MAGNA/CURE®
UDC-HV

Photopolymer dual cure direct emulsion for the broadest range of applications.

Magna/Cure® UDC-HV *(HV, HV Z-1, HV Z-2, HV Clear)* direct emulsion allows screen makers to obtain remarkable image quality and exceptionally durable stencils. In addition, Magna/Cure UDC-HV's high viscosity allows for excellent coating on low or high mesh counts. Magna/Cue UDC-HV dual cure emulsion is designed for the widest range of imaging applications and comes in multiple colors.

- **Fast exposue with excellent image quality**
- **Hard, durable stencils, resistant to the widest range of inks and additives.**
- **Superior mesh adhesion**
- **Lightening fast washout and easy reclaim**
- **High viscosity allows coating on low or high mesh counts**
- **For use with solvent, UV and Plastisol Inks**

Premium Quality

Premium emulsion designed for the widest range of imaging applications.

CHEMICALS

REQUIRED

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 UDC-HV 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
(Available in clear and dyed formulation)

SPECIFICATIONS

Appearance:	Purple (HV), Red (HV Z-1), Blue (HV Z-2), Colorless (HV Clear)
Viscosity:	5300 CPS (sensitized)
Solids:	35% (sensitized)
Exposure:	Fast (see reverse)

STORAGE

Magna/Cure UDC-HV 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 UDC-HV emulsion should be stored in its original container.

Sensitized UDC-HV 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 assure freshness.

Protect from freezing. Magna/Cure UDC-HV is not freeze/thaw stable.

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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.

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

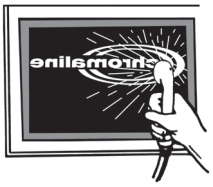
Dry screen thoroughly in horizontal position with print side down, using a completely clean and dark drying cabinet. Temperature should not exceed 110ºF (43ºC). Relative humidity should not exceed 50%; lower RH provides faster drying and allows for more efficient curing.

EXPOSE

Using an exposure calculator to determine proper exposure times for Magna/Cure UDC-HV, 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.



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 yellow 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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