

KIWOBOND® UltraCure UV 3004

UV-light curing screen adhesive, especially suitable for the G-BOND UltraCure unit

KIWOBOND UltraCure UV 3004 is a UV reactive, one-component adhesive for the chemically and physically highly resistant bonding of screen printing meshes onto aluminium, steel and galvanized iron frames. The bonding is resistant to all common screen printing inks and cleaning agents. KIWOBOND UltraCure UV 3004 is low viscous and especially suitable to be applied by the dosing unit of the G-BOND UltraCure unit.

PROPERTIES

KIWOBOND UltraCure UV 3004 is a very fast curing, UV-reactive adhesive and sensitive in a wide UV-wave length range. It is odourless, easy to apply and, with the exception of chlorinated hydrocarbons, very solvent resistant after curing. KIWOBOND UltraCure UV 3004 is suitable for all mesh types. In general, used or destroyed meshes can easily be removed from the frame.

Notice: Due to the many variables of available frame types and their condition, it is recommended to test the suitability of KIWOBOND UltraCure UV 3004 for the particular frame.

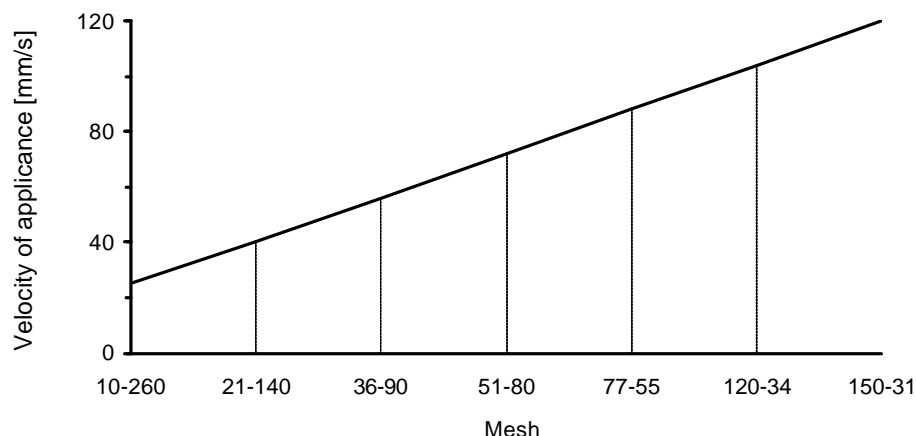
APPLICATION

Before use, thoroughly remove any old adhesive residue from the frame. Best adhesion can be achieved on sandblasted aluminium frames. To stretch again successfully, the old adhesive film must be even and without break-outs, a surface roughness of max. 40 µm is required. The solvent resistance can be reduced due to the old adhesive film.

The viscosity of KIWOBOND UltraCure UV 3004 was chosen in a way that the adhesive, after being applied by the GBOND UltraCure unit, fills the mesh without any further manual action, however stops at the frame's edges, thus achieving a clean and economic adhesion on the frame

The quantity of adhesive depends on the meshes and the width of the frames. The average consumption with the G-BOND UltraCure unit is approx. 200 g/m² when using a mesh of 100-40 and stretching the frame for the first time. When re-stretching the mesh onto an existing and even adhesive layer, approx. 150 g/m² is needed. For a frame width of 40 mm, generally one applying cycle is sufficient, up to 60 mm two cycles, from 65 mm three cycles, etc. are necessary. The indicated consumption quantities are guide values, which may vary according to the frame used.

The following diagram shows guide values for dosing the adhesive when working with a G-BOND UltraCure unit. For details please refer to the user's manual of the G-BOND UltraCure unit.



Curing is achieved by UV-light within a very short time. Exposure time depends on the type of UV-light source, the distance to the adhesive surface, the thickness of the adhesive film and the mesh to be stretched. A clearly longer exposure time is therefore required for dyed or very fine meshes due to their shading effect. Especially short exposure times can be achieved using our G-BOND UltraCure system. Guide values for curing when using a mesh 100-40:

White mesh: approx. 80 mm/ s (per application cycle)
Yellow mesh: approx. 40 mm/ s (per application cycle)

KIWOBOND UltraCure UV 3004 is sensitive to light. Therefore ensure that original containers are only left open for a short time when taking material out.

CLEANING

Unhardened: KIWOSOLV L 63

Hardened: Complete removal of hardened adhesive residue can only be made mechanically i.e. using a belt or an angle grinder.

COLOUR

Colourless, slightly yellow

DENSITY

Approx. 1,12 g/cm³

VISCOSITY

Approx. 200 mPas (Brookfield RVT, spindle 1, 20 r/min, 20°C)

SOLIDS CONTENT

100%

HEALTH HAZARDS/ ENVIRONMENTAL PROTECTION

Please follow further information given in the material safety data sheet.

STORAGE

1 year (at 20 - 25°C and tightly closed original container). Use opened bottles soonest possible. KIWOBOND UltraCure UV 3004 is temperature sensitive and must therefore not be heated over +50°C.