In-line coating
with TEGO® RC Silicones
Introduction

Thirty years ago, as the pioneer for UV free radical curable silicone technology, Evonik has continuously developed innovative solutions for the tape and label market. Through cooperations with equipment manufacturers for converting and coating as well as material suppliers Evonik’s TEGO® RC team strives for continuous improvement of processes, making us the partner of choice for in-line siliconizing. TEGO® RC Silicons guarantee successful in-line converting of entire labels. The patented UV radical technology allows for instant cure meaning no post cure, efficient operation and high quality. A global network of experts and local test facilities allow a smooth start with in-line siliconizing.
MANY GOOD REASONS FOR IN-LINE SILICONIZING

The traditional way of producing a pressure sensitive adhesive label uses a pre-manufactured laminate, consisting of a siliconized liner, and adhesive together with a face sheet to print on. Modern technology, products and equipment allow the label producers to customize their selection of raw materials for face stock and liner, paper or film, adhesive and UV silicone. Through in-line coating every step of the label making process is under your control; design, coating and printing gives you 100% flexibility and 100% control. This makes in-line siliconizing the right choice when it comes to independence, cost and time management.
Self-adhesive products such as labels and tapes are sophisticated, multilayer systems. In addition to the adhesive and the face stock material, a laminated label also includes a backing known as a release liner. This liner is made of paper, plastic or other materials. If the label is to work properly, an invisible yet crucial fourth layer, the silicone, also comes into play: Thanks to this silicone layer, pressure sensitive adhesive products can be peeled off of backings the liner with exact precision and fast.

TEGO® RC UV radical curing silicone is the latest innovation of silicone coating technology offering many advantages. Coating at room temperature means less consumption of energy and no stress to the substrate. Heat sensitive substrates can be used. Paper shows excellent lay-flat behavior. Thin gauge substrates, recycled material, plant based substrates and even linerless labels can be coated successfully. TEGO® RC Silicones consist of 100% active material and contain no solvent.

Because of the cold cure technology TEGO® RC Silicones offer the advantage to print before siliconizing. They will not compromise the print of the facestock or thermal activated ink. The before mentioned properties makes TEGO® RC Silicones especially suitable for the production of linerless labels for both Variable Information Print (VIP) and prime label applications.

TEGO® RC Silicones allow also for production of tapes. Applications in electronics, construction and composites are the driving growth and innovations in the tape sector. The UV curing technology provides many advantages as capability
to fine-tune of release properties, narrow processing window and flexibility in choice of substrate. TEGO® RC Silicones can be used to achieve excellent release coating including foam tapes, reflective films, security tamper evident tapes or diaper tapes.

After application the silicone coating passes through a UV chamber where the liquid product undergoes a free radical polymerization process and instantly forms into a solid, flexible layer of less than a micron thickness. On the same converting line one can immediately apply the adhesive, laminate the facestock, die cut, slit and rewind the final product all in one pass. High line speeds up to several hundred m/min are standard.

TEGO® RC Silicones mean an advantage to the environment and efficient production.

The release value, the force to peel off the label from the liner, depends on both the adhesive and the type of TEGO® RC products used. Release values can be adjusted ranging from Premium/Easy to Controlled/Tight.

Typically a silicone release coating consists of an anchorage component (A), release component (R) and a photoinitiator (PI). By changing the ratio of the individual components the release values can be adjusted. In addition one component systems (O) facilitate handling during production as they are used without the need for blending.
Prior to use, TEGO® RC Silicones are blended in the appropriate ratio to achieve the desired release value. The photoinitiator should be added accurately, e.g. 2.0 +/- 0.2%. For one component products blending is not required.

The recommended mixing equipment is dependent on the daily volumes used. For small amounts of silicone (e.g. up to 30 kg), a drill with a paddle stirrer usually is sufficient. For higher volumes continuous mixing and metering equipment is commercially available.

PICTURE 3
Blending of TEGO® RC Silicones

- 200 kg iron drums
- Drum stand
- Catch basin
- TEGO® RC Silicones
- Additional marking of the drums
- Wall mounted agitator
- Calibrated bar for volume determination
- Mixing container e.g. 50 l
- Tap with drop bucket
TEGO® RC Silicones allow manufacturers to coat on wide selection of substrates.
On paper, on temperature sensitive films (incl. PE, PP or PVC), bio engineered films or non-woven materials. Changing between substrates in production may require optimization of blends and machine settings. To ensure performance and quality, silicone coat-weight and release values should be checked before starting full production.

Evonik’s TEGO® RC Silicones offer Technical Service with vast experience and expertise when it comes to all kind of substrates for liner and adhesives, such as hot melt and acrylic systems.
COATING EQUIPMENT

For applying the silicone and the adhesive to the substrate, specially designed equipment is widely available in the market. Equipment and machine suppliers offer total system solutions or customized modules to retrofit existing equipment.

Prior to the application of the silicone the substrate is treated with Corona surface treatment. Corona surface treatment ensures good wetting and anchorage of the silicone on the substrate. To apply TEGO® RC Silicones a 3 or 5-roller gravure coating system is standard.

The silicone is cured by passing through a UV chamber, with nitrogen atmosphere. The UV chamber is fitted with medium pressure mercury lamps. Such units are available from several suppliers. Once the liner leaves the UV chamber the silicone is completely cured with no post-cure and the adhesives can be applied. Printing can take place prior or after the silicone coating. Converting steps, as slitting and die-cutting usually follow silicone coating.
Testing equipment and test methods are important for process and quality control. Tests can and should be run both on and off line. Evonik training can be provided to ensure your team runs these tests properly. We have also capabilities to run tests for our customers at our test facilities.

**SELECTION OF QUALITY AND PERFORMANCE TESTS**

- Oxygen analyzer to monitor the level of oxygen in the UV chamber. Level of oxygen must be under 50 ppm.
- Smear test to check if the silicone is cured.
- Rub off test to check if the silicone is rubbing or flaking off.
- Dye stain test to check coverage across the web (paper only).
- QSA – Subsequent Adhesion Test to check for curing performance.
- TESA Tape 4154-loop test to check for curing performance.
- Microscope, to check surface quality.
- TLMI & FINAT testing procedures provide detailed test method descriptions.
# GETTING STARTED – CHECKLIST FOR OPERATION AND MAINTENANCE

<table>
<thead>
<tr>
<th>SECTION</th>
<th>BEFORE PRODUCTION</th>
<th>MAINTENANCE SCHEDULE (REFER ALSO TO MANUFACTURER)</th>
</tr>
</thead>
<tbody>
<tr>
<td>TEGO® RC Silicones</td>
<td>• Start coater heating (40 to 60 °C) to control viscosity, ensure silicone mixing and charging level in holding tank during production</td>
<td>• Check shelf life of TEGO® RC Silicones components</td>
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<tr>
<td></td>
<td>• Check rollers to be clean and smooth</td>
<td>• Make sure that all rollers are freely turning down web of the silicone coater – no dragging. Dragging can cause scratches and defects</td>
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<tr>
<td></td>
<td>• Check roller speeds and nip settings depending on substrate</td>
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<tr>
<td></td>
<td>• Check silicone coating aspect</td>
<td></td>
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<tr>
<td>Coating head</td>
<td></td>
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<tr>
<td></td>
<td>• Start UV lamps</td>
<td>• Clean and replace UV lamps after lifetime</td>
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<tr>
<td></td>
<td>• Start nitrogen purging, monitor Oxygen readings to be &lt; 50 ppm</td>
<td>• Clean quartz windows and reflectors</td>
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<td></td>
<td></td>
<td>• Clean gap and blades of Nitrogen knife using plastic chim</td>
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<td></td>
<td></td>
<td>• Check water and air cooling system (filters)</td>
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<td></td>
<td></td>
<td>• Calibrate Oxygen analyzer annually</td>
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<tr>
<td>UV unit</td>
<td></td>
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<tr>
<td>Corona treater</td>
<td>• Activate for better wetting and better anchorage</td>
<td>• Clean electrodes from dust and make sure grounding roll is clean</td>
</tr>
<tr>
<td>Adhesive coating</td>
<td>• Check slot die, clean particles, check coat weight, maintain adhesive temperature as recommended by manufacturer.</td>
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</tbody>
</table>
GLOBAL PRESENCE

THE AMERICAS

Richmond, VA USA
- FAUSTEL 3 roll offset gravure coater
- ELTOSCH inerted UV unit with 2 x 160 W/cm UV lamps
- Web width 610 mm
- Substrate on 3” or 6” core
- Line speed: 25-250 m/min

EUROPE | MIDDLE EAST | AFRICA

Essen, Germany
- COATEMA 5-roll-smooth coater
- In-line silicone and adhesive coating (dispersion or hotmelt)
- IST/HOENLE inerted UV units for silicone and hotmelt curing with 1 x 200 W/cm UV lamp each
- Web width 500mm
- Substrate on 3” or 6” core
- Line speed: 20-100 m/min

ASIA | PACIFIC

Shanghai, China
- ETI 3 roll offset gravure coating line
- ETI inerted UV unit with 160 W/cm UV lamp
- Web width 336 mm
- Substrate on 3” core
- Line speed: 150 m/min

FACE-TO-FACE PERFORMANCE

OUR GLOBAL RC-SILICONE TEAM WILL ASSIST WITH
- Training and assistance in application & processing of the TEGO® RC Silicones coating
- Technical service during start-up phase and on-going production
- Utilize our wide network of contacts to equipment and machine suppliers
- Innovative developments for future challenges
- Long-term relationships based on trust

We offer training facilities and pilot coaters around the globe for adhesive trials, release compatibility trials, substrate trials, new product developments, test methods and procedures, technical questions and operator training sessions.
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