



## Mounting Instructions for Presses

### Mechanical Press

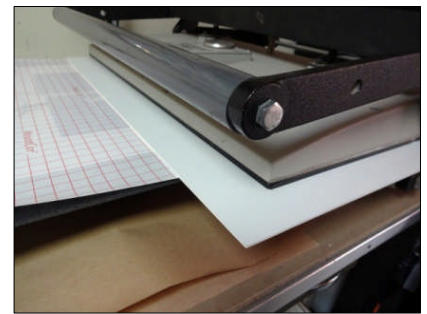
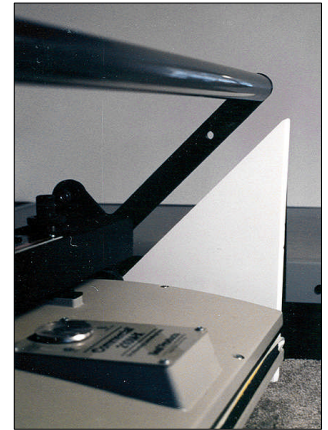
#### *Single Mount (no larger than platen)*

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. Place in press, lock closed for **30 seconds**.
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. Since a release board is required the gridded liner may be discarded.
7. Close lid and lock press closed for **4 minutes**.
8. Move to next bite and mount 4 minutes. Continue until done.
9. Remove from press and cool.
10. 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.  
*The adhesive feels tacky when first removed but is fully bonded.*
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

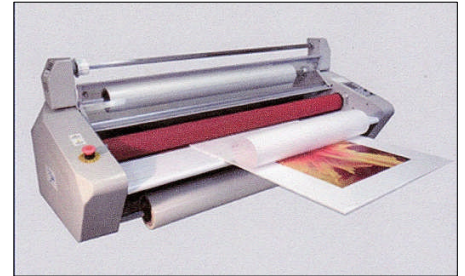
MountCor aggressively bonds in a roll laminator at the reduced temperature of 260°F at a speed of 2-4 fpm while still be safe enough for all digitals. All exposed adhesive must be fully covered with the release liner when feeding through heated rollers to insure clean results.

## 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. Warm roller to desired temperature and set fpm speed.
2. Adjust rollers to substrate thickness.
3. Pull back gridded liner and align image on board.
4. Close liner to hold image in place.
5. Feed the liner through the rollers with the board to protect the roll.
6. Nip end into rollers and allow it to feed through on automatic.
7. Trim to size as needed.



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## 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 between 220°F -260°F but fpm will also need to be adjusted for maximum bond. Remember the dwell time under a heated roller is 1 second or less depending on the size of the roller and speed.

| Image  | Temperature | FPM*    |
|--|-------------|---------|
| Paper - lightweight                          | 260°F       | 2-4 fpm |
| Posters - 60-90#                             | 260°F       | 2-4 fpm |
| Polyester and Encapsulated Charts            | 260°F       | 2-4 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 |

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

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

## Suggested Settings for Mechanical and Vacuum Heat Presses

| Image                                   | Temperature | Mechanical* | Vacuum* (+ draw) |
|---|-------------|-------------|------------------|
| Porous Paper - thin, light, newsprint   | 130°F       | 30 seconds  | 2 minutes        |
| Heavy Asian Paper - uneven and textured | 130°F       | 30 seconds  | 2 minutes        |
| 60-90# 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       | 1 minute    | 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        |

\* 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.

WARNING: Foamboard is combustible and may constitute a fire hazard if improperly used. Do not expose to flame or other ignition source as this product may burn rapidly. For more information and MSDS sheet call Gilman Brothers Company at 800-852-4220

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