



# Material Handling Notes for Dissolvable Products

## Background

Avery Dennison dissolvable label materials are virtually residue-free, disintegrating in 40-75 seconds when immersed in ambient water (72°F). No residue means no bacteria growth. Because dissolvable labels don't need to be removed, they save on clean up time and waste.

## Press

Dissolvable constructions are no different than "standard" pressure-sensitive (PS) constructions in that no "special requirements" are needed for converting. The recommended ink technology used for converting on dissolvable paper facestocks is water-based in systems, as opposed to UV or solvent. When die cutting these dissolvable paper facestocks, make sure:

- > Die is tooled correctly to the construction
- > Die station and anvil are clean,
- > Die is within manufacturer's tolerance for roundness,
- > Drive gears have been lubricated and maintained with no missing or chipped teeth

A quality die strike would enable the operator to see a faint image of all die cavities on the liner after wetting with marker, or die stain solution. Rewind pressure on press should be kept as low as possible to prevent adhesive bleed.

## Storage Conditions

Since these papers and adhesives are made to dissolve, they are very sensitive to storage conditions. These materials turn yellow with exposure to air in humid and warm conditions. They are also sensitive to volatile organic compounds such as vehicle (forklift) exhaust. To alleviate these issues, we recommend these materials be stored in cool and dry conditions, 72°F with 50% relative humidity and kept wrapped in a relatively non-porous material, such as a couple of layers of plastic stretch or polyethylene wrap to prevent exposure to these conditions. The adhesive is also sensitive to the same conditions and will lose adhesion and release characteristics if not protected.

## Finishing

When finishing converted labels from press, rewind pressure should be lowered so that when you remove finished labels from the rewind mandrel, the roll will be flexible. When holding the roll of labels, you should be able to flex the roll - this will prevent adhesive bleed and back label transfer. You should be able to hold the finished roll of labels on the outside of the roll without the center core area falling through.

All comparisons are believed to be reliable and accurate. However, the furnishing of such information and comparisons is for reference purposes only and does not constitute a warranty of any kind. Actual product performance should always be tested for fitness-for-use

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