certified Women Owned Small Business



Most of our foams are California Prop65 compliant without additional labeling.
Most of our foams can be made UV resistant. Consult your sales representative for details