

## SPEEDMASK® 730-BT Chemical Milling and Harsh-Environment Processing Mask

**APPLICATIONS**

- Chemical Milling/Etching
- Plating
- Anodizing
- Grit Blasting

**FEATURES**

- UV/Visible Light Cure
- Excellent Surface Protection
- Excellent Chemical Resistance
- Fast Curing
- Easy Peel Off
- Moderate Adhesion
- Spray or Dip
- High-Visibility Blue Color
- Trimmable After Cure

**RECOMMENDED SURFACES**

- Nickel Alloys
- Steel
- Titanium
- Stainless Steel
- Aluminum
- Glass

**SPEEDMASK® 730-BT** UV/Visible light-curable masking resin is formulated to provide good surface protection during chemical milling/etching, plating, anodizing, and aggressive grit-blasting operations aiding in the manufacturing, overhaul, repair, and rework of turbine engine blades, vanes, and other turbine components. 730-BT is impervious to most acid and alkali solutions. **SPEEDMASK®** resins contain no nonreactive solvents and cure upon exposure to light. Their ability to cure in seconds enables faster processing, greater output, and lower processing costs. When cured with Dymax light-curing spot lamps, focused-beam lamps, or flood lamps, they deliver optimum speed and performance for many masking applications. Dymax lamps offer the optimum balance of UV and visible light for the fastest, deepest cures. This product is in full compliance with the RoHS Directives 2002/95/EC and 2003/11/EC.

**UNCURED PROPERTIES \***

Property	Value	Test Method
Solvent Content	No Nonreactive Solvents	N/A
Chemical Class	Acrylated Urethane	N/A
Appearance	Blue Translucent Gel	N/A
Soluble in	Organic Solvents	N/A
Density, g/ml	0.96	ASTM D1875
Viscosity, cP (20 rpm)	20,000 (nominal)	ASTM D2556

**OTHER CURED PROPERTIES \***

Property	Value	Test Method
Boiling Water Absorption, % (2 h)	0.2	ASTM D570
Water Absorption, % (25°C, 24 h)	0.3	ASTM D570
Linear Shrinkage, %	1.2	ASTM D2566

**CURED MECHANICAL PROPERTIES \***

Property	Value	Test Method
Durometer Hardness	D35	ASTM D2240
Tensile at Break, MPa [psi]	3.4 [500]	ASTM D638
Elongation at Break, %	275	ASTM D638
Modulus of Elasticity, MPa [psi]	3.4 [500]	ASTM D638

\* Not Specifications

N/A Not Applicable



© 2008-2015 Dymax Corporation. All rights reserved. All trademarks in this guide, except where noted, are the property of, or used under license by Dymax Corporation, U.S.A.

Technical data provided is of a general nature and is based on laboratory test conditions. Dymax does not warrant the data contained in this bulletin. Any warranty applicable to the product, its application and use is strictly limited to that contained in Dymax standard Conditions of Sale published on our website at [www.dymax.com/pdf/Conditions\\_of\\_Sale.pdf](http://www.dymax.com/pdf/Conditions_of_Sale.pdf). Dymax does not assume responsibility for test or performance results obtained by users. It is the user's responsibility to determine the suitability for the product application and purposes and the suitability for use in the user's intended manufacturing apparatus and methods. The user should adopt such precautions and use guidelines as may be reasonably advisable or necessary for the protection of property and persons. Nothing in this communication shall act as a representation that the product use or application will not infringe on a patent owned by someone other than Dymax or act as a grant of license under any Dymax Corporation Patent. Dymax recommends that each user adequately test its proposed use and application before actual repetitive use, using the data in this communication as a general guideline. Technical Data Collection Prior to 2008 06/05/2015

Dymax Corporation  
860.482.1010 | [info@dymax.com](mailto:info@dymax.com) | [www.dymax.com](http://www.dymax.com)

Dymax Europe GmbH  
+49 (0) 611.962.7900 | [info\\_de@dymax.com](mailto:info_de@dymax.com) | [www.dymax.de](http://www.dymax.de)

Dymax Engineering Adhesives Ireland Ltd.  
+353.1.231.4696 | [info\\_ie@dymax.com](mailto:info_ie@dymax.com) | [www.dymax.ie](http://www.dymax.ie)

Dymax Oligomers & Coatings  
860.626.7006 | [info\\_oc@dymax.com](mailto:info_oc@dymax.com) | [www.dymax-oc.com](http://www.dymax-oc.com)

Dymax UV Adhesives & Equipment (Shanghai) Co. Ltd.  
+86.21.37285759 | [dymaxasia@dymax.com](mailto:dymaxasia@dymax.com) | [www.dymax.com.cn](http://www.dymax.com.cn)

Dymax UV Adhesives & Equipment (Shenzhen) Co. Ltd.  
+86.755.83485759 | [dymaxasia@dymax.com](mailto:dymaxasia@dymax.com) | [www.dymax.com.cn](http://www.dymax.com.cn)

Dymax Asia (H.K.) Limited  
+852.2460.7038 | [dymaxasia@dymax.com](mailto:dymaxasia@dymax.com) | [www.dymax.com.cn](http://www.dymax.com.cn)

Dymax Asia Pacific Pte. Ltd.  
+65.6752.2887 | [info\\_ap@dymax.com](mailto:info_ap@dymax.com) | [www.dymax-ap.com](http://www.dymax-ap.com)

Dymax Korea LLC  
+82.2.784.3434 | [info\\_kr@dymax.com](mailto:info_kr@dymax.com) | [www.dymax.com/kr](http://www.dymax.com/kr)

**CURING GUIDELINES**

Cure rate is dependent upon many variables, including lamp intensity, distance from the light source, and required depth of cure. The cure times below are based on lab results and are intended for reference only. Testing was performed using a 0.38 mm [0.015 in] coating thickness. Time/belt speed was determined by a complete, tack-free cure.

Dymax Curing System (Intensity)	Cure Time or Belt Speed
<b>2000-EC</b> (50 mW/cm <sup>2</sup> ) <sup>A</sup>	6 s
<b>5000-EC</b> (200 mW/cm <sup>2</sup> ) <sup>A</sup>	4 s
<b>BlueWave® LED PrimeCure</b> (575 mW/cm <sup>2</sup> ) <sup>B</sup>	10 s
<b>BlueWave® 200</b> (10 W/cm <sup>2</sup> ) <sup>A</sup>	0.5 s
<b>Porta-Ray® 400</b> (400 mW/cm <sup>2</sup> ) <sup>A</sup>	2 s
<b>UVCS Conveyor with Fusion F300S</b> (2.5 W/cm <sup>2</sup> ) <sup>C</sup>	8.2 m/min [27 ft/min]

**A** Intensity was measured over the UVA range (320-395 nm) using a Dymax ACCU-CAL™ 50 Radiometer.

**B** Intensity was measured over the UVA/Visible range (350-450 nm) using a Dymax ACCU-CAL™ 50-LED Radiometer.

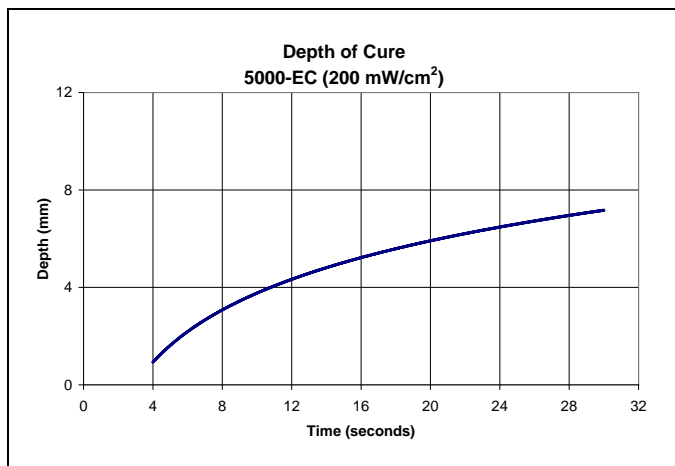
**C** At 53 mm [2.1 in] focal distance. Maximum speed of conveyor is 8.2 m/min [27 ft/min]. Intensity was measured over the UVA range (320-395 nm) using a Dymax ACCU-CAL™ 100 Radiometer.

Full cure is best determined empirically by curing at different times and intensities, and measuring the corresponding change in cured properties such as tackiness, adhesion, hardness, etc. Full cure is defined as the point at which more light exposure no longer improves cured properties. Higher intensities or longer cure times may degrade Dymax light-curable masks.

Dymax recommends that customers employ a safety factor by curing longer and/or at higher intensities than required for full cure. Although Dymax Application Engineering can provide technical support and assist with process development, each customer must ultimately determine and qualify the appropriate curing parameters required for their unique application.

**DEPTH OF CURE**

The graph below shows the increase in depth of cure as a function of exposure time. A 9.5 mm [0.37 in] diameter specimen was cured in a polypropylene mold and cooled to room temperature. It was then released from the mold and the cure depth was measured.


**OPTIMIZING PERFORMANCE AND HANDLING**

1. This product cures with exposure to UV and visible light. Exposure to ambient and artificial light should be kept to a minimum before curing. Dispensing components, including needles and fluid lines, should be 100% light blocking, not just UV blocking.
2. All surfaces to be masked should be clean and free from grease, mold release, or other contaminants prior to dispensing the resin.
3. Oxygen in the atmosphere may inhibit surface cure. Surfaces exposed to air may require higher intensity UV (>100 mW/cm<sup>2</sup>) to produce a tack-free cure. Flooding the bond area with an inert gas, such as nitrogen, can also reduce the effects of oxygen inhibition.
4. Part should be allowed to cool after cure before testing.
5. Light curing generally produces some heat. If necessary, cooling fans can be placed in the curing area to reduce the heating effect on components.
6. At the point of curing, an air exhaust system is recommended to dissipate any heat and vapors formed during the curing process.

**DISPENSING THE RESIN**

This material may be dispensed with a variety of manual and automatic applicators or other equipment as required. Questions relating to dispensing and curing systems for specific applications should be referred to Dymax Application Engineering.

**STORAGE AND SHELF LIFE**

Store the material in a cool, dark place when not in use. Do not expose to light. This product may polymerize upon prolonged exposure to ambient and artificial light. Keep covered when not in use. This material has a six-month shelf life from date of shipment, unless otherwise specified, when stored between 10°C [50°F] and 32°C [90°F] in the original, unopened container.

**CLEANUP**

Uncured material may be removed from dispensing components and parts with organic solvents. Cured material will be impervious to many solvents and difficult to remove. Cleanup of cured material may require mechanical methods of removal.

**GENERAL INFORMATION**

This product is intended for industrial use only. Keep out of the reach of children. Avoid breathing vapors. Avoid contact with skin, eyes, and clothing. Wear impervious gloves. Repeated or continuous skin contact with uncured material may cause irritation. Remove material from skin with soap and water. Never use organic solvents to remove material from skin and eyes. For more information on the safe handling of this material, please refer to the Material Safety Data Sheet before use.