

# Optimizing Shrink Sleeve Applications on HP Indigo Digital Presses

**Proper testing** is the most crucial step before starting production.

**Substrate Compatibility:** Not all substrates perform the same. Many PETG films have different skins, thus can perform differently when seaming through the primer. Trying different film grades and/or manufacturers may yield better results.

**Primer Coat Weight:** As a rule of thumb, a lower coat weight will make it easier to seam through the primer, allowing faster speeds and creating better bonds. On the press, use the lowest coat weight available, and consider pre-diluting the primer for even lower coat weight. (Add no more than 20% water vs. total volume.)

**Seaming Solvent:** To properly seam through the primer layer, you must ensure the solvent has enough time to penetrate through before it dries. Often, pure THF will dry too quickly and prevent seaming. Use a solvent mixed with dioxolane to lengthen drying time. You may find press-ready seaming adhesives on the market.

**Wick vs. Needle:** A wick is always preferred, as it is more effective at breaking through the primer layer and helping the solvent penetrate through it.

**Seaming Machine Speed:** When testing a new primer-film-solvent combination, start with slower machine speeds and verify seam bonds before increasing speed. Michelman’s seamable primers typically allow successful operation at speeds of 50-200 meters (150-600 feet) per minute.



APPROVED IN-LINE AND OFF-LINE PRIMERS FOR HP INDIGO WEB PRESSES

PRESS	AVAILABLE PRIMERS	IN-LINE/ OFF-LINE	SEAMABLE	SEAM STRENGTH	WATER RESISTANCE	REQUIRED PRESS MAINTENANCE
HP INDIGO 6K & 8K DIGITAL PRESSES	DigiPrime® 040	in-line	yes†	high/film tear	medium	high
	DigiPrime® 680	in-line	no	n/a	low	low
	DigiPrime® Vision 9000	in-line	yes†	low	low	medium
HP INDIGO 20K, 25K, & 200K DIGITAL PRESSES	DigiPrime® 050	in-line	no	n/a	low	low
OFF-LINE COATING EQUIPMENT	DigiPrime® Icon 8020	off-line	yes†	medium	medium	medium
	DigiPrime® Icon 8500	off-line	yes†	medium	high	medium

† When properly configured and used in combination with compatible substrates and seaming adhesives.

Need help developing a shrink sleeve application? Talk to the experts: [michelman.com/contact](https://michelman.com/contact)

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