

**LG Hausys sign & graphic materials**

**Product Warranty and Installation Bulletin for LD2800  
Calendered Print Vinyl for Solvent Inkjet Printing**

**Product Description**

LD2800 is a 3.9 mil calendered print vinyl supplied with permanent pressure sensitive adhesive. It’s designed for solvent-based inkjet printing and guarantees up to 2-years of outdoor durability. The product is designed to meet high resolution printing with excellent color.

**Physical Properties**

Outdoor Durability	Up to 2 years with proper printing, lamination, and application	
Application Surface	Smooth, flat and simple curved surfaces	
Tensile Strength	≥ 1.8kg/ cm <sup>2</sup>	ASTM 882
Elongation	≥ 100%	ASTM 882
Peel Adhesion	≥ 1,200g/in	180 Peeling PSTC-1
Opacity	Tt ≤ 10	Haze Meter (Tt: Transmission)
Gloss product	60 ↑	@ 60°, in machine direction
Matte product	10 ↓	@ 60°, in machine direction
Shelf Life	1 year	Free from excessive moisture, direct sunlight

**Fabrication and Printing**

***Printing, Drying and Laminate***

Use solvent-based printing for optimal print quality. Recommended printer settings and ICC profiles are available for download at [www.lghausys.com](http://www.lghausys.com). After printing, allow the ink to properly dry at least 24 hours to 48 hours before laminating, cutting, or applying the graphic. Digital image with Saturated color (like Black, Brown etc) need to have enough time to drying before laminating.

In this case, Full drying is needed for solvents in the ink have a chance to evaporate. This process is absolutely needed which can prevent shrinkage & tunneling problems after application. Laminate with LG Hausys laminating film to prevent vinyl and/or print damage from scratches, smoke, fumes, etc.

Warranty will be applied to Finished graphic appearance defects such as excessive fading, discoloration (including that due to mildewing or wicking on flexible substrates), peeling, gloss changes, excessive

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dimensional change or loss of adhesion that makes the graphic virtually unsuitable for its intended purpose.

### Surface Preparation

1. Surface must be completely cleaned 1 day prior to product application.
2. After cleaning, completely dry off the surface to remove all moisture. To speed up drying, use lint-free cloth or paper towels that leave the surface lint and dust-free.

### Application Temperature and Environment

1. Application must be administered indoors where temperature and humidity can be controlled.
2. The optimal air and surface temperature for film application is 65°F ~ 75°F.

### Application Techniques

1. Secure film to the required position by using masking tape. Make sure to position the film with at least 2-inches from the edges of the area for application.
2. Hold up the graphic on one side first and remove only half of the release paper. Then, place the graphic on the vehicle surface and stretch it over the areas to be covered. Repeat above installation procedures for remaining portion of graphic.
3. Apply film using a felt-tip squeegee. For application on slightly curved areas, soften the film before application by using a heat gun to heat up the surrounding areas of curvature and the film to the temperature of approximately 176°F (80°C). Continuous use of the heat gun in the same spot may cause damage to the film; therefore, position of heating must be constantly changed.
4. If air bubbles remain after application, use an air release tool to remove only the large bubbles, as smaller bubbles disappear within several days when exposed to sunlight.

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5. The above instructions must be complied with to reduce the possibility of application failure or film memory problems.

### Removal

1. To remove film after use, temperature of both air and vehicle surface must be above 50°F. Removal at lower temperatures may be more difficult as the film can become brittle and/or leave adhesive residue traces.

2. Application of film to a surface where the coating has not been sufficiently hardened may cause damage to the surface. If vinyl applied in Unsound painted area or Repainted surface, It can damage the painted surface.

3. Residue remaining after removal of film can be cleaned by using solvent or a designated remover. Always test vehicle finish for solvent, cleaner, or chemical compatibility first.

4. Defects will only be recognized as a defect only on products sold as “removable” and then, when the residue remaining is more than 30%. This warranty will only apply to LG Hausys’s recommended removal methods. LG Hausys should be notified of warranty claims no later than seven (7) business days after the attempted removal.

### Not to do list

1. Don't apply on the PC (polycarbonate) surface. The adhesive reacts with PC then emit gas called Bisphenol-A. This phenomena make the bubbles, and the vinyl is unusable. Additionally the shrinkage rate of PC is more than PVC film which results in deformation Of PVC Vinyl.

2. When applying on Wood Products

: Wood absorbs moisture. it must have a thick, smooth coating of high-quality on both sides and all edges. General Wood surface (not treated with coating) can not cover moisture then drop down the adhesion level.

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This cause Edge lifting & Adhesion Failure.



< Bubble from Polycarbonate >



< Wood surface Failure >

### 3. LSE Surface

: Adhesion to plastics such as ABS, PP or rubber is always difficult. Do not decorate surfaces of this kind if you require long-life decoration. Use LD3870 for this application.

### 4. This product can be applied for partial car wrapping, but full wrapping is not recommended.

Full car wrapping, we recommend our cast Print vinyl like LD8210.

## Limitation on the Warranty

This warranty does not cover damage caused by (a) failure to follow LG Hausys's recommendations or product data bulletins (available at [www.lghausys.com](http://www.lghausys.com)) and/or (b) manufacturing, installation or removal by untrained or unqualified manufacturers, installers or technicians and/or (c) misuse, abuse, accident, vandalism, neglect or mishandling by end user or any other person and/or (d) act of god, such as earthquake, fire, flood and/or (e) war, government action and any other situation that is beyond LG Hausys's control.

This warranty does not cover damage caused by (a) failure to follow LG Hausys's recommendations, (b) mishandling by the end user, or natural disaster.

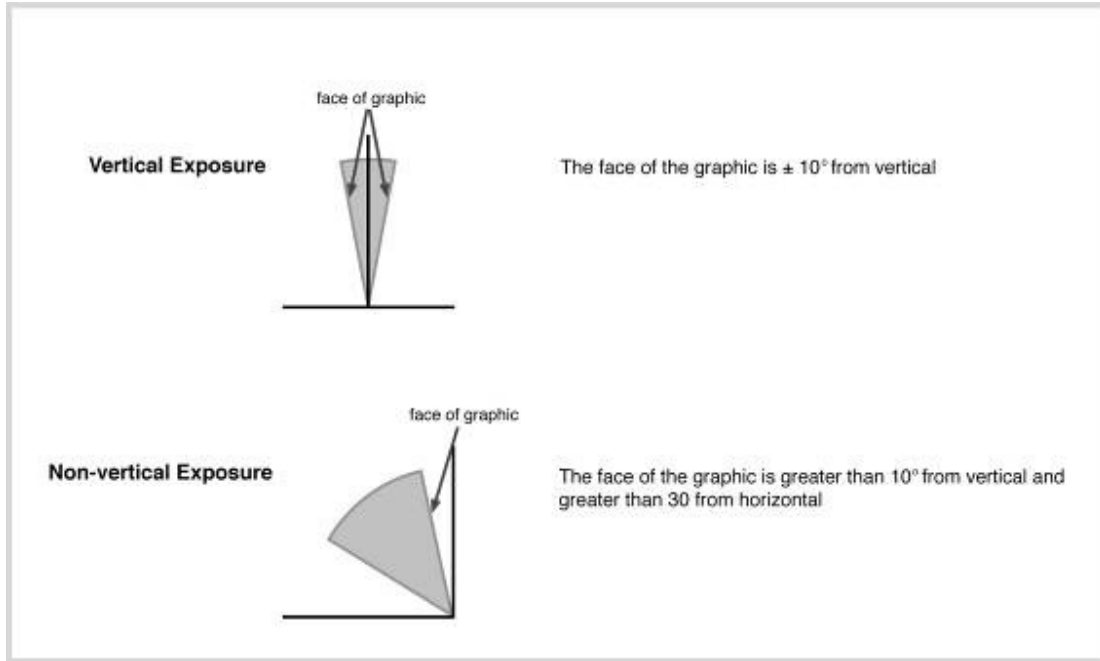
## Warranty of durability

The non vertical reduction of 20% is calculated first (Refer to the "Vertical/ Non-Vertical Exposure Conditions" below), then appropriate reduction of certain rate of reduction (Refer to the Table A.) according to the Area where the products are used (Refer to the Table B. below).

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**- Vertical/ Non-vertical Exposure Conditions :**

The Durability of Non-vertical Exposure application will be 20% less than published durability in the product Bulletin.



\* If the face of the graphic is less than  $30^\circ$  from horizontal, We generally do not guarantee the durability in any condition. Also, We don't guarantee the durability of solvents' ink.

**■ Table A :**

■ Warranty & Compensation Table						
	Area	A1		A2		A3
Warranty	P.O.U	2 Years		1.6 Years		1.2 Years
Compensation	Up to 2yr	25%	1	25%	1	25%
Rate (%)	Up to 1yr	50%	1	50%	1	50%

\* P.O.U (Period of use) \* compensation is only confined to Durability

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■ Table B :

Area	Countries
Area 1	Austria, Belarus, Belgium, Bosnia & Herzegovina, Canada, Denmark, Ecuador, Estonia, Finland, France, Georgia, Germany, Hungary, Iceland, Italy, Latvia, Lithuania, Luxembourg, Mexico, Netherlands, Norway, Poland, Romania, Russia, Slovakia, Slovenia, Sweden, Switzerland, Ukraine, United Kingdom, United States of America(Except desert areas), Uzbekistan, Vatican City
Area 2	Albania, Algeria, Angola, Argentina, Armenia, Australia, Azerbaijan, Bangladesh, Brazil, Central African Rep., Chile, China, Colombia, Congo, Costa Rica, Cyprus, ,Dominica, Dominican Republic, El Salvador, Gabon, Gambia, Greece, Guatemala, Haiti, Honduras, India, Indonesia, Ivory Coast, Jamaica, Japan, Kazakhstan, Kenya, Korea (South), Kyrgyzstan, Liberia, Malaysia, Maldives, Mali, Malta, Mozambique, Myanmar(Birma), Namibia, Nepal, New Zealand, Nicaragua, Nigeria, Pakistan, Panama, Paraguay, Peru, Philippines, Portugal, Puerto Rico, Senegal, Singapore, South Africa, Spain, Sri Lanka, Suriname, Taiwan, Tanzania, Thailand, Togo, Trinidad & Tobago, Turkey, Turkmenistan, Uganda, Ukraine, Uruguay, Venezuela, Vietnam, Zambia, Zimbabwe
Area 3	Exposed at all sites above altitudes of 1,000 meters; Australia above line Perth/Brisbane, Bahrain, Chad, Egypt, Ethiopia, Iraq, Israel, Jordan, Kuwait, Lebanon, Libya, Morocco, Oman, Qatar, Saudi Arabia, Tunisia, United Arab Emirates, Yemen

### Remedies and Limitation of Liability

For any product that does not meet the above warranty conditions, upon timely notification, LG Hausys's sole responsibility shall be, at LG Hausys's sole discretion, that LG Hausys will (a) refund the full purchase price of all LG Hausys materials used to produce the graphic, or (b) replace all LG Hausys materials consumed in the manufacture of the graphics.

The replacement graphic or materials will carry only the remaining term of the original graphic or material's warranty period.

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EXCEPT AS SPECIFICALLY STATED IN THIS WARRANTY, LG HAUSYS SHALL NOT BE LIABLE FOR ANY OTHER COST, LOSS OR LIABILITY IN ANY WAY RELATED TO THE PERFORMANCE, USE OR INABILITY TO USE ANY OF THE PRODUCTS. LG HAUSYS SHALL NOT BE LIABLE FOR ANY DIRECT OR INDIRECT OR CONSEQUENTIAL DAMAGES, INCLUDING BUT NOT LIMITED TO LOSS OF PROFIT, REVENUE OR LOSS OF BUSINESS CHANCE RESULTING FROM THE PRODUCT OR SERVICE OF LG HAUSYS.

### **Claim Procedure**

End users may contact the distributor or graphic manufacturer who may submit a claim on your behalf. Distributors or Graphic manufacturers are required to submit claims by filing such on-line at [www.lghausys.com](http://www.lghausys.com), describing the claim in detail. If you do not have internet access, call our regional Office.