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## Technical Data Sheet

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### Product Description

Coats Signal C502 600 is a premium quality retro reflective heat transfer designed for tough industrial laundry conditions including tunnel dry at 160°C. When illuminated by a light source, it helps to enhance the visibility in nighttime or difficult weather conditions.

### Product Construction

Coats Signal C502 600 is made of high performance glass beads laminated on a durable polymer layer and a heat reactive adhesive is applied on the back side. The reflective side and the adhesive side of the film are protected by a liner. The daytime colour is silver and when illuminated by light the reflected colour is white.

### Areas of Applications

Coats Signal C502 600 is a retro reflective heat transfer with heat reactive adhesive for all high visibility industrial wash applications such as apparel and accessories, workwear and uniforms where EN ISO 20471 certification is required. Coats Signal C502 600 is suitable for woven fabrics made from cotton, polyester, etc. The heat transfer should be applied on a flat surface with the help of uniform heat and pressure for example a transfer heat press or continual belt heat press. Other methods such as heat fusing or high frequency welding can also be used. Tests should be done ahead of bulk production to determine which process suits best for the application.

### Product Certification

#### Reflective Performance – EN ISO 20471:2013

Coats Signal C502 600 is tested according to EN ISO 20471 high visibility standard. It delivers maximum retro reflective performance. The typical reflective performance (RA in cd/lux/m<sup>2</sup>) according to EN ISO 20471, table 4 is shown below.

Observation angle	Entrance angle	Coats Signal C502 600	Minimum norm requirement
12'	5°	500	330

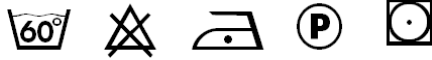
### Article Number / Make-up

Art. No.: C502 600 / width: 50.8mm (±0.8) - roll of 200 m

Art. No.: C502 600 / various widths available

## Care Instructions

### Domestic Wash



### Industrial wash

- Maximum wash temperature: 75°C
- Tumble dry: 90°C
- Tunnel dry: 160°C
- Use low alkaline surfactant detergent, do not use sodium hydroxide or potassium hydroxide containing detergents, lower pH near to neutral is recommended
- Do not use solvenated surfactants
- Do not use perborate based bleaching
- Soak soap for less than 15 min.

### Physical Performance

Coats Signal C502 600 meets or exceeds in origin the performance as per EN ISO 20471, clause 6.1 as well as the requirements in clause 6.2 after exposure to abrasion, flexing, folding at cold temperature, temperature variation, washing, dry cleaning and influence of rainfall. The following table shows the detail specifications.

Tests	Details
Retro reflective performance in origin	EN ISO 20471:2013, pt. 6.1, table 4 and 5 Test method: CIE 54.2
Retro reflective performance after pre-treatment	EN ISO 20471:2013, point 6.2, table 6 Test method: CIE 54.2
Abrasion	EN ISO 12947-2:2007, 9 kPa, wool, 5000 cycles
Flexing	EN ISO 7854:1997, method A, 7500 cycles
Folding at cold temperature	ISO 4675, (-20 ±2)°C
Temperature variation	EN ISO 20471:2013, pt. 7.4.4, 12 hours @ (+50±2)°C & 20 hours @ (-30±2)°C
Domestic wash 60°C	EN ISO 6330:2012, method 6N+F, 100 cycles
Domestic wash 90°C	EN ISO 6330:2012, method 9N+F, 50 cycles
Industrial wash 75°C with tumble dry at 90°C and tunnel dry at 160°C	EN ISO 15797:2004, method 8 with tumble dry (90°C) and tunnel dry (160°C), 50 cycles
Dry clean	EN ISO 3175-2:2010, perchloroethylene, 50 cycles
Influence of rain	EN 20471:2013, annex C

## Lamination

For heat lamination, first remove the blue liner on the adhesive side to expose the dry adhesive, do not remove the liner on the reflective side at this stage. Place the heat transfer on the surface with the adhesive side down. The recommended temperature for lamination is 140°C-160°C with approx. 4-5 bar line pressure for a duration of around 15-20 seconds. For heat press, the pressure should be even. After lamination, allow the application to cool to room temperature and remove carefully the liner on the reflective side. It is recommended that continuous testing should be done to ensure acceptable adhesion. All high visibility garments should be made according to proper standards.

## Storage

Coats Signal reflective tapes should be stored in a cool and dry place with low humidity. The used rolls should be returned back to original packaging or suspended from the middle by using a rod.

## General Safety Information

Since conditions and applications vary considerably in the use of a product, the customer and/or user should assure herself or himself that the product meets end customer requirements and is suitable for the intended end use. Coats accepts no liability for unsuitable or improper use or application of products.

Information provided above is based on current averages and should be taken only as indicative. Coats accepts no liability for the preciseness and correctness of the information provided.

Product information sheets are updated from time to time, please be sure you are referring to the most recent publication. Coats supports customers with advice on individual applications on request; if you have any questions or concerns, please contact us. Coats Signal cannot guarantee an absolute visibility especially in severe weather conditions.

## Further Assistance

Please contact your local Coats representative for further assistance.