

Product Information

START 20 SurADoming Workstation

START
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The following document provides the introduction, application and technical information of the SurADoming START 20 workstation.

1. General

SurADoming START 20 (Order no. 8315) is an expanded 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 20 consists of 1) a light-curing box for fast curing within minutes, including two DIN A4+ 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), 5) a syringe stand and 6) 1 liter SurAChem 5380 cleaner, from which the consumption of syringes, pistons and needle tips is reduced to the minimum. The SurALux 2000 light-curing box is equipped with four UVA-lamps and has a maximum curing area of 380 x 220 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.



Workstation Equipment	
Quantity	Description
1	SurALux 2000 Light-curing box, including 2 baking papers 380 x 220 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
1	Syringe stand
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 **SurADoming START 20** workstation let the beneficial production of small to medium size articles and helps the operator to get prepared for future production of larger quantities, as also become familiar with the handling of the SurACer® 4460 doming resin.

The coating material SurACer® 4460 will obtain a crystal-clear, shiny and tack-free surface after its irradiation under the SurALux 2000 light-curing box in about 5-10 minutes. Except SurACer® 4460 doming material, also the SurACer® 4497 scratch-resistant coating can be processed with the workstation.

2. Application

The mixing of the 2-component SurACer® 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 dosing 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).

After mixing component 1 with component 2 in the integrated weighing- and mixing cups, the syringe can be filled with the SurACer® 4460 doming resin and sealed with its piston. Before filling, the syringe needs to be closed with a tip cap. 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.

By pulling the syringe gun's trigger the resin is pushed forward through the needle tip and applied to the respective article. A gray conical needle with 1.20 mm diameter is here recommended (Order no.: 8301435). After coating the self-adhesive foils (from which the waste has been removed) 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 2000 light-curing box. Here articles can be cured in about 5-10 minutes on paper size up to DIN A4+.

The SurALux 2000 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 in its marked surface area. The shelf is closed and the digital timer is set.

The curing process starts directly after setting the timer, whereas one minute after that time the internal cooling of the light-curing box begins with the integrated fan. After completion of the curing process an acoustic signal sounds and the ventilation switches off. The shelf is pulled out and a "fingernail" test reveals whether the hardening 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 2000 light-curing box, consult the attached product- and application information.



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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 2000	
Input voltage:	230 V AC
Size:	534 x 342 x 210 mm
Irradiation time:	5 - 10 min
Irradiation area:	380 x 220 mm
UVA-light:	4 Tubes, each 36 W (380-450 nm)
Standards:	CE
Fuse :	4 Ampere
Timer:	Digital adjustable



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