

Multi-Cure® 706-H Acid Strip and Thermal Spray Coating Mask with Heat Cure

APPLICATIONS

- Acid Stripping
- Air Plasma Spray
- Machining

FEATURES

- UV Light Curing
- Secondary Heat Cure
- Resists Acids
- High Adhesion
- Hard / Durable
- Thixotropic Gel
- High Viscosity

RECOMMENDED SURFACES

- Nickel Alloys
- High Temperature Steel

SPEEDMASK® 706-H UV curable masking resin is formulated to provide excellent surface and internal cavity protection during acid stripping, air plasma strap operations of turbine components during acid stripping, APS coatings, and machining operations. This resin is specially formulated to cure with heat in applications where shadowed areas exist. **SPEEDMASK®** resins contain no nonreactive solvents and cure upon exposure to light. Their ability to cure in seconds enables faster processing, greater output, and lower manufacturing costs. When cured with DYMAX light curing spot lamps, focused beam lamps, or flood lamps, they deliver optimum speed and performance for many masking applications. DYMAX lamps offer the optimum balance of UV and visible light for the fastest, deepest cures. This product is in full compliance with the RoHS Directives 2002/95/EC and 2003/11EC.

UNCURED PROPERTIES *

Property	Value	Test Method
Solvent Content	No Nonreactive Solvents	N/A
Chemical Class	Acrylated Urethane	N/A
Appearance	Clear Translucent Gel	N/A
Soluble in	Organic Solvents	N/A
Density, g/ml	1.07	ASTM D1875
Viscosity, cP (20 rpm)	30,000 nominal	ASTM D2556

OTHER CURED PROPERTIES *

Property	Value	Test Method
Boiling Water Absorption, % (2 hr)	1.9	ASTM D570
Water Absorption, % (25°C, 24 hr)	0.4	ASTM D570
Linear Shrinkage, %	0.8	ASTM D2566

CURED MECHANICAL PROPERTIES *

Property	Value	Test Method
Durometer Hardness	D75	ASTM D2240
Tensile at Break, MPa [psi]	54 [7,900]	ASTM D638
Elongation at Break, %	3.8	ASTM D638
Modulus of Elasticity, MPa [psi]	900 [130,000]	ASTM D638

* Not Specifications

N/A Not Applicable



CURING GUIDELINES

Cure rate is dependent upon many variables, including lamp intensity, distance from the light source, and required depth of cure. The cure times below are based on lab results and are intended for reference only. Testing was performed using a 0.38 mm [0.015 in] coating thickness. Time/belt speed was determined by a complete, tack-free cure.

DYMAX Curing System (Intensity)	Cure Time or Belt Speed
2000-EC (50 mW/cm ²) ^A	30 sec
5000-EC (200 mW/cm ²) ^A	20 sec
BlueWave® 200 (10 W/cm ²) ^A	2 sec
Porta Ray 400 (400 mW/cm ²) ^A	5 sec
UVCS Conveyor with Fusion F300S (2.5 W/cm ²) ^B	6.1m/min [20 ft/min]

A Intensity was measured over the UVA range (320-395 nm) using a DYMAX ACCU-CAL™ 50 Radiometer.

B At 53 mm [2.1 in] focal distance. Maximum speed of conveyor is 8.2 m/min [27 ft/min]. Intensity was measured over the UVA range (320-395 nm) using a DYMAX ACCU-CAL™ 100 Radiometer.

SECONDARY HEAT CURE

Heat can be used as a secondary cure mechanism where the resin cannot be cured with light. The following heat cure schedule may be used:

Temperature	Time*
110°C [230°F]	60 minutes
120°C [250°F]	30 minutes
150°C [300°F]	15 minutes

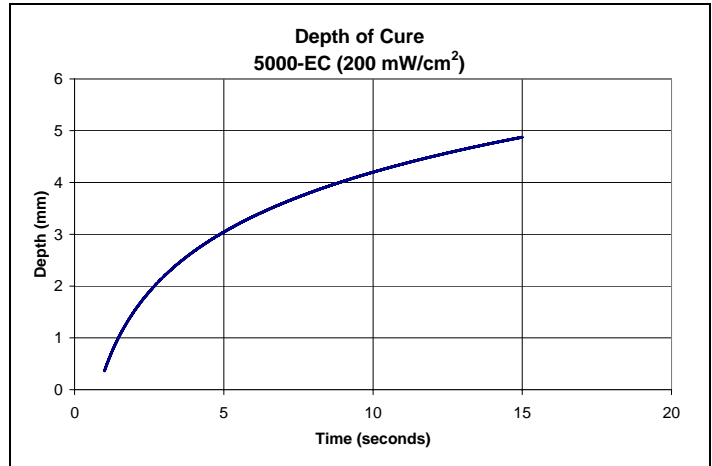
*Note: Actual heat cure time may vary due to part configuration, volume of mask applied, and oven efficiency.

Full cure is best determined empirically by curing at different times, intensities, and temperatures, and measuring the corresponding change in cured properties such as tackiness, adhesion, hardness, etc. Full cure is defined as the point at which more light or heat exposure no longer improves cured properties. Higher intensities or longer cure times (up to 5x) will generally not degrade DYMAX light curing masks.

DYMAX recommends that customers employ a safety factor by curing longer, at higher intensities, and/or at higher temperatures than required for full cure. Although DYMAX Applications Engineering can provide technical support and assist with process development, each customer must ultimately determine and qualify the appropriate curing parameters required for their unique application.

DEPTH OF CURE

The graph below shows the increase in depth of cure as a function of exposure time. A 9.5 mm [0.37 in] diameter specimen was cured in a polypropylene mold and cooled to room temperature. It was then released from the mold and the cure depth was measured. These depths are only due to light cure.


OPTIMIZING PERFORMANCE AND HANDLING

1. This product cures with exposure to UV light, and heat. Exposure to ambient and artificial light should be kept to a minimum before curing. Dispensing components, including needles and fluid lines, should be 100% light blocking, not just UV blocking.
2. All surfaces to be masked should be clean and free from grease, mold release, or other contaminants prior to dispensing the resin.
3. Oxygen in the atmosphere may inhibit surface cure. Surfaces exposed to air may require higher intensity UV (> 100 mW/cm²) to produce a tack-free cure. Flooding the bond area with an inert gas, such as nitrogen, can also reduce the affects of oxygen inhibition.
4. Part should be allowed to cool after cure before testing.
5. Light curing generally produces some heat. If necessary, cooling fans can be placed in the curing area to reduce the heating effect on components.
6. At the point of curing, an air exhaust system is recommended to dissipate any heat and vapors formed during the curing process.

DISPENSING THE RESIN

This material may be dispensed with a variety of manual and automatic applicators, or other equipment as required. Questions relating to dispensing and curing systems for specific applications should be referred to DYMAX Applications Engineering.

STORAGE AND SHELF LIFE

Store the material in a cool, dark place when not in use. Do not expose to light. This product may polymerize upon prolonged exposure to ambient and artificial light. Keep covered when not in use. This material has a one-year shelf life when stored between 10°C [50°F] and 32°C [90°F] in the original, unopened container.

CLEAN UP

Uncured material may be removed from dispensing components and parts with organic solvents. Cured material will be impervious to many solvents and difficult to remove. Clean up of cured material may require mechanical methods of removal.

GENERAL INFORMATION

This product is intended for industrial use only. Keep out of the reach of children. Avoid breathing vapors. Avoid contact with skin, eyes, and clothing. Wear impervious gloves. Repeated or continuous skin contact with uncured material may cause irritation. Remove material from skin with soap and water. Never use organic solvents to remove material from skin and eyes. For more information on the safe handling of this material, please refer to the Material Safety Data Sheet before use.

RECOMMENDED DYMAX LITERATURE

LIT010A	Guide to Selecting and Using UV Light Curing Systems
LIT013	<i>SPEEDMASK[®]</i> Selector Guide
LIT077	Chemical Safety
LIT133	UV Light Curing System Safety Considerations
LIT159	ACCU-CAL [™] 50 Radiometer
LIT172	Porta Ray 400 UV Curing System
LIT206	Flood and Focused Beam UV Light Curing Systems
LIT218	BlueWave [®] 200 UV Light Curing Spot Lamp

Literature is available at www.dymax.com or by calling any DYMAX location.

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