TECHNICAL DATA SHEET
F-19293 WESSCO® 3704 UV-Coating HIGH-GLOSS

Viscosity 60s DIN #4, 27.5s Zahn #3, 280 CPS

Suitable for gluing or foil stamping, high reactivity
Solvent-free, UV-curable high-gloss coating for inline processing with GALACRYL Primer on conventional printing inks for finishing paper, board and plastic film.

Not suitable for coating of food stuff and other sensitive packaging. This applies for secondary packaging too, unless a barrier avoids migration of substances to the content. Before the finished secondary packaging is brought into circulation corresponding migration tests shall be conducted.

For sheet-fed press with coating unit. In-line application.

1. Application
   - Packaging
   - Commercial printing

2. Product Properties
   - low odor
   - high reactivity
   - liquid
   - solvent-free (100% system)
   - colorless
   - light sensitive
   - heat sensitive

3. Properties of the finished product
   Even, smooth and high gloss appearance:
   - suitable for gluing
   - suitable for foil stamping
   - high degree of refinement
   - high scuff resistance
   - high chemical resistance
   - can be further processed immediately
   - suitable for folding and creasing, depending upon substrate
   - can be recycled with de-inking process

4. Technical Data
   - Solid content 100%
   - Flashpoint >100°C (212°F)
   - Viscosity 23°C (73.4°F)
     - DIN #4 Cup: 60 ± 5s
     - Zahn #3 Cup: 27.5 ± 4s
     - Centipoises: 280 CPS
   - Reactivity per lamp 80 W/cm (200 W/inch) reference value
     - (200 W/inch) reference value (270 f/min)

5. Further Processing
   Preliminary tests are imperative!
   - Gluing:
     - do not print on/over gluing flaps
     - do not use water based primer on gluing flaps
     - test glue first for suitability
   - Foil stamping:
     - check adhesion of coating
     - maintain constant application of coating
     - check foil for suitability
     - blocking parameters: optimize power, time and temperature
   - Coating preparations:
     - Stir very well before use.
     - Check machine for cleanliness.

6. Coating preparations
   - Stir very well before use.
   - Check machine for cleanliness.

7. Processing
   - Method of Application:
     - Roller / chamber coating application
   - Speed
     - Must be adapted to number, power, and state of UV-lamps as well as to substrate to achieve full curing of the coating.
   - Curing
     - Degree of curing may vary, depending upon substrate and state of UV-curing equipment.
   - Cleaning
     - Clean all equipment with appropriate washes after use.
   - Stacking behavior
     - Check regularly degree of curing, temperature and flatness at delivery end.

8. Packaging
   - Black canister 25 kg (6.6 gallon, 55 lb)
   - Drum 200 kg (55 gallon, 440 lb)
   - Tote 1000 kg (275 gallon, 2204 lb)

9. Safety Precautions
   - Refer to WESSCO® 3704 Material Safety Data Sheet
   - complying with Regulation 91/155/EEC and observe warnings on packs.

10. Transport - Non dangerous good!