

Magna/Cure[®] MAX-R

Maximum resistance dual cure emulsion for the broadest range of applications

MAX-R is a universal emulsion designed to offer UNMATCHED resistance in any imaging application. MAX-R offers the following benefits:

- **Outstanding resistance to aggressive water and solvent based inks and adhesives.**
- **Extreme durability; withstands long print runs.**
- **Heat and humidity resistance.**
- **Excellent imaging.**
- **Easy reclaimability with high pressure.**
- **Compatible with Plastisol, Water-based (including Discharge & HSA) inks as well as solvent cleaning**

UNMATCHED Resistance

Magna/Cure MAX-R dual cure emulsion is designed to offer UNMATCHED resistance for the broadest range of applications.



CHEMICALS

RECOMMENDED

Chroma/Wet™ iSC
degreaser / adhesion promoter

Chroma/Strip™ iSC
ready-to-use stencil remover

MATERIALS

REQUIRED

Exposure unit
Clean work area
Washout area
Scoop coater

RECOMMENDED

Drying Cabinet
Pressure washer
Exposure Calculator

SAFETY AND HANDLING

Magna/Cure MAX-R emulsion should be handled like any other dual cure emulsion. Avoid contact with skin and eyes. This material is not hazardous when used within reasonable standards of industrial hygiene and safe working practices. Refer to SDS for further information.

STANDARD SIZES

Quart, Gallon, 3.5 gallon, 50 gal. drum

SPECIFICATIONS

Appearance: Blue
Solids: 37%
Viscosity: 3,360 CPS (sensitized)
Exposure: Fast (see reverse)

STORAGE

Magna/Cure MAX-R emulsion should be stored at room temperature and should not be stored at temperatures above 80°F (27°C) or below 32°F (0°C). Magna/Cure MAX-R emulsion should be stored in its original container.

Sensitized MAX-R emulsion has a shelf life of 4 to 6 weeks at room temperature (72°F) or longer when refrigerated. To maximize sensitized shelf life use only distilled water to dissolve diazo sensitizer.

Coated, unexposed screens can be stored as long as one month in a clean, cool, dry and completely dark area.

Expiration date. Always check the expiration date on sensitizer bottle to ensure freshness.

Protect from freezing. Magna/Cure MAX-R is not freeze/thaw stable.



INSTRUCTIONS

DEGREASE

Work up a lather on both sides of mesh to degrease. Be sure to use only high-quality mesh degreaser, such as Chroma/Wet iSC designed specifically for this purpose. Rinse thoroughly.



MIX

Mix emulsion and sensitizer according to instructions on bottle. Let emulsion stand at least two hours, preferably overnight, before using. **FOR BEST RESULTS:** Always stir emulsion before use. Contents may settle over long periods of time. Gentle stirring will ensure that the emulsion is properly mixed.

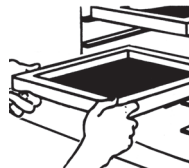
COAT

Fill scoop coater with room temperature emulsion. Slowly apply first coat to print side. Next, coat squeegee side with 1-3 coats depending upon thickness required. **For most art, a 1X2 coating will be optimal.** If a thicker stencil is required, apply additional wet-on-wet coatings from the squeegee side.



DRY

Dry screen thoroughly in horizontal position with print side down, using a completely clean and dark drying cabinet. Temperature should not exceed 110°F (43°C). Relative humidity should not exceed 50%; lower RH provides faster drying and allows for more efficient curing.



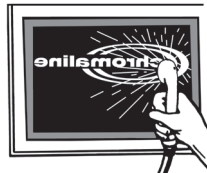
EXPOSE

Using an exposure calculator to determine proper exposure times for Magna/Cure MAX-R, place emulsion side of photopositive in contact with print side of screen. *See exposure guidelines at right.*



DEVELOP

Gently spray both sides of screen with lukewarm water, wait 30 seconds then gently wash print side of the screen until image is fully open. Rinse both sides thoroughly. Dry screen completely and you are ready to print.



IMPORTANT PRINTING NOTE

Water based inks: to prevent premature breakdown on the press, spray or wipe both sides of the stencil with a water-saturated cloth immediately prior to printing.

Solvent based inks: to prevent premature breakdown on the press, wipe both sides of the stencil with a solvent-saturated cloth immediately prior to printing.

RECLAIM

Apply high-quality screen reclaimer, such as Chroma/Strip iSC to both sides. Scrub area to be reclaimed with a stiff nylon brush to ensure entire surface is wet and let sit until stencil begins to dissolve. Remove stencil residue with pressure washer, then rinse with hose, thoroughly flooding screen and frame.



*Do not let reclaimer dry

EXPOSURE GUIDELINES

Note: Exposure times are suggested only as a guide. Individual exposure times may vary depending upon equipment used, bulb age, and other shop conditions. Suggested exposure times are as follows:

Exposure times below were set for 5KW unit at 40" from frame. All screen mesh was dyed in color. Screens were coated wet on wet, once on print side and twice on squeegee side.

SUGGESTED MINIMUM EXPOSURE GUIDELINES

Mesh	Time
158 mesh TPI (62 cm)	60 - 90 sec.
230 mesh TPI (90 cm)	45 - 60 sec.
305 mesh TPI (120 cm)	30 - 45 sec.

* Exposure times were determined using the Chromaline Exposure Calculator.

AVOID FAILURE: Dual cure emulsions have a very wide exposure latitude. Underexposed stencils often appear acceptable, but premature breakdown can occur on the press. When determining exposure speed, always overexpose your test stencil. Then, using the Chromaline Exposure Calculator, reduce exposure time until acceptable image quality is achieved. This will help assure good durability.



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