

E-MAX 776-SC

Heat-Resistant, See-Cure, Moderate-Adhesion Protective Mask

APPLICATIONS

- Plating
- Decorative Etching and Anodizing
- Powder Coating
- Part Handling
- Air Plasma Spray
- Grit Blasting

FEATURES

- Blue-to-Pink upon Sufficient Exposure to UV/Visible Light
- UV/Visible Light Cure
- Excellent Surface Protection
- Fast Curing
- Easy Peel-Off after Exposure to Heat
- Spray or Dip

RECOMMENDED SURFACES

- Nickel Alloys
- Steel
- Stainless Steel
- Aluminum
- Titanium
- Cobalt
- Glass

E-MAX 776-SC is formulated to provide excellent surface protection of turbine and metal components during many plating, decorative etching and anodizing, air plasma spray, blasting, and powder-coating processes. The blue transitions to pink upon exposure to sufficient light energy indicating full cure has been achieved. E-MAX 776-SC also has the ability to remain flexible at higher temperature processes up to 204°C [400°F]. This resin cures quickly and is easily removed after processing. A hot-water soak may be used to ease removal. When properly cured, E-MAX 776-SC leaves no residue on the surface. Dymax resins contain no nonreactive solvents and cure upon exposure to light. Their ability to cure in seconds enables faster processing, greater output, and lower processing 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 RoHS directives 2015/863/EU.

UNCURED PROPERTIES *

Property	Value	Test Method
Solvent Content	No Nonreactive Solvents	N/A
Chemical Class	Acrylated Urethane	N/A
Appearance	Blue Translucent Gel	N/A
Soluble in	Organic Solvents	N/A
Density, g/ml	1.12	ASTM D1875
Viscosity, cP (20 rpm)	52,000 (nominal)	ASTM D2556

OTHER CURED PROPERTIES *

Property	Value	Test Method
Appearance	Pink Translucent Solid	N/A
Boiling Water Absorption, % (2 hr)	11	ASTM D570
Water Absorption, % (25°C, 24 hr)	20	ASTM D570
Linear Shrinkage, %	2	ASTM D2566

CURED MECHANICAL PROPERTIES *

Property	Value	Test Method
Durometer Hardness	D40	ASTM D2240
Tensile at Break, MPa [psi]	6.8 [980]	ASTM D638
Elongation at Break, %	160	ASTM D638
Modulus of Elasticity, MPa [psi]	3.9 [560]	ASTM D638

* Not Specifications
N/A Not Applicable



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CURING GUIDELINES

The blue color of this Dymax See-Cure resin transitions to pink when it is fully cured. Full cure is achieved when additional light exposure does not improve the cured properties. The chart below provides information on how long it takes to complete the transition from blue to pink, using different light sources. Cure rate is dependent upon many variables, including lamp intensity, distance from the light source, and required depth of cure. The times and belt speed for the transition listed 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 and transition from blue to pink.

Dymax Curing System (Intensity)	Time or Belt Speed to Complete Transition from Blue to Pink
5000-EC (200 mW/cm ²) ^A	8 s
BlueWave® LED PrimeCure (575 mW/cm ²) ^B	12.5 s
BlueWave® 200 (10 W/cm ²) ^A	1 s
Porta-Ray® 400 (400 mW/cm ²) ^A	5 s
UVCS Conveyor with Fusion F300S (2.5 W/cm ²) ^B	3.7 m/min [12 ft/min]

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

B Intensity was measured over the UVA/Visible range (350-450 nm) using a Dymax ACCU-CAL™ 50-LED Radiometer.

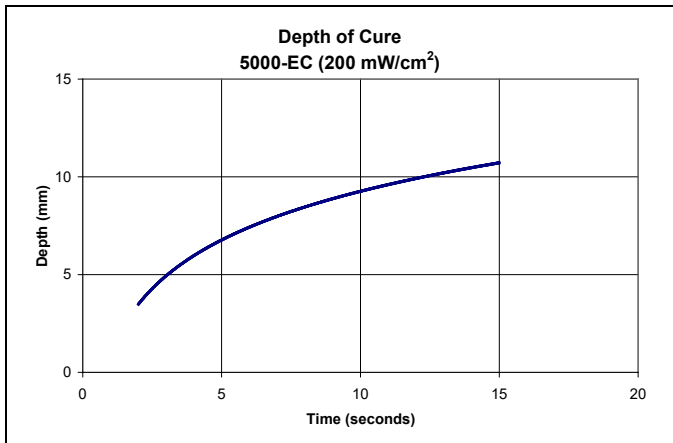
C At 53 mm [2.1 in] focal distance. Maximum speed of conveyor is 8.2 m/min [27 ft/min]. Intensity was measured over the UVA range (320-395 nm) using a Dymax ACCU-CAL™ 100 Radiometer.

Full cure is best determined empirically by curing at different times and intensities. Full cure can also be determined by measuring cured properties such as tackiness, adhesion, hardness, etc. Higher intensities or longer cures (up to 5x) will generally not degrade Dymax light-curable masks.

Dymax recommends that customers employ a safety factor by curing longer and/or at higher intensities and/or temperatures than required for full cure. Although Dymax Application 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.



OPTIMIZING PERFORMANCE AND HANDLING

1. This product cures with exposure to UV and visible light. 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 mask.
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 effects 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 Application 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 12-month shelf life from date of manufacture, unless otherwise specified, when stored between 10°C (50°F) and 35°C (90°F) in the original, unopened container.

CLEANUP

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. Cleanup 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 Safety Data Sheet before use.

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