

UV Polyacrylic Clear Matt By Spray

Product code: E/236X

Color: Transparent

Finish: Matt

Composition and Application Field

Clear polyacrylic product UV drying, applying as top-finish with spraying machine (robot and automatic system), on flat substrates, previously treated with UV basecoat of the same nature. It is endowed with very good distension, film uniformity, hardness and scratch-resistance.

Available in the following versions

E/2360	6±1% Gloss
E/2361	12±3% Gloss
E/2362	30±5% Gloss
E/2363	50±5% Gloss
E/2364	70±5% Gloss

Product Preparation

Dilution

With E/694 or E/692 or E/693 at 10-15% until to reach the working viscosity of 16-18 Sec Cup No 4 / usually it comes ready to use no need to add any photo initiator.

Technical Characteristics

Physical Properties

Specific gravity	0.98	(± 0,025) Kg/l
* Visc. Ford	25	(± 3) Sec.
4/@ 25°C		
Weight solids	45%	(± 2) Kg/Kg
Weight solids blended	-	(± 2) Kg/Kg
Flash Point	21	grades
		centigrade

(Abel Pensky closed cup)

Application Rate 100-110 gr/m² (per coat)

N.B: Only 1 coat is required.

Drying

The product must be dried under high pressure UV lamps, after almost 15 to 20 min of flash-off under air and TL lamps if available, and if not normal tunnel is required. The number of the lamps, the line speed and the flash-off are in according with the UV line. The varnishing cycle, the substrate and in general with the working conditions. Normally in UV tunnel with 2 or 3 UV lamps 80 W/sq cm with exposition of 7-8 Sec, the completely drying of the product ready for use is obtained with a line-speed of 10-12 m/minute. Considering a lot of possibility to use and variables that can have effect on drying, contact our technical Department for more information and clarifications.

Dry Film Characteristics

Mechanical Characteristics

Adherence	Very Good (on sanded substrates)
Plasticity	Very Good
Transparency	Very Good
Hardness	Very Good

Surface Preparation

Sand very well the substrate already treated with UV basecoat applied by roller or curtain or spray, without leave any sanding residues, before to apply the UV top-finish. The way to prepare the substrate with the UV basecoat, determine the final result, for this reason do a good basecoat treatment.

Application Method

The product must be applied by spray machine after added the photo initiator and the thinner if needed (our material usually comes ready to use only 5 to 10% of thinner is required) to control the viscosity and drying. Use only automatic spray equipments and do not use manual spray gun.

Subsequent Treatments

After drying the top-finish does not need any subsequent treatment and can be stacked and packaged.

Note

In case of eventually varnishing cycle on non-wooden substrates (paper, laminate etc.), they must be insulating with proper primer to improve the adhesion. Do not apply on substrates with moisture content up to 14-15%. Do not apply in environment with temperature below to 15°C or up to 30°C. Keep controlled the quantity of product applied, to maintain the gloss value as the same level. In case of bubbling on film applied, contact our Technical Department that will suggest a proper additive. Verify periodically the functionality of the UV lamps. Starting to varnish new substrates never used, do preliminary test to verify the varnishing cycle.

Packing

Available in 25ltr.

Storage

If the drum is hermetically closed and well stored at 25°C, the product and the additives have six months of shelf-life. For material already included the photo initiator additive the shelf life of the product is 6 month Use before the expiry date indicated on labeling.