

InstaCure Primer Coat Clear Technical Data Sheet

InstaCure Primer Coat Clear is a semi flexible, 100% solids UV curable printable clear coat. Its formulation allows it to be used as both a primer coating onto substrates like glass, polyolefin, PET-G and other low surface energy substrates, or as a top coat. This product exhibits excellent clarity, mar and scuff resistance and has excellent resistance to blocking. InstaCure Primer Coat Clear is available in Clear Gloss only. (ICUVPCC).

Typical Applications

Typical applications include priming hard to print to substrates such as plastics, poly based materials and glass prior to printing. InstaCure Primer Coat should be used on more rigid based products as its flexibility is limited. Clear exhibits outstanding adhesion to recommended substrates and ink systems during and after elongation and performs well in all cutting/trimming applications.

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

InstaCure Primer Coat Clear 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
- Glass
- High Impact Polystyrene (HIPS)
- PETG
- Polystyrene
- Polycarbonate

Recommended Printer/Ink Systems:

- Traditional Screen Print Ink Systems
- Digitally printed UV curable ink systems

Performance Properties

- Printable
- Low viscosity and excellent flow out
- Excellent intercoat adhesion (layer to layer)
- Superb water and moisture resistance
- Good resistance to non aromatic cleaners (see list of recommended cleaners)
- 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, every 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 temps 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 at between 8 and 10 microns* per pass, at curing speeds of up to 70 linear feet (21 meters) per minute. 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

When properly cured, final film properties (scratch and chemical resistance) are available within 24 hours of 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

4000 to 4500 square feet (371-418 square meters) per gallon based on lay down of between 8-10 microns* dependant on substrate and absorption conditions.

Light Fastness

This product DOES NOT contain UV Inhibitors, it will however 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 (60-80°F/15-27°C) dark place. With suitable conditions, unopened coating is expected to have a shelf life of approximately twelve (12) months from date of manufacture.

Clean Up

Use high percentage isopropyl alcohol (above 91%) or other fast evaporating washes safe for use on EDPM rubber rollers for clean up. If in doubt, contact Drytac to be certain your cleaner will not harm the rollers.

- 1) Turn off pump.
- 2) Bring rollers together and engage scraper to reduce amount of coating on roller to minimum.
- 3) Introduce IPA to coating roller and let run for at least 5 minutes. Note: Coating will not cure unless it is exposed to hi intensity UV light so there is no need to clean after each use unless going between coating types that may otherwise contaminate the coating.

- 4) Turn pump back on and run for at least 5 minutes.

Note: Be sure to return all air pressure settings to normal before beginning to clean the coater and don't forget to SEPARATE ALL ROLLER SURFACES before turning off machine

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

Recommended Cleaners for use on coated graphics: (only after 48 hr 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 exactly the 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 application or substrate applied to. Make certain that product is right for the desired use, work 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*