

Product Information

START 15 SurADoming Workstation



The following document provides the introduction, application and technical information of the SurADoming START 15 workstation.

1. General

SurADoming START 15 (Order no. 8311) is a simple doming workstation used for the processing of the SurACer[®] 4460 coating resin and is operated without digital dispenser and compressor. This workstation enables an easy, individual and manual production of doming labels, stickers and other promotional items. The light-cured and environmental friendly SurACer[®] 4460 doming resin will be the coating material used.

SurADoming START 15 is a manual workstation and consists of 1) a light-curing box for fast curing within minutes, including two 380 x 190 mm baking papers, 2) a manual syringe gun with a 55 ml syringe and its related accessories 3) 1 kg non-toxic SurACer[®] 4460 doming resin with innovative features, sufficient for the production of 1000 labels in sizes between 5-6 cm², 4) two 500 ml weighing- and mixing cups, each with a glass stirrer (length: 300 mm, diameter: 7 mm) and 5) 1 liter SurAChem 5380 cleaner for the cleaning of the equipment. The SurALux 1000 light-curing box is equipped with two UVA-lamps and has a maximum curing area of about 340 x 150 mm. SurACer[®] 4460 is the Isocyanate-free, highly flexible and resistant to weather and UV-light doming resin with a very long pot- and storage time.

The SurA Doming START 15 workstation will help the operator to get prepared for future production of larger quantities, as also become familiar with the handling of the SurACer[®] 4460 doming resin.



Workstation Equipment	
Quantity	Description
1	SurALux 1000 Light-curing box, including 2 baking papers 380 x 190 mm with a curing area of 340 x 150 mm
1 kg	SurACer [®] 4460 doming resin
1	Manual syringe gun with 55 ml syringe & piston, needle tips with sizes 1.20 mm, 1.37 mm and 0.58 mm, tip cap
2	500 ml Weighing- and mixing cup (PP)
2	Glass stirrer (length: 300 mm, Ø 7 mm)
1 l	SurAChem 5380 cleaner

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The doming material SurACer[®] 4460 will obtain a crystal-clear, shiny and tack-free surface after its irradiation under the SurALux 1000 light-curing box in about 5-10 minutes. Except SurACer[®] 4460 doming resin, also the SurACer[®] 4497 scratch-resistant coating can be here processed.

2. Application

The mixing of the 2-component SurACer[®] 4450 or 4460 doming resin is performed in the integrated weighing- and mixing cup and in the mixing ratio 1:2. Before using the SurACer[®] 4460 doming resin, consult the attached product- and application information.

The processing and dispensing of the SurACer[®] 4460 coating material is performed by a manual syringe gun with a 55 ml syringe in the familiar shapes (circle, square, triangle).

Before filling, the syringe needs to be closed with the tip cap. After mixing component 1 with component 2 (ratio 1:2) in the integrated weighing- and mixing cups, the syringe can be filled with the SurACer[®] 4460 doming resin. The syringe gun's plunger is assembled by simply pushing it from the front side all the way towards the gun with the gearing side looking down. The filled syringe is thereafter to be docked to the manual syringe gun. Before the coating process begins, the self-adhesive foils (from which the waste has been removed) are placed on the baking paper and the tip cap of the syringe is replaced by a needle tip.

A gray conical needle with 1.20 mm diameter is here recommended (Order no.: 8301435).

By pressing the trigger of the manual syringe gun, the coating resin will flow forward and will be distributed to the articles applied. After coating the self-adhesive foils with the doming resin, the backing paper is placed in the light-curing box. The entire handling, as also working with the syringe, requires necessary exercise.

The curing of the SurACer[®] 4460 doming resin is carried out in the SurALux 1000 light-curing box. Here, articles can be cured in about 5-10 minutes on paper size up to 340 x 150 mm.

The SurALux 1000 light-curing box is placed on a horizontal surface, connected with 220 V power supply and turned on by the main switch. The light-curing box is opened and the backing paper is positioned inside appropriately. The shelf is closed and the timer is set.

The curing process starts directly after setting the timer, whereas shortly after that the internal cooling of the light-curing box with the integrated fan begins. After completion of the curing process, an acoustic signal sounds and the light-curing box turns off (the ventilation remains on for about 3 more minutes). The flap is opened and a "fingernail" test reveals whether the curing process is complete. It is at this point to determine whether further curing must be carried out. The working area should be regularly cleaned and ventilated. Before using the SurALux 1000 light-curing box, consult the attached product- and application information.



SurA Chemicals GmbH

Am Poesener Weg 2
D 07751 Bucha b. Jena - Germany

Phone: +49-36 41-35 29 0
Fax: +49-36 41-35 29 29
e-mail: info@surachemicals.de
www.surachemicals.de

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3. Technical Information

SurACer® 4460	
Compliance:	RoHS compliant according to the EU Directive 2011/65/EC
Registration:	All of the ingredients have been in accordance with the REACH Regulation (EC) No. 1907/2006 preregistered
Hazardous substances:	No dangerous goods; there are no particular requirements for storage, transport and disposal

SurALux 1000	
Input voltage:	230 V AC
Size:	534 x 262 x 210 mm
Irradiation time:	5 - 10 min
Irradiation area:	340 x 150 mm
UVA-light:	2 Tubes, each 36 W (380-450 nm)
Standards:	CE
Fuse :	4 Ampere
Timer:	Digital



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Phone: +49-36 41-35 29 0
Fax: +49-36 41-35 29 29
e-mail: info@surachemicals.de
www.surachemicals.de