
Technical Data Sheet



DLX®

HUMIDITY-RESISTANT DIAZO-PHOTOPOLYMER (DUAL-CURE) DIRECT EMULSION

DLX is formulated to reduce the acrylate odor and eliminate the surface oiliness that are characteristic of most dual-cure emulsions, especially under hot and humid conditions. As a result, positives are less likely to stick to the emulsion surface. Because of its high solids content (unsensitized, 38%), **DLX** dries rapidly. It is a brilliant blue color, so stencils are easy to inspect on white or colored fabric.

INSTRUCTIONS

Step 1: PREPARE THE FABRIC

Used or surface treated fabric need only be degreased using **Screen Degreaser Liquid No. 3** or dilute **Screen Degreaser Concentrate No. 33**. (Mechanical roughening is an option for new fabric that is not surface treated. It increases the surface area of fabric for a better mechanical bond of the stencil, increasing printing run length. Use **Microgrit No. 2** before degreasing. Roughening and degreasing can be combined in one step with **Ulanogel 23**.)

Step 2: SENSITIZE THE EMULSION

DLX is partially presensitized; therefore, it must be handled under yellow light. Dissolve the diazo sensitizer powder by adding lukewarm water up to the shoulder of the bottle. Shake 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 emulsion to debubble. Write the date of sensitizing on the label.

Step 3: COAT THE SCREEN

Method 1: Apply one coat of emulsion to the printing side, then one coat on the squeegee side. Dry the screen thoroughly.

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°. Dry the screen thoroughly.

Method 3: Follow Method 2. Then, after drying the screen, apply two additional coats on the printing side, wet-on-wet. Dry the screen again. Method 3 optimizes the definition of printed edges.

Step 4: DRY THE SCREEN

Dry multicoated screens (Methods 2 or 3) thoroughly in a horizontal position, printing side down, at room temperature in a dirt- and dust-free area. Use a fan to accelerate the drying. Avoid high humidity. Under humid conditions, dry the coated screen with warm, filtered air, up to 104°F (40°C) in a commercial dryer. Use a dehumidifier in the drying area, if possible.

Step 5: CALCULATE THE APPROXIMATE EXPOSURE TIME

From the Base Exposure Table below, select the type of light source you have and its wattage or amperage. The exposure times indicated are for 305/inch (120/cm.) white fabric at an exposure distance of 40 inches (= ca. 1 meter), using coating Methods 1, 2, or 3. The exposure time shown for your light source and coating method is your Base Exposure Time. Multiply your Base Exposure Time by all relevant Exposure Variable Factors (table, below) to find your Approximate Exposure Time.

Step 6: DETERMINE THE OPTIMAL EXPOSURE TIME

Make a Step Wedge Test (instructions can be found in the **Ulanogel Direct Emulsions Technical Data Booklet**) or use the **Ulanogel Exposure Calculator Kit**—carried through to actual printing—to determine your optimum exposure time. Optimum exposure is indicated: ■ At that exposure time when the emulsion first reaches its maximum color density and the edges of the positive do not "resolve." ■ The squeegee side emulsion is hard and not soft or slimy. ■ The print best duplicates the test positive *at the level of resolution that the job requires*.

Step 7: WASHOUT

Wet both sides of the screen with a gentle spray of cold water. Then spray the printing side forcefully 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 8: BLOCKOUT & TOUCHUP

Blockout Option 1: Before drying and exposure, use excess emulsion from the coating step to cover the blockout area.

Blockout Option 2: For non-water-based inks, after exposure and washout, dry the screen. Apply **Screen Filler No. 60** or **Extra Heavy Blockout No. 10**.

Touchup Option 1: With non aqueous inks, touch up with **Screen Filler No. 60** or **Extra Heavy Blockout** thinned with water.

Touchup Option 2: With aqueous inks, touch up with **DLX** thinned with water; then dry and re-expose it.

Technical Data Sheet



Step 9: RECLAIM THE SCREEN

Remove ink with the appropriate solvent. Rinse the screen with water. Degrease the screen with **Screen Degreaser Liquid No. 3** to remove ink residues. Rinse with forceful spray. Brush **Stencil Remover Liquid No. 4** or **Stencil Remover Paste No. 5** on both sides of screen. Do not let stencil remover dry on the screen. Wash with forceful spray of water. Use **Haze Remover Paste No. 78** or **Ghost Remover** and **Ghost Remover Activator** to remove ink and haze residues.

BASE EXPOSURE TABLE (For 305T/in (120T/cm) white polyester or nylon at 40 in (100 cm) exposure distance.)

Carbon Arc	Coating Method 1	Coating Method 2	Coating Method 3
15 amps	192 sec.	10 min.	12 min.
30 amps	96 sec.	5 min.	6.5 min.
40 amps	72 sec.	216 sec.	5 min.
60 amps	48 sec.	144 sec.	192 sec.
110 amps	26 sec.	80 sec.	108 sec.
Metal Halide			
1000 watts	44 sec.	124 sec.	164 sec.
2000 watts	22 sec.	62 sec.	82 sec.
3000 watts	15 sec.	41 sec.	52 sec.
4000 watts	11 sec.	31 sec.	41 sec.
5000 watts	8 sec.	24 sec.	31 sec.
Pulsed Xenon			
2000 watts	116 sec.	5.5 min.	6 min.
5000 watts	46 sec.	134 sec.	180 sec.
8000 watts	29 sec.	84 sec.	115 sec.
Mercury Vapor			
250 watts	231 sec.	11 min.	14 min.
2000 watts	29 sec.	82 sec.	106 sec.
4000 watts	15 sec.	41 sec.	52 sec.
Fluorescent Tubes*			
FT 40 watts	144 sec.	6 min.	Not recommended

*Base exposure times are for unfiltered black light, or super diazo blue tubes, at 4-6' (10-15 cm) exposure distance. For plant-light, filtered black light, and "daylight" tubes, use double the time at least.

EXPOSURE VARIABLE FACTORS (Factors for Variables Affecting Base Time)

Fabric:		Viscosity Adjustment:
Steel/metalized polyester	2.0 - 4.0	5% dilution 0.95
Dyed Fabric	1.5 - 2.0	10% dilution 0.9
305T white polyester or nylon	1.0	5% more viscous 1.1
Finer than 330T (130T/cm)	0.7 - 0.9	
Coarser than 250T (100T/cm)	1.1 - 2.0	
Multifilament PET	1.3 - 1.5	High Heat and Humidity:
Exposure Distance:		Factor 1.3-1.8
20"/50cm 0.25	36"/90cm 0.81	
24"/60cm 0.36	40"/100cm 1.00	Taped-up Positives:
28"/70cm 0.49	52"/130cm 1.69	Factor 1.2-1.3
32"/80cm 0.64	60"/150cm 2.25	

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