

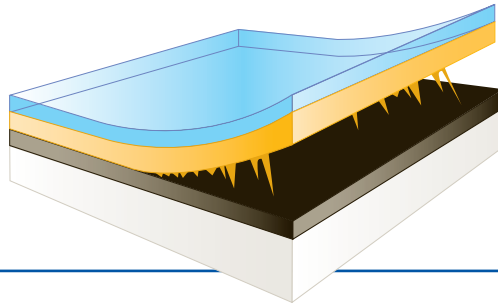
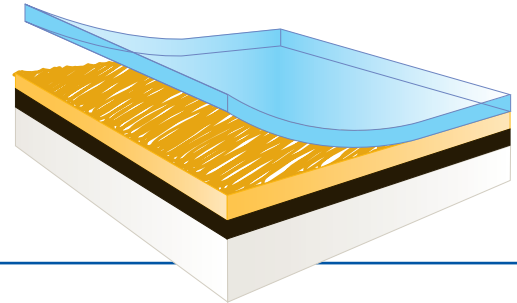
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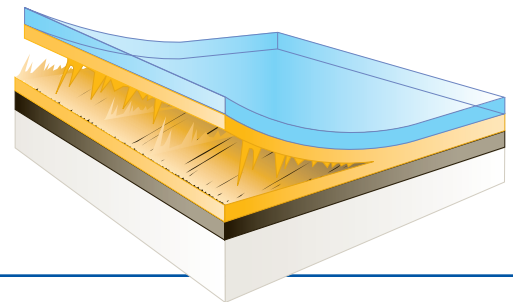
**Adhesion Failure To Upper Substrate**

- Upper substrate comes off clean.
- All adhesive stays on the lower substrate.



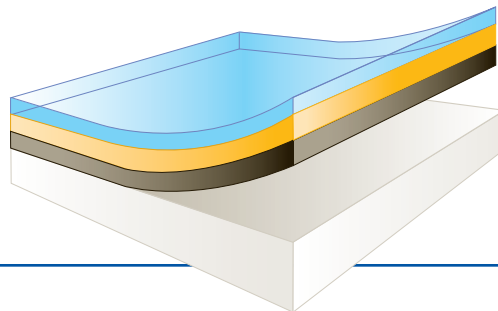
**Adhesive Failure To Ink**

- Adhesive stays with the upper substrate.
- No adhesive residue on lower substrate.



**Adhesive Shear Failure**

- Some adhesive stays with the upper substrate.
- Some adhesive stays with the lower substrate.
- Adhesive internal strength was exceeded.

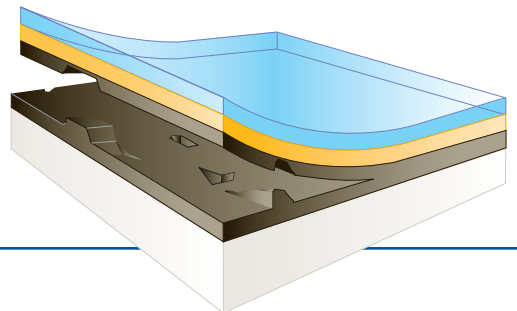


**Ink Anchorage To Core Failure**

- Adhesive and ink remains with the upper substrate.
- Adhesive was able to separate layers below it.

**Ink Shear Failure**

- Some ink stays with the upper substrate.
- Some ink stays with the lower substrate.
- Ink internal strength was exceeded.



**Combination Of All Failures**

- Peel is inconsistent with high and low values.
- Records chattering and zippering effect during peel test.
- No one single interface is the weakest link.

