

Avery Dennison[®] Instructional Bulletin 1.08

Explanation of Gloss Variance with Cast Laminating Films

Revision 1

Description

Gloss variance is a term used to describe uneven areas of high gloss typically found on cast PVC and Polyurethane films that use a PET liner. Typically this is a characteristic of soft, conformable films, and occurs when the face film is in contact with the release liner in a wound roll. There are many factors that can affect the level and severity of Gloss Variance, including:

- Heat
- Time wound in a roll
- Tightness of roll winding
- Film formulation (type and amount of plasticiser)
- Texture of release liner

How to Eliminate Gloss Variance

Gloss Variance is reversible with full gloss recovery achieved from the moment the DOL is unwound, and laminated to MPI films by using either of the below methods:

- Heat assist lamination: 40°C to 50°C
- Heat IR lamps: 40°C to 50°C
- Sunlight exposure after vehicle installation: 30°C+
- Heat with heat gun before or after vehicle installation: 40°C+

Note: Gloss Variance will also disappear when laminated material is stored overnight as a loosely wound roll or sheets, under ambient dry conditions (22°C / 50% RH). In the event of Gloss Variance persisting, full gloss recovery will occur with additional time or exposure to heat.

For further information, contact your local Avery Dennison representative.

Warranty and Limited Remedy

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The above information provides basic information on how to apply pressure-sensitive graphics. The instructions are designed to help ensure success across a broad range of applications. Depending on the size and complexity of applications, a certain amount of expertise is needed.

Professional applicators can be hired to ensure proper application of finished graphics. When mounting graphics in remote geographic areas, professional applicators can offer the added benefit of local service.

Avery Dennison has a vast network of Certified Installers who have been specially trained and certified in accordance with our recommended techniques.

You can review the Certified Installer list here: [Find a Graphics Installer](#)

Consider hiring a professional whenever the application requires:

- Multiple panels to be registered
- Complex surfaces, such as rivet and corrugated trucks
- Harsh environmental conditions (i.e. outdoor applications in high heat climates)
- Remote geographic locations

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