InstaCure SuperFlex Technical Data Sheet

InstaCure SuperFlex is an extremely flexible, 100% solids UV curable clear coat specially formulated for use on applications requiring extreme elongation like vehicle wraps and thermo formable applications. InstaCure SuperFlex is available in Clear Gloss, Satin Matte and Translucent White (ICUVSFG, ICUVSFSM and ICUVSFTW).

Typical Applications

Typical applications include coating printed-on plastics used in vacuum forming, casting, vehicle wraps and flexible banners. InstaCure SuperFlex exhibits outstanding adhesion to recommended substrates and ink systems during and after elongation and performs well in all cutting/trimming applications.

InstaCure SuperFlex comes pre-mixed and is intended for use undiluted in reverse roll coaters with a smooth applicator roll.

InstaCure SuperFlex is NOT compatible with most aromatic solvent cleaners, so care should be taken to follow specific cleaning recommendations for coated graphics.

Recommended Substrates

- Acrylic
- Aluminum
- High Impact Polystyrene (HIPS)
- PETG
- Polystyrene
- Polycarbonate
- PSV (Cast and Calendared)
- PVC (Mesh & Scrim)

Recommended Printer/Ink Systems:

- Traditional Eco Solvent based Inks
- Traditional Solvent based inks
- Traditional Screen Print Ink systems
- Digitally printed UV curable ink systems
- HP Latex Inks/Prints

Performance Properties

- Extreme elongation for draw depth, greater than 6x
- Multiple pass heat bending without chipping
- Excellent intercoat adhesion (layer to layer)
- Superb water and moisture resistance
- Good resistance to non-aromatic cleaners (see list of recommended cleaners)
- Flexible for multi-layer applications and die-cutting
- Satin Matte provides excellent primer surface for anchoring ink to and improving overall print quality
- Can be routed or die-cut without chipping
- Excellent mar and scratch resistance after full cure (24 hours)

Coating & Equipment Compatibility

DocuMate	PhotoMate	Multi Pro	XL
N	N	Y	Y

Coating Instructions:

While this coating is supplied in press ready condition it should be mixed well prior to use each time. Adjust flow rate for medium flow out where approximately ½-inch of bead forms between rolls.

Optimal temperature for this coating is 65-90°F (18-30°C). At lower temperatures the coating will have heavier viscosity and will not flow properly. Allow at least a 10 to 15 minute warm up period (with coating flowing) prior to use.

Curing Instructions (for use in VersaCoater XL)

The coating will cure well when applied between 8 and 10 microns* per pass, at curing speeds of up to 70 linear feet (21 meters) per minute. The following settings are recommended starting points:

Starting Point	Top Roll	Bottom Roll	Pinch Pressure	Cu Lamp	Cu Speed
Gloss	40	60	60 psi	150	65
Satin Matte	40	60	60 psi	250	65
Trans White	60	50	45 psi	250	55

When properly cured, final film properties (scratch and chemical resistance) are available immediately after polymerization with exposure to UV at between 150 - 170mjs/cm.

If a loss of gloss or adhesion due to insufficient cure is noticed, slow down the curing unit, or increase the lamp power and speed, not to exceed 80 feet (24 meters) per minute.

Typical Coverage
3,200 to 3,600 square feet (297-334 square meters) per gallon based on lay down between 8-10 microns* dependant on substrate and absorption conditions.

Light Fastness
This product DOES contain UV Inhibitors; however, use of this product may not appreciably affect light-fastness of the printed product. It will protect the ink from exposure to many elements that tend to degrade inks faster, such as water, moisture, air and dust contaminants, abrasion and scratching.

We recommend that you contact your ink manufacturer to obtain base durability information and conditions affecting durability for the inks you are using.

Storage
Care should be taken to store the coating in tightly closed containers located in a cool, dark place (60-80°F/15-27°C). With suitable conditions, unopened coating is expected to have a shelf life of approximately 12 months from date of manufacture.

Clean Up
Use Drytac Press Wash or similar acetone based screen press washes safe for use on EDPM rubber rollers for clean up. If in doubt, contact Drytac to be certain your coater has polypropylene hoses before use of Press Wash.

1) Turn off pump.
2) Bring rollers together and engage scraper to reduce amount of coating on roller to minimum.
3) Capture excess coating back into supply pail and remove. Replace coating supply with 1.5 gallons of press wash.
4) Turn pump back on and run for at least 5 minutes.
5) Turn pump off. Slowly pour remaining ½ gallon of press wash directly between rollers and let run until out.
6) Let drain, then replace press wash with 99% Isopropyl Alcohol (IPA).
7) Turn pump back on and run 5 minutes. Return to normal cleaning procedure.

Note: Be sure to return all air pressure settings to normal before beginning to clean the coater.

Please consult Drytac Technical Service for further information 1-800-280-6013

Recommended Cleaners for use on coated graphics: (only after 48 hour cure time)

Soap & Water	De-Solv-It	Formula 409
Turpentine	Mineral Sprits	Fantastic
WD 40	Krud Kutter	99% IPA *
Goof Off *	MEK**	Acetone **

* Prolonged contact may soften coating
** Not recommended

Precautions
Read the material safety data sheet prior to processing. It contains instructions for precautions when handling clear coats. If clear coat comes in contact with skin, wipe clear coat off with a clean, dry cloth (do not use solvent). Wash and rinse the affected area with soap and water.

NOT ALL COATERS ARE EQUIPPED TO HANDLE COLORED OR NON STANDARD COATINGS. CONSULT YOUR COATER MANUFACTURER PRIOR TO USING ANY COLORED CURABLE COATING.

We strongly recommend a preliminary test of printing and curing on the substrates intended for use, in order to ascertain the exact procedure, the working times and the obtained affect. Follow the indications on the package, ask for the safety data sheets and always follow the indications contained therein.

IMPORTANT

Only the correct use of the product will allow satisfactory results. For this reason, Drytac is not responsible for the improper use of the product, either by the substrate applied to or application. Make certain that product is right for the desired use and works according to the instructions given in our technical data sheets. If in doubt of the appropriate application methods or use, contact Drytac at one of the phone numbers listed below.

**Note:* *25 microns equal 1 mil*