

EnduraCoat Intego Technical Data Sheet

EnduraCoat Intego is a flexible, extremely low VOC, high solids content, super fast drying acrylic aqueous clear coat specially formulated for use on digitally printed PVC's used for a variety of signage and display applications. It can be sprayed, applied manually or applied through a conventional flood coater. The addition of Tinuvin® UVA absorbers and hindered amine light stabilizers (HALS) ensures that the prints you coat will be protected from harsh UV radiation typically known to degrade color in prints. EnduraCoat Intego is available in Gloss and Matte (ECWBIG, ECWBIM). **This product is ideal for hand-apply application due to its extremely fast dry times.**

Typical Applications

Typical applications include coating of digitally printed PSV and Flex vinyl using traditional solvent based ink jet technology used for low cost banners, short term back lit signage, construction site signage and kiosks.

EnduraCoat Intego comes pre-mixed with a viscosity between 18 and 22 seconds in a #2 Zahn. This product may be sprayed, applied using a wax applicator or applied through a conventional flood coater such as the AFC series flood coaters from Drytac. Depending on the application method used, **dilution may be required.**

EnduraCoat Intego is compatible with most commercially available flood coaters using a mayer bar.

Recommended Substrates:

- PSV (Cast and Calendered)
- Flex PVC
- Wet Strength Papers

Recommended Printer/Ink Systems:

- Traditional True Solvent based Inks
- HP Latex Inks/Prints

Performance Properties:

- Excellent intercoat adhesion (layer to layer)
- Superb water and moisture resistance
- Good resistance to common household and some aromatic cleaners (see list of recommended cleaners)
- Good mar and scratch resistance after full cure

Coating & Equipment Compatibility

Viscosity Target	Mayer based Flood Coater	Manual Applicator
Using #2 Zahn	18 to 22	undiluted

(Dilute with distilled water only)

Instructions for Use

While this coating is supplied in coater ready condition it should be mixed well prior to use each and every time.

Optimal temperature for this coating is 65-90°F (18-32°C). At lower temperatures the coating will have heavier viscosity and will not flow properly. Allow at least a 10 to 15 minute warm up period (with coating flowing) prior to use.

If coating freezes, allow it to warm to room temperature before use. Alternatively, container may be placed in warm bath of 80°F (27°C) for 30 minutes and then mixed thoroughly with drill and paddle or spindle paint mixer until clumps dissolve.

For use on Automated Flood Coatiers: for applications requiring temporary use (six months to one year), a #12 mayer bar is recommended. For applications requiring short term use (one to two years), the #18 bar is recommended. For use on graphics requiring extended outdoor durability to three years, the #26 bar is recommended. All bars to be used in static mode.

For use in HVLP Sprayers: thin to proper viscosity and filter prior to adding to tank. Start with a pressure of 50 psi and adjust the fan so that an even mist is produced that is heavy enough to stick to the print, but not run. Practice using broad sweeping (horizontal) strokes, overlapping slightly. Be sure to wear protective eye wear and an appropriate respirator.

For use with manual applicator: use undiluted for best results. The use of a rubber based squeegee or a wool wax applicator is recommended. Pour the coating onto the graphic being coated into one corner. Work the coating across and down the substrate using an "M" or figure 8 motion, being careful not to raise and lower the applicator too often, causing bubbles. If a rubber squeegee is used, simply work from side to side, with slight overlaps between drawdowns. EnduraCoat Intego dries to 80 percent cure within 15 to 20 minutes in a relative humidity range between 60 and 80 percent. Coated product is usually safe to roll and ship within two to four hours of coating, temperature and humidity dependent.

Curing Properties

When fully cured, final film properties (scratch and chemical resistance) are available 24 hours after polymerization.

Cure Times	Roll Coater	HVLP gun	Manual Applicator
before stacking	Immediate	25-30min	25-30min

Typical Coverage

Coverage Rates per gallon	Flood Coater	HVLP gun	Manual Applicator
Manual Coating	N/A	400 sq/ft	360sq/ft
Smooth Bar	2258 sq/ft		
#12 Mayer Bar	1318 sq/ft		
#18 Mayer Bar	880 sq/ft		
#26 Mayer Bar	*610 sq/ft		

* @ 1 mil dry film thickness

Light Fastness

Hi quality Tinuvin® UV absorbers and HALS have been added to this product. While we are confident the use of this coating will significantly extend print life, we recommend that you contact the ink manufacturer to obtain base durability information and conditions affecting the long term durability and color fade characteristics for the inks you are using.

In addition to slowing color fade, use of this product will help protect the ink from exposure to many elements that tend to degrade inks faster, such as water, moisture, air and dust contaminants, abrasion and scratching.

Storage

Care should be taken to store the coating in tightly closed containers located in a cool (60-80°F/15-27°C) place. With suitable conditions, unopened coating is expected to have a shelf life of approximately 12 months from date of manufacture.

Clean Up

Use clean hot water with a solution of 5 to 10 percent IPA to clean lines, rollers and tank of coating. Do not let coating dry on painted surfaces.

Please consult Drytac Technical Service for further information 1-800-280-6013

Recommended cleaners for use on coated graphics: (only after 48 hour cure time)

Soap & Water	De-Solv-It	Formula 409
Turpentine	Mineral Sprits	Fantastic
WD 40	MEK**	99% IPA**
Goof Off*	Acetone **	

* Prolonged contact may soften coating

** Not recommended

Precautions

Read the material safety data sheet prior to processing. It contains instructions for precautions when handling clear coats. If clear coat comes in contact with skin, wipe clear coat off with a clean, dry cloth (do not use solvent). Wash and rinse the affected area with soap and water.

Availability

EnduraCoat Intego is available in Gloss and Matte (ECWBSBG, ECWBSBM). Economy pricing is available in four-1 gallon and 55 gallon drums. Customized packaging is available on large sized orders.

IMPORTANT MESSAGE

We strongly recommend a preliminary test of printing and curing on the substrates intended for use, in order to ascertain exactly the procedure, the working times and the obtained affect. Follow the indications on the package, ask for the safety data sheets and always follow the indications contained therein.

Only the correct use of the product will allow satisfactory results. For this reason, Drytac is not responsible for the improper use of the product, either by substrate applied to or application. Make certain that product is right for the desired use and work according to the instructions given in our technical data sheets. If in doubt of the appropriate application methods or use, contact Drytac at one of the phone numbers listed below.

*Note: 25 microns equal 1 mil