

Product Information

BASIC 40 SurADoming Workstation

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BASIC
40

The following document provides the introduction, application and technical information of the SurADoming BASIC 40 workstation.

1. General

SurADoming BASIC 40 (Order no. 8340) is a professional doming workstation used for the processing of the SurACer® 4460 doming resin and is operated with a digital dispenser and a compressor. This workstation enables an easy, individual and manual production of doming labels, stickers and other promotional items. The equipment combination optimizes the dispensing process of the resin and reduces significantly the manufacturing time. The light-cured and environmental friendly SurACer® 4460 doming resin will be the coating material used.

SurADoming BASIC 40 consists of 1) a light-curing box for fast curing within minutes, including two DIN A4+ baking papers, 2) 1 kg non-toxic SurACer® 4460 doming resin with innovative features, sufficient for the production of 1000 labels in sizes between 5-6 cm², 3) a digital, time-controlled dispenser with footswitch and fingerswitch, 4) an oil-free compressor with a 3 liter tank, 5) a 301 ml cartridge with adapter & hose, needle tips, tip cap, as also luer-lock extension hose 6) a stainless-steel cartridge stand, 7) two 500 ml weighing- and mixing cups, each with a glass stirrer and 8) 1 liter SurAChem 5380 cleaner, from which the



Workstation Equipment	
Quantity	Description
1	SurALux 2000 light-curing box, including 2 baking papers 22 x 38 cm
1 kg	SurACer® 4460 doming resin
1	Digital dispenser DG 1000T with footswitch and fingerswitch
1	Compressor KM 35 (max. pressure 6 bar)
1	301 ml cartridge transparent with cartridge adapter & 1m hose with bayonet connection, 3 needle tips with sizes 1x 1.20 mm, 1x 1.37 mm and 1x 0.58 mm, tip cap, luer-lock extension (needle-side)
1	Syringe stand - 301 ml
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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consumption of cartridges 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 a 38 x 22 cm. 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 coating material will obtain a crystal-clear, shiny and tack-free surface after its irradiation under the SurALux 2000 light-curing box in about 8-10 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 dispensing of the doming resin is directly controlled by a footswitch or a fingerswitch connected to the digital dispenser.

Screw the ca. 70 cm-long black luer-lock hose to the tip of the 301 ml cartridge. At the other end of the black luer-lock hose, screw the tip cap. After mixing component 1 with component 2 in the integrated weighing- and mixing cups, the cartridge, fitted in the cartridge stand, is to be filled with the SurACer® 4460 doming resin. The filled cartridge is thereafter to be docked to the cartridge adapter.

The cartridge-adapter's hose is connected to the "Air Out" plug of the digital dispenser. The digital dispenser DG 1000T gives constant, accurate and reproducible results thanks to its adjustable dispensing-time mode.

Additionally, its adjustable vacuum retainer prevents from eventual unwanted dripping of the resin.

A second compressed-air hose connects the digital dispenser DG 1000T ("Air In") to the source of the compressor KM 35. The two are to be switched on and set by the appropriate pressure. A material pressure of 0.5 - 1 bar is recommended on the digital dispenser. Before using the digital dispenser DG 1000T and compressor KM 35, consult the attached product- and application information.

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 is removed from the luer-lock extension hose and replaced by the respective needle tip. By pressing the footswitch or, alternatively the fingerswitch, 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). The flow rate of the Doming material can be increased or decreased by adjusting the pressure, respectively. 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 8-10 minutes on paper size up DIN A4+ sheet.

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 the corresponding surface area.



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The drawer is closed and the timer is set. The curing process starts directly after setting the timer, whereas at the same 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 drawer is opened

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.

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:	8 - 10 min
Irradiation area:	380 x 220 mm
UVA-light:	4 Tubes, each with 36 W (380-450 nm)
Standards:	CE
Fuse :	4 Ampere
Timer:	Digital adjustable

Digital Dispenser DG 1000T	
Input voltage:	110 - 240 V AC
Size:	245 x 190 x 70 mm
Weight:	3 kg
Time setup:	Via selecting buttons
Time range:	00.01 sec – 99.99 sec
Display:	Selected dispensing time (LED)
Dosage:	Manual
Compressed-air inlet:	0.5 - 7 bar
Compressed-air outlet:	0.01 - 7 bar
Standards:	CE

Compressor KM 35	
Pressure System:	2-piston compressor, oil-free
Input voltage:	230 V AC
Size:	320 x 135 x 350 mm
Weight:	7 kg
Power:	190 Watt (1/4 PS)
Suction capacity:	30 - 35 l/min.
Max. pressure:	6 bar
Boiler size:	3 l
Standards:	CE



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