

925WR-P & 925WR-P/CL

PHTHALATE-FREE, WATER RESISTANT SCREEN EMULSION

925WR-P is a pale violet emulsion formulated for use with water-based textile inks. It has 41% solids content and a viscosity of 7000 centipoise (sensitized). It is identical to **925WR**, but uses a powdered diazo and, thus, does not require hazardous labels nor add-on shipping charges. **925WR-P/CL** is undyed for easier see-through registration; it is packaged with separate dye.

INSTRUCTIONS

Step 1: PREPARE THE FABRIC

Used or surface treated mesh need only be degreased using **Screen Degreaser Liquid No. 3**. Mechanical roughening is an option for new mesh that is not surface treated. It increases the surface area of mesh for a better mechanical bond of the stencil, increasing printing run length. Use **Ulnaogel No. 23** to roughen and degrease in a single step.

Step 2: SENSITIZING

Dissolve the diazo sensitizer by adding lukewarm water up to the shoulder of the diazo bottle according to the table below.

925WR-P & 925WR-P/CL	Diazo #	# of Fills to Shoulder
QUART (60cc)	DIAZO C58	1 Time
1 GALLON (100cc)	DIAZO C30	2 Times
5 GALLON (500cc)	DIAZO C31	2 Times

Shake it well. Wait 15 minutes for bubbles to disperse. Pour the fully dissolved sensitizer into the emulsion. Stir with a clean broad, flat, plastic or stainless steel instrument until the emulsion is uniform in color. Close the container. Wait at least one hour for the sensitized emulsion to debubble. Write the date of sensitizing on the emulsion container label.

Step 3: COATING THE SCREEN

Method 1: Apply one coat of emulsion on the printing side, then one coat on the squeegee side. Method 2: Apply two coats on the printing side, then two coats on the squeegee side, wet-on-wet. After each coating, rotate the screen 180°. Method 3: Follow Method 2 (above). Then, after drying the screen, apply two additional coats on the printing side, wet-on-wet. Dry the screen again.

Step 4: DRY THE SCREEN

Dry multicoated screens (Methods 2 or 3) horizontally, printing side down, at room temperature in a dirt- and dust-free area. Use a fan to speed drying or, preferably, dry coated screens with filtered air, up to 104°F. (40°C.) in a commercial dryer. Dehumidify the drying area, if possible.

Step 5: STORAGE

Unsensitized emulsion can be stored for up to 1 year. Sensitized emulsion can be stored for 3 – 6 weeks at room temperature; up to 3 months in a refrigerator. Store coated screens in a cold, dry, completely dark area until exposure.

Step 6: CALCULATE THE APPROXIMATE EXPOSURE

Refer to the Base Exposure Table (below). Base Exposure Time X Exposure Variable Factors = Approximate Exposure Time.

Step 7: DETERMINE THE OPTIMAL EXPOSURE TIME

Make a Step Wedge Test (there is an instructional video covering this on the Ulano Website (www.ulano.com) or use the **Ulano ExpoCheck** to determine your optimum exposure time. Optimum exposure is indicated at that exposure time when: ■ No positive outline or darkening of the emulsion color is observable if the exposure is increased. ■ The squeegee side emulsion is hard and not slimy. ■ An actual print best duplicates the test positive *at the level of resolution that the job requires*.

Step 8: WASHOUT

Wet both sides of the screen with a gentle spray of cold water. Then spray forcefully from the printing side until the image areas clear. Rinse both sides with a gentle spray until no soft emulsion is left on the squeegee side, and no foam or bubbles remain. Blot excess water from the printing side with unprinted newspaper stock.

Step 9: BLOCKOUT & TOUCHUP

Blockout Option 1: Before drying and exposure, use excess emulsion from the coating step to cover blockout area. **Option 2:** For non-water-based inks, after exposure and washout, dry the screen. Apply **Screen Filler No. 65** or **Extra Heavy Blockout No. 10**.

Touchup Option 1: Use excess emulsion and re-expose. **Touchup Option 2:** For non-water-based inks, use **Screen Filler No. 65** or **Extra Heavy Blockout No. 10** thinned with water.



Technical Data Sheet

Step 10: RECLAIM THE SCREEN

Remove ink from the screen using the solvent or solvent blend recommended by the ink manufacturer. Use **Screen Degreaser Liquid No. 3** to help remove ink and solvent residues that might impair the action of the stencil remover. Brush **Stencil Remover Liquid No. 4** or **Stencil Remover Paste No. 5** on both sides of the screen. Do not let the stencil remover dry on the screen. Wash the screen with a forceful spray of water. Use **Haze Remover No. 78** to remove ink and haze residues, if necessary.

BASE EXPOSURE TABLE AT 40 INCHES EXPOSURE DISTANCE

LIGHT SOURCE		COATING METHOD		
		1	2	3
Metal Halide				
	2000 watts	44 sec.	124 sec.	164 sec.
	3000 watts	29 sec.	82 sec.	104 sec.
	4000 watts	21 sec.	62 sec.	82 sec.
	5000 watts	16 sec.	48 sec.	62 sec.
Mercury Vapor				
	2000 watts	58 sec.	164 sec.	211 sec.
Fluorescent Tubes*				
	40 watts	288 sec.	12 min.	N/R

*Base exposure times are for unfiltered black light, or super diazo blue tubes at 4-6" (10-15 cm.)

EXPOSURE VARIABLES

Factors for Variables Affecting Base Time

Fabric	
metal fabric	2.0-4.0
dyed fabric	1.5-2.0
finer than 330T/in (130T/cm)	0.7-0.9
coarser than 250T/in (100T/cm)	1.1-2.0

High Heat and Humidity	
Factor	1.3 – 1.8

Taped-Up Positives	
Factor	1.2 – 1.3

Exposure Distance			
20 inches /50 cm.	0.25	44 inches /110 cm.	1.21
24 inches /60 cm.	0.36	48 inches /120 cm.	1.44
28 inches /70 cm.	0.49	52 inches /130 cm.	1.69
32 inches /80 cm.	0.64	56 inches /140 cm.	1.95
36 inches /90 cm.	0.81	60 inches /150 cm.	2.25
40 inches /100 cm.	1.00	72 inches /180 cm.	3.24

Viscosity Adjustment	
5% dilution	0.95
10% dilution	0.9
5% more viscous	1.1

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713dm (9250); re. 1213dm (925WR-P)