



STORAGE AND LABELLING CONDITIONS

Labelstock should be stored in its original packaging and away from strong light, at a temperature of 15 to 25 °C and a relative humidity of 50 to 55%.

Printed labels should be used within 2 years of the labelstock's date of manufacture for the adhesive to maintain the best possible properties for labelling.

Under optimal conditions, bottles would be washed and dried before labelling, their temperature above 15 °C and the relative humidity below 55%. However, these conditions are not often met, which is why UPM Raflatac has developed RP 30 and RP 40 for labelling on cold and moist surfaces.

Tests are highly recommended for all applications.

Optimal bonding time

All our wine adhesives need time to bond onto the bottle. If bottles are packaged horizontally immediately after the labelling process, optimal bonding between adhesive and glass won't be achieved.

It's also important to note that when bottles from upper rows press heavily against bottles on lower rows, the labels can still move on the glass and this can lead to creasing. 24 hours should be allowed after the labelling process before optimal bonding is achieved.

Troubleshooter

1. The label doesn't stick to the bottle

- Labelling pressure requires group applicator adjustment
- Check the smoothing of the label onto the bottle
- Check the synchronization of the dispenser and the bottling line
- Adhesive is not well adapted to the bottle surface treatment
- Printed labels have exceeded their date of expiry

2. The label stays on the backing

- Plate system/web tension not well adjusted
- Badly set dispensing tool
- Dispensing tool not well adapted
- Label shape not adapted to the labelling machine
- Backing defect due to bad storage conditions
- Release is too high
- Lack of silicone on the backing





3. Pre-dispensing problem

- Release too low
- Plate system/web tension not well adjusted
- Label with very little shape might be wound with the face side in, which is not recommended
- Printed labels have exceeded their date of expiry

4. Broken web

- Web tension too high
- Micro-tears on the sides of the roll
- Backing could be die-cut by a badly adapted die-cutting tool
- Joints not well made
- Roll too tight
- Backing too thin, or backing not well adapted
- Web width too narrow
- Silicone defects
- Speed too high
- Too much speed variation
- Clumps in the adhesive
- Web not well set in the plate system
- Dispensing plate not well adapted

5. Web doesn't stop between each label

- Matrix stripping residue between labels
- Bad detection: cleanliness, settings or transparency of the face material
- Dirty photoelectric cell

6. The label is stuck on the reverse side of the backing

- Roll has been exposed to high humidity
- Roll too tight, causing adhesive to bleed
- Ink or varnish not well polymerised

7. Creases in the label

- Label roll and bottle speed not well synchronized
- Hygrometry
- Irregularities in bottle geometry
- Worn pressure rollers (non-contact zone between the bottle and the label)

8. The label is crosswise or incorrectly aligned on the bottle

- Labels have already been printed crosswise on the web
- Bottle guide, or more likely guide on label dispenser, is unsuitable
- Labels not well centred on the web
- Parallelism not well adapted between the web and the dispensing plate

A few terms currently in use in the pressure sensitives industry

Tack

The feeling of stickiness when the surface of an adhesive is touched or when a label is applied to a surface and then quickly pulled away.

Adhesion

The state in which two surfaces are held together by chemical or physical force, or both, with the aid of an adhesive.

Release

- High-speed release – the force required to remove the label from its liner and also the liner from the label.
- Low-speed release – the force required to separate the laminate construction at an angle of 180 degrees at a speed of 300 mm per minute.

Shear

A method of separating adhesive-bonded materials by forcing the interfaces to slide over each other.