

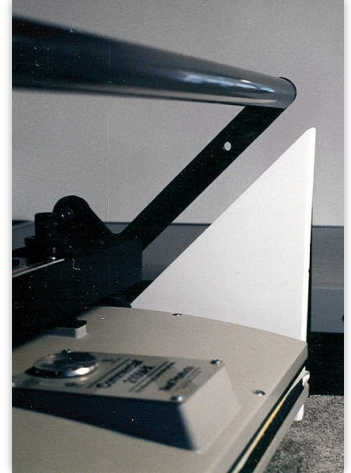


Mounting Instructions for Presses

Mechanical Press

Single Mount (no larger than platen)

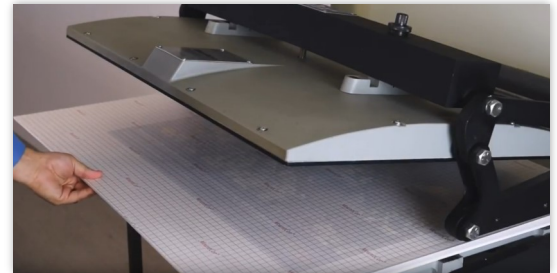
1. Warm press to **130°F** temperature. (Calibrate with heat strip)
2. Peel back liner leaving 2" of liner attached to lower edge of board.
3. Align image face up between liner and board.
4. Verify image alignment using gridded pattern on release liner.
5. Close the release liner covering all exposed adhesive.
6. Place in press, lock closed for **30 seconds**. (Heavier media may require more time.)
7. Remove from press and cool.
8. Trim to size as needed.



Multiple Bite Mount

Bonding images larger than the press platen is possible using multiple bites with each bite overlapping the previous to insure all the adhesive has been fully activated. A longer dwell time is needed because of the added release board.

1. Warm press to **130°F** temperature.
2. Verify arm is adjusted to 45° for 3/16" MC + release board thickness.
3. Peel back liner leaving 2" of liner attached to lower edge of board.
4. Align image face up between liner and board.
5. Cover section within the press with release board.
6. Close lid for **4 minutes**. (Heavier media may require more time.)
7. Move to next bite and mount 4 minutes. Continue until done.
8. Remove from press and cool.
9. Trim to size as needed.



Hot Vacuum Press

Basic Mount

The draw time of a vacuum press varies depending on manufacturer and overall size of the press. Dwell time is the period after full draw when all materials are compressed and heated for activation. A 1 minute draw + 2 minute dwell is the average 3 minute time for a vacuum. Release boards are never required for any technique in a vacuum press. Use of one will require additional press dwell time for heating additional inner materials. Do not increase the temperature.

1. Warm press to **130°F** temperature.
2. Peel back liner leaving 2" of liner attached to lower edge of board.
3. Align image face up between liner and board.
4. Verify image alignment using gridded pattern on release liner.
5. Close the release liner covering all exposed adhesive.
6. Close lid and activate the vacuum and run a full 2 minutes plus draw time. (Heavier media may require more time.)
7. Remove from press and cool.
8. Trim to size as needed.

Flush Mount (mounting to the outer edges of the board)

1. Tack the image along center end at the very edge to hold in place.
2. Remove the gridded liner and replace with a larger sheet of single-sided release paper.
3. Then follow the steps 6 through 8 above.

Mounting Instructions for Roll Laminators

MountCor aggressively bonds in a roll laminator at the reduced temperature of 260°F at a speed of 2-4 fpm while still being safe enough for all digitals. All exposed adhesive must be fully covered with the release liner when feeding through heated rollers to insure clean results. (The higher the temperature, for example 300°F, the faster the speed.)

Hot Roll Laminator

Basic Mount

It is important to feed the board with the sealed liner edge entering the roller nip first to ensure smooth alignment and no ripples of the release liner.

1. Heat roller to desired temperature and set fpm speed.
2. Adjust rollers to substrate thickness.
3. Pull back gridded liner, leaving 2", and align image on board.
4. Close liner to hold image in place.
5. Feed the board with the liner through the rollers to protect the roll.
6. Trim to size as needed.



Suggested Settings for Roll Laminator

Our recommended roller temperature is 260°F at 2-4 fpm for **most** standard mounting. Lightweight paper, digital paper, and photos may bond at 260°F but fpm will also need to be adjusted for maximum bond. Higher temperatures and slower speeds, for example 300°F at 1 fpm, may be necessary to bond heavier media.

**Modify FPM speed to insure maximum bond and to fit production needs.*

Image	Temperature	FPM*
Paper—lightweight	260°F	2-4 fpm
Posters - 60-90#	260°F	2-4 fpm
Polyester and Encapsulated Charts	260° - 300°F	1 fpm
Synthetic Paper - Yupo, Tyvek	260°F	2-4 fpm
Photos (traditional) - RA-4, Fiber base, RC	260°F	2-4 fpm
Digital Paper/Photos, Laser Copies, Plotters	260°F	2-4 fpm
Dye sublimation, Dye diffusion Prints	260°F	2-4 fpm
Inkjet – dye, pigment, solvent, UV, latex	260°F	2-4 fpm

Lower temperatures at slower dwell times have proven good results, test all changes in temperature and fpm.

Image	Temperature	Mechanical*	Vacuum*(+ draw time)	Roll Laminator
Porous Paper, thin, light, newsprint	130°F	30 seconds	2 minutes	Recommended Settings 260°F** 2-4 fpm
Heavy Asian Paper, uneven and textured	130°F	30 seconds	2 minutes	
Open Edition Reproductions	130°F	30 seconds	2 minutes	
4-ply mat	130°F	30 seconds	2 minutes	
Polyester and encapsulates	130°F	30 seconds	2 minutes	
Multiple Bites with 4-ply release board	130°F	4 minutes	NA	
RA-4, fiber base, RC photos	130°F	30 seconds	2 minutes	
Digital paper laser copies, plotters	130°F	30 seconds	2 minutes	
Dye sublimation, dye diffusion	130°F	30 seconds	2 minutes	
Inkjet – dye, pigment, solvent, UV	130°F	30 seconds	2 minutes	

Suggested Settings for Mechanical and Vacuum Heat Presses

** Duration times may vary depending on weights of materials and sizes being mounted. Add draw time to above vacuum times. Since 130°F is safe for digital images—while 150°F is not—dwell time may be added to any mounting without concern for damaging art. Altering the temperature is not advised.*