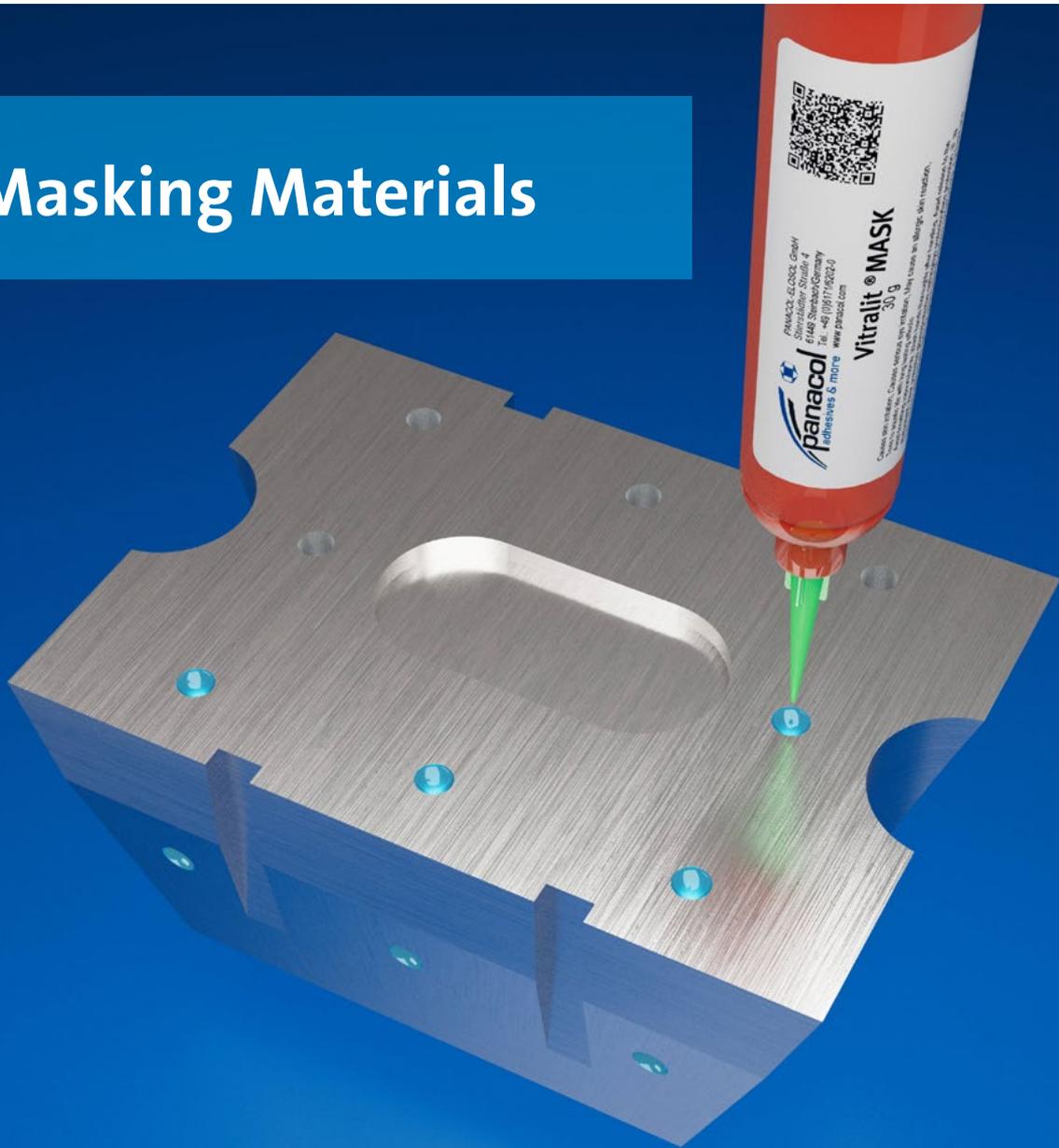


# UV Masking Materials



Temporary Surface Protection for:

- Plating
- Sandblasting
- Anodizing
- Powder Coating
- Surface Finishings

### Features of Panacol UV Masking Materials

- > Quick to apply
- > Solvent-free
- > Superior protection for complex geometries
- > Suitable for manual or automated removal
- > Reduces application and processing costs

### UV Mask Application Methods

Panacol UV masking materials are single component, liquid compositions that can be easily applied using various methods. These UV masking materials can be manually dispensed from syringes or cartridges. They can also be applied by dipping the components into the mask, or by spraying the mask onto component surfaces. The UV masking process can be automated and integrated into existing production lines using robotic dispensing or screen printing. Many factors should be considered when choosing which dispensing method or system is best for the application. These factors include part size, cycle time, UV mask volume and packaging, placement tolerance, and of course, budget. Selection assistance is obtainable from Panacol applications engineers. Their in-depth knowledge of compatible, commercially available dispensing systems can simplify the conversion to Panacol's UV masking process.

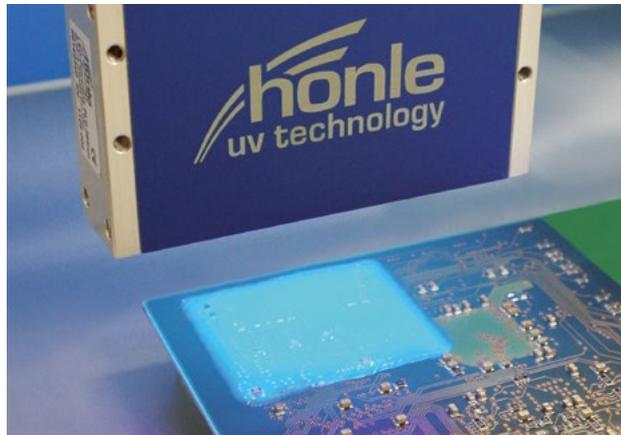


### UV Mask Selection

Many processes can have the same generic category description such as grinding, plating, peening, etc. However, individual processing techniques, velocities, temperatures, and chemical solutions can vary as mandated by manufacturer's specifications. For this reason, it is highly recommended that UV masking users consult with Panacol applications engineers when selecting UV masks for each of their intended processes. Our product knowledge and extensive experience with UV masking applications ensures that the best UV mask and curing options are selected based on your specific requirements.

## UV Mask Curing

All Panacol UV masking materials can be cured with LED curing systems. Broad spectrum UV lamps, (discharge lamps) can also be used, but significant process efficiency and cost reduction is attainable from LED curing. As a member of the Hönle Group, Panacol offers a broad selection of high intensity LED curing equipment that is manufactured in Germany by Dr. Hönle AG. LED heads and arrays are compact, and can be positioned to create optimized curing processes offering the shortest possible cycle times.



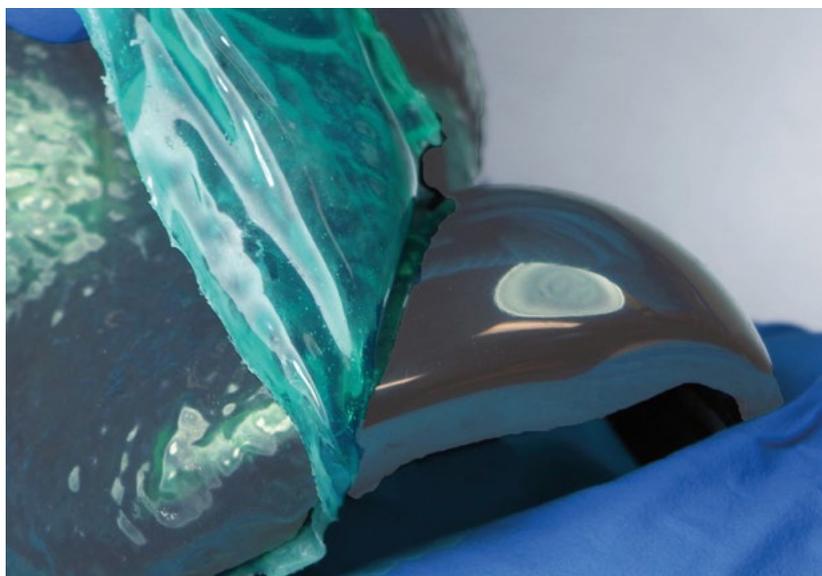
## UV Mask Removal

Panacol UV masking materials offer several options for quick and residue-free removal. The removal options include:

- Dissolving in agitated water or in an ultrasonic tank
- Peeling at room temperature
- Peeling at elevated temperature (pre-treatment with hot air or water)
- Oven burn-off (>900°F/500°C)



Choosing the appropriate UV mask removal option is dependent on the component configuration, type of process, and the allowable cycle time for completion. When fully cured, the Panacol UV masking material can be categorized as an industrial plastic, and should be disposed of in accordance with local regulatory requirements. Wastewater containing the water-soluble UV mask must also be disposed in accordance with local regulatory requirements. An analysis of the water may be required in order to identify the proper disposal method as residues from the manufacturing or overhaul process may be present. Exhaust emissions from burn-off grade UV masks are adequately removed with filters or scrubbers typically incorporated in furnace exhaust ducts.



### Variety of UV Masks

Panacol high performance UV curable masking materials are suitable for a variety of applications and industries. They are primarily designed to provide temporary surface protection for surface finishing applications including blasting, peening, and electroplating/anodizing. These UV masking materials can also be used when applying aggressive paints, powder coats, and heat resistant coatings. They are formulated to resist prolonged immersion in heated solutions of acids, degreasers, chemical stripping agents, and plating baths. For high-value metal-alloy components, these UV masks can be applied to form scratch resistant shells for safer handling and transportation. In a similar fashion, the useful life of fixturing that is used in processes such as grit blasting and peening can be extended with Panacol's UV mask materials.

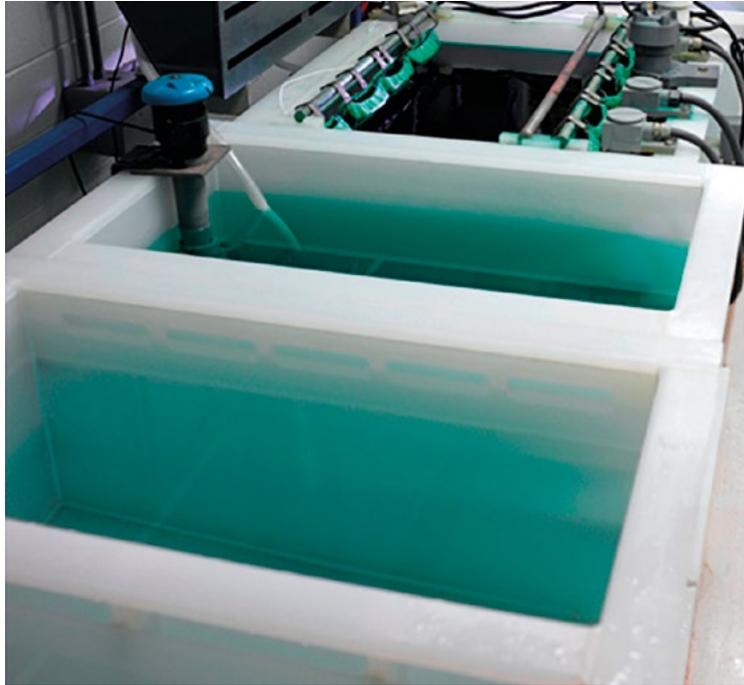
Panacol UV masks are perfectly designed to replace traditional application methods including temperature resistant tapes, waxes, solvent or water-based coatings, lacquers, and reusable boots. Applying these traditional masks is typically labor intensive. Depending on geometry, a single component may require hours of masking time. In addition, performance is not always consistent with traditional masks. Loose fitting boots, voids, and low adhesion tapes generate costly rework processes and scrap of high-cost components. Panacol UV masking materials can be applied quickly, accurately, and provide dependable, edge-to-edge surface protection.



### Turbine Component Masking

UV curable masking materials from Panacol are ideally suited for turbine component production and subsequent overhaul and repair operations. These UV masks provide the performance required for acid stripping, grinding, shot peening, plating, air flow testing, plasma coating, and some HVOF processes. In many lower impact processes, UV mask removal can be accomplished by a simple room temperature peel or a hot water dip and peel. For nickel alloy components that

undergo very rigorous processing, more resilient UV masks are utilized with substantially higher adhesion. Removal is best accomplished through incineration. Existing ovens used for component heat treating are usually sufficient for the required incineration process. Panacol's UV mask materials will burn cleanly, leaving no residue. Turbine blades, vanes, stators, nozzles, and transitions can be processed faster and with more consistent results.



### UV Masks for Orthopedic Devices

A segment of the Medical Device Industry can also benefit from these UV masking materials. Orthopedic implants made of metal alloys are exposed to grit blasting, polishing and coating processes. They require masking that provides superior surface protection and flawless performance. This is achievable with Panacol's UV masking materials. They are ideal for masking orthopedic screws, plates, and prostheses. The masks come off cleanly, leaving no residue behind.

The advantages of using Panacol-USA's masking products to protect high-value, labor intensive components and assemblies are significant:

### Advantages of UV Masks

- > Solvent-free, single coat application
- > Conforms precisely to component geometry
- > No surface residue after removal
- > Cures in seconds for continuous in-line processing
- > Easy application and removal after processing
- > Consistent performance for improved quality

Each of these advantages can be dollarized to reflect the actual process cost savings derived from using Panacol UV curable masking materials.

### Panacol UV Masking Materials

As an aid to product selection, an overview of Panacol UV Masks is shown in the table below.

Process	Vitalit® Mask					
	20100	20101	20102-G	20102-G GEL	20104	20107
Air Plasma/HVOF		x	x	x		
Acid Strip		x	x	x		
General Plating		x	x	x		
Plating of Nickel Alloys		x				
Anodizing			x	x		x
Grit Blast	x		x	x	x	x
Shot Peen	x		x	x	x	x
Machining or Grinding	x	x	x	x		x
Polishing	x		x	x		
Laser Drill						
Airflow Test						
Paint						x
Powder Coat						x
PCB Assembly/Coating						
Plastic Surface Masking						
Viscosity (mPas)	200 - 400	10,000 - 40,000	7,000 - 15,000	50,000 - 70,000	14,000 - 17,000	40,000 - 60,000
Features	Moderate adhesion water soluble mask	Hard, highest adhesion, acid resistant	High adhesion, durable, green color	High viscosity, thixotropic gel version of 20102-G	Moderate adhesion	Moderate adhesion
Application Method	Spray, needle, spatula	Syringe needle, spatula	Needle, spatula, dip, spray	Syringe needle, spatula, dip, spray	Syringe needle, spatula	Syringe needle, spatula, spray
Cure Method*	UV	UV or heat	UV	UV	UV	UV
Removal Method	Dissolve in hot agitated water	Incinerate @ 900°F or higher (approx. 500°C)	Peel after hot water soak, 2-3 minutes @min. 150°F/65°C	Peel after hot water soak, 2-3 minutes @min. 150°F/65°C	Peel @ room temperature	Peel @ room temperature
	*Note: Appropriate wavelength for UV curing and temperature					

If required, Panacol can modify existing products to create customized UV masking solutions for unique component designs and processes.

Vitalit® Mask							
20108	20109	20110	20111	20114	20115	20116	20117
x					x		x
x					x	x	
x					x		x
x					x	x	
	x		x				x
	x						
x					x		
				x			
	x	x					
	x	x	x				
	x	x	x				
			x				
			x				
7,000 - 9,000	15,000 - 40,000	50,000 - 70,000	30,000 - 50,000	90 - 150	thixotropic	50,000 - 70,000	20,000 - 30,000
Lower viscosity than 20101	Low adhesion	Very thick, low adhesion	Mask for protective coatings, wave solder, white color	Low viscosity cavity fill	Controlled flow properties, extremely clean burn-off	High viscosity cavity fill	Highest adhesion peelable mask, green color
Dip, spray	Syringe needle, spatula	Syringe needle, spatula	Needle, spray, jet dispense	Syringe needle, pourable	Dip, spray	Syringe needle, spatula	Syringe needle, spatula, spray
UV or heat	UV	UV	UV	UV or heat	UV	UV or heat	UV
Incinerate @ 900°F or higher (approx. 500°C)	Peel @ room temperature	Peel @ room temperature	Peel @ room temperature	Incinerate @ 900°F or higher (approx. 500°C)	Incinerate @ 900°F or higher (approx. 500°C)	Incinerate @ 900°F or higher (approx. 500°C)	Peel after hot water soak, 2-3 minutes @ min. 150°F/65°C

for secondary heat curing can be obtained from the TDS.

## Hönle UV and LED-UV Curing Systems for Panacol UV Masking Materials

A very wide selection of UV lamps and LED systems are available from Dr. Hönle AG. This provides manufacturers with the ability to maximize creativity when designing their optimal curing process. Shown below are several curing systems that are often used for curing Panacol UV masking materials:



### UVA Hand 250

Handheld, full spectrum UV curing system. Ideal for curing all UV mask materials on larger components and surfaces. Transformer

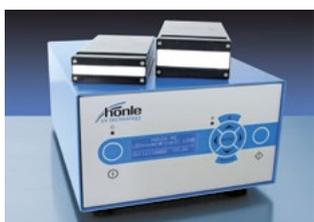
powered for simple operation and long bulb life.



### UVA Hand LED

Handheld, LED curing system offers convenience and high efficiency. It features instant on and off control. Available in

365nm and 405nm wavelengths which are ideal for Panacol UV masks.



### LED Powerline AC/IC

High intensity LED system for high-speed curing. Air cooled, compact heads can be mounted in any position to create efficient curing stations or conveyORIZED curing modules. The LED heads can be integrated into existing production processes and controlled through a remote PLC.



### LED Spot 100 HP IC

A wide area LED curing system that can be mounted over conveyors for in-line curing of Panacol UV masks. Multiple heads can

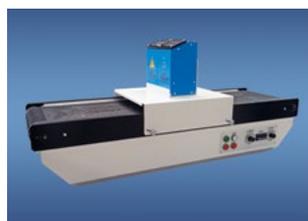
also be stacked together to create a stationary curing area for large, UV masked parts or multiples of smaller masked components.



### Bluepoint LED eco

High intensity LED system for curing small deposits of UV mask such as inside bores, cooling holes, etc. UV masked areas up to

20mm in diameter can be cured in 1-2 seconds. Power and program up to 4 individual curing heads from a single controller.



### ConVey LED Conveyor

Customized curing module that integrates LED curing and conveyORIZED parts movement. Ideally suited for curing UV mas-

king materials applied on small to mid-sized parts. The LED curing options are optimally matched with the UV mask and the desired production throughput.

Further information and our standard product range at  
[www.panacol.com](http://www.panacol.com)

### Contact us

**Panacol-Elosol GmbH**  
Stierstädter Straße 4  
61449 Steinbach  
GERMANY  
Phone: +49 6171 6202-0  
[info@panacol.de](mailto:info@panacol.de)  
[www.panacol.com](http://www.panacol.com)

**Eleco Panacol – EFD**  
125, av Louis Roche  
Z.A. des Basses Noëls  
92238 Gennevilliers Cedex  
FRANCE  
Phone: +33 1 47 92 41 80  
[eleco@eleco-panacol.fr](mailto:eleco@eleco-panacol.fr)  
[www.eleco-panacol.fr](http://www.eleco-panacol.fr)

**Panacol-USA, Inc.**  
142 Industrial Lane  
Torrington CT 06790  
USA  
Phone: +1 860 738 7449  
[info@panacol-usa.com](mailto:info@panacol-usa.com)  
[www.panacol-usa.com](http://www.panacol-usa.com)

**Panacol-Korea Co., Ltd.**  
#707, Kranz Techno  
388 Dunchon-daero  
Junwon-gu, Seongnam  
Gyeonggi-do, 13403 KOREA  
Phone: +82 31 749 1701  
[moon@panacol-korea.com](mailto:moon@panacol-korea.com)  
[www.panacol-korea.com](http://www.panacol-korea.com)

**Hoenle UV Technology  
(Shanghai) Trading Ltd**  
Room 821, No. 800  
Cimic Building Pudong  
Shanghai 200120, CHINA  
Phone: +86 21 64 73 02 00  
[info@hoenle.cn](mailto:info@hoenle.cn)  
[www.panacol.cn](http://www.panacol.cn)



Operating parameters depend on production characteristics and may differ from the foregoing information. We reserve the right to modify technical data. © Copyright Panacol-Elosol GmbH. Updated 03/2023.

Photos: Panacol; Adobe Stock/kimtar02008 (p.2, top)/murmakova (p.4, bottom); Permapack (p.5, middle); GettyImages/AdShooter (p.5)