



## Technical Bulletin

### *Hard Coat Clears* UV Curable Screen Printing Ink

Effective 07.06.2007

Polymeric Imaging Inc.'s abrasion-resistant clear coatings are specifically formulated as a protective finish for interior decorative trim as well as electronic instrument panels. These clears offer unique film properties to overprint UV and conventional ink systems and provide a finish ranging from high-gloss or water-white to velvet or highly textured satin.

The over-printed graphic will have a durable finish with outstanding mar, abrasion, and chemical resistance. Other decorative prints may be screened directly onto this product with excellent adhesion characteristics. These clear coatings have tremendous thermal stability not commonly found among UV coatings.

- Adheres well to polycarbonate, PVC, ABS, PETG, and most other rigid plastics.

#### **APPLICATION:**

|                        |   |
|------------------------|---|
| <b>Mixing</b>          | Clear coats are supplied at screen print viscosity and can be used directly from the container. Thinning is not recommended.<br>For spray applications, dilute with isopropyl to proper viscosity. Roller coatings reduce with xylol. Prior to cure, flash off the solvents with infrared lamps.              |
| <b>Mesh</b>            | <ul style="list-style-type: none"> <li>• 390 to 420 plain weave (150-165 cm) for gloss hard coats</li> <li>• 305 plain weave (120 cm) for textured satins</li> </ul>  |
| <b>Squeegee</b>        | Sharp 60 to 80 durometer polyurethane blade   |
| <b>Cure Parameters</b> | 1-300 watt per inch medium pressure mercury vapor lamps<br><br>Prior to cure, a finer texture and lower gloss may be achieved by subjecting the printed surface to radiant heat of approximately 150°F to 185°F for five to ten seconds. This time may vary depending on individual manufacturing techniques. |
| <b>Belt Speed</b>      | 40 feet per minute (12 m/min)   |

#### **Available as:**

- 1945 Hard Coat Satin Clear
- 2278 Hard Coat Air Texture Clear
- 4506 Hard Coat Matte Clear
- 4693 Hard Coat Texture Clear
- 12236 LV Hard Coat Air Texture Clear

#### **Similar to:**

GE 8A13F  
GE8A13  
GE 8B35  
GE 8A35  
GE 8A13

*More than a shade superior*