



# SpeedMask® Maskants

## Frequently Asked Questions

### Dispensing

**Q: Can I flush out the jetting valve with Acetone?**

**A:** The best choice is to flush the jetting valve with IPA. Acetone may leave a residue.

**Q: Can masking resins be used on spherical parts?**

**A:** SpeedMask® resins can accommodate the most complex and intricate configurations. The dispensing and curing system may need to be customized for the complete coverage and cure.



**Q: Would you recommend a ram pump or pressure pot to dispense the masking resins?**

**A:** We recommend a ram pump for dispensing maskant from 15-liter or 1-gallon pails. The ram pump will prevent cavitation when compared to a pressure pot.

### Curing

**Q: What curing equipment can be used for complex spherical surfaces?**

**A:** Please contact your local sales or Application Engineer to discuss simple customized cure options. A 360° cure can be achieved by spinning the component on a rotary table in front of multiple curing lamps. This set up will achieve full cure coverage.

**Q: Are SpeedMask® resins LED compatible?**

**A:** Yes. Some SpeedMask® resins such as 724, 726-SC, 728-G, 758-H, 7601, and 7602 are LED compatible. Please refer to the PDS for curing guidelines.

### Application and Product Specific

**Q: Is there a maskant that can withstand 200°F (93°C) for 172 hours?**

**A:** Before we can address this question, we need to obtain more application information.

**Q: Can I trim the maskant?**

**A:** SpeedMask® 730-BT, 734-BT and 744 are formulated to be trimmable and will maintain edge tension.

**Q: What thickness is recommended for a mask?**

**A:** 0.015" (0.38 mm) is the recommended minimum thickness for a mask. We suggest that during the product evaluation a few thicknesses are tested to determine the appropriate thickness sufficient to hold up to each customers' process.

**Q: Do any surface treatment processes cut into the maskant?**



**A:** Yes, some of the more aggressive surface treatment processes like plasma spray, HVOF, grinding and CNC machining will wear down the maskant. SpeedMask® resins are resilient to grit blast and shot peening type surface treatments.

**Q: How do you dispose of the cured maskant?**

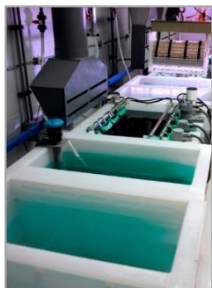
**A:** Cured maskant should always be treated in accordance with the local and state regulatory agencies. SpeedMask® resins are 100% organic materials and considered to be an industrial plastic after curing. If the maskant has been exposed to plating baths or other chemicals, the customer needs to consult their regulatory agency for guidance on disposal.

**Q: Are there SpeedMask® resins formulated with See-Cure technology?**

**A:** Yes, SpeedMask® 726-SC and 750-SC are available. 7601 and 7602 also exhibit color change upon cure.

**Q: Are there fluorescing versions of SpeedMask®?**

**A:** Yes, SpeedMask® 731-REV-A fluoresces yellow. SpeedMask® 7601 and 7602 fluoresce blue.



**Q: How long can I leave the mask on before it is processed in our plating bath?**

**A:** After completing the cure in accordance with the PDS curing guidelines, it is best practice to wait until the maskant returns to ambient temperature before processing it in a plating bath.

## Removal

**Q: Are there any ways to ease the removal of a cured peelable mask?**

**A:** The maskant can be exposed to warm air or ultrasonic bath at 150°F (66°C) for 3 to 5 minutes to ease the removal of the peelable maskant. Please consult INF048 - SpeedMask Removal Infographic for additional suggestions.

**Q: Is any residue left on the part's surface when the mask is removed?**

**A:** On porous surfaces, there is a chance the maskant can be trapped in the porous surface and leave behind a residue.

**Q: Can the mask be incinerated in a vacuum furnace process?**

**A:** SpeedMask® resins can be incinerated in either an air or vacuum furnace.

**Q: How long does it take to incinerate the mask?**

**A:** Each application is different. Incineration must be in either an air or vacuum furnace at a minimum of 1100°F (593°C), with 2000°F (1093°C) being the optimum temperature. The number of parts in the furnace, the amount of maskant applied per part, and the air flow in furnace all influence the speed of incineration.

**Q: I am using a Dymax peelable maskant. Can it be removed by incineration?**

**A:** Yes, both the peelable and burn-off grade masks can be removed with incineration with the exception of 724, 726-SC, 740-BT, and 7501-T-UR-SC which contain inorganic filler.

**Q: Can I remove cured masking resin with solvents?**

**A:** Maskants can be soaked in organic solvents to ease the removal. Duration of exposure is maskant/thickness dependent and should be tested individually

Adding bath agitation or elevated temperature during chemical soaking may help decrease exposure time.

**Q: Can I use a water jet to remove cured maskants?**

**A:** Yes, a water jet can remove some of the masking products. This removal process will need to be tested on a case-by-case basis.

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