

ACTEGA Kelstar Technical Bulletin

Blister Pack Coating

Blister pack coating can be run either in-line or off-line. Most printers prefer off-line due to the ability to apply more coating than in-line.

The blister pack coating is unlike conventional acrylic water based coating and is formulated to function like an adhesive. Blister pack works by migrating into the stock and adhering to the paper fibers.

To run the blister pack as trouble free as possible, a few precautions should be taken.

- Proper film coating weight is the key to a successful blister pack job (refer to Calculating Coating Weight). Inconsistent or low coating film weight will add to the possibility of improper fiber tear of the blister seal from the blister board. If too much coating is applied, there could be a potential for the sheets to block in the delivery.

- Spray powder cannot be used because it causes poor intercoating adhesion of the blister seal and the blister board.

- Racking of loads is therefore recommended.

- Blister board **must** be used. Blister board allows proper penetration of the blister pack coating so a proper seal is achieved.

- Wax free or blister pack inks should be used.

If coating with blister pack for the first time, it is recommended to coat off-line. This will minimize the chances of error and having sealing problems.

Proper film coating weights are as follows:

1.6 – 1.9 lb. wet film / 1000 sq. ft. or
125,000 sq. in. / lb.

Calculate Coating Weight for In-Line or Off-Line Blister Pack Coating

- Take one foot square piece of foil; Fold in half; Tape to sheet of stock.
- Run through coater / machine
- Cut through both layers of foil with 4" x 6" board
- Weigh both pieces of 4" x 6" coated and uncoated

Example: Uncoated - .070 Grams
Coated - .130 Grams

Difference of 0.06 = 0.79 lbs. applied per thousand square feet (dry film weight) or 1.98 wet film weight.

** All weights based on 40% solids coating*

- Difference determined on Coating Weight Conversion Chart (next page)

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Coating Weight Conversion Chart

For converting wet coating weight on a 4" x 6" coated foil versus a 4" x 6" uncoated foil

Weight / Grams Difference of Foil	Lbs. / M Sq. Ft. Wet Film Weight
.030	0.99
.035	1.16
.037	1.22
.045	1.49
.050	1.65
.052	1.72
.054	1.78
.060	1.98

The wet film weight should be 1.6 to 1.9 lbs. per 1000 square feet. Preliminary testing must be conducted to establish that each specific application may be accomplished acceptably.

If too little coating is being applied, there could be potential problem of not sticking and not getting fiber tare.

Contact ACTEGA Kelstar at 856 829 6300 or info.actega.kelstar@altana.com for additional information or technical assistance.