

Processing Guidelines

Novacryl Interior Photopolymer

Recommended Processing Times

Main Exposure <i>With proper vacuum and UV lamps at 360nm (Stouffer Scale reading of 15-16)</i>	2:00-4:00 minutes
Washout <i>Tap Water at room temperature 65-75F</i>	5:00 minutes
Dry <i>Preheat dryer to 110F (43C)</i>	20:00 minutes
Post Exposure <i>With no vacuum and UV lamps at 360mns</i>	5:00 minutes

Processing Note: Please use caution when handling Novacryl immediately after processing. Strength will increase over 24-48 hours. You may wish to filter waste water before discharging into sewer. Refer to MSDS for recommended concentration of photopolymer effluent for disposal. Consult local authorities for regulations in your area. Please consult Nova Technical Support if any of the above processing times fail to produce satisfactory results. **Use only factory approved equipment for processing Novacryl.**

Shear Cutting Recommendations: All **Novacryl** products with a base thickness up to 1/8 can be sheared to a finished edge suitable for paint using an AccuCutter Finishing Shear and a Corner Mate radius cutter.

Routing Recommendations: Use a 1/2", 3 flute McMaster-Carr bit #35505A65 or a 3/4" two flute straight bit or DML #01401 (1/2" shank, 3/4" Diameter) 2 flute helix trim bit. For table routers, use a two flute upward spiral carbide bit.

Finishing Recommendations: All Novacryl products require a top coat to be applied after processing. Refer to our painting specifications for more details.

For more information visit our website www.novapolymers.com or call our Technical Support Team 1-888-484-NOVA