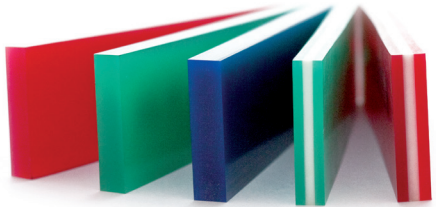


# serilor®SR

## Standard resistance squeegee



**serilor®SR** squeegee is an all purpose polyurethane blade with good combined resistance to chemicals and abrasion. It was developed to withstand various applications in screen printing. The industry standard S1 is a universal grade, your ideal choice for non critical abrasive application or when using common screen inks.

**serilor®SR** blades are manufactured with a centrifugation process to avoid bubbles and craters in the material and to bring optimal homogeneity to the compound, even at the core of the material and after grinding. Our exclusive computer controlled casting process guarantees batch to batch consistency.

### ADVANTAGES :

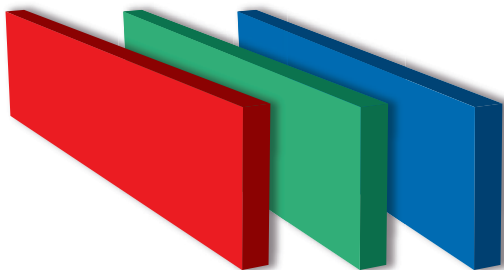
- Good resistance to chemicals & abrasion
- Resistance to abrasion
- Sharpens easy
- Color coded for easy identification
- High environment stability
- Individual package and batch

### APPLICATIONS :

- Graphics multi-purpose
- Textile printing
- Manual or automatic equipment use

**Marking:** serilor®SR[1 or 3] length X width X thickness Profile hardness [batch N°] MADE IN FRANCE

### serilor®SR1 - Mono layer standard references



soft 65shA red    medium 75shA green    hard 85shA blue

*60,70,80,90 and other durometers are available as specials.  
Other colors on request.*

### serilor®SR3 - Triple layer standard references



Triple medium (75/90/75shA)    Triple soft (65/90/65shA)  
Green/white/Green    Red/white/Red

Recommended when high speed automatic printing equipment is used, **serilor®SR3** has a 90shA hard center layer for support, ideal for fine lines and halftone printing. Using Triple durometer squeegees will extend your squeegee life, help prevent dot gain, and generate immediate savings on ink and other consumable through better control of the squeegee pressure.

### Standard Dimensions: 50 x 09 mm / 2"x3/8"

| SPECIFICATIONS |                 | TOLERANCES   |
|----------------|-----------------|--|
| Length         | 3660 mm / 12 ft | ≥ 3640 mm  |
| Width          | < 50 mm (2")    | ± 1 mm   |
|                | ≥ 50 mm         | + 1 / -2 mm  |
| Thickness      | 4-12mm          | ± 0.4mm  |
| Hardness       | 60 to 90 shA    | ± 3 shA<br>No more than 2shA between the 2 sides of a squeegee |

### Standard profiles:

- P0: Straight square edge
- P1: Double bevel + flat land 60° angle + 1mm flat (±0,5mm)
- P2: Single bevel + flat land 45° angle + 1mm flat (±0,5mm)
- P3: Round bevel
- P5: Double bevel (V type)
- P6: Single bevel 45° angle
- D: «Diamond» square profile



## INSTRUCTIONS

In general softer grades (65sh) are used for increased ink deposits and high coverage printing. Harder grades (85sh) are used for reduced deposits, notably when printing UV inks for fine texts and higher line counts.

Do not apply excessive pressure on squeegees as this makes your ink deposit heavy, uncontrollable and creates excessive wear. It is recommended that your squeegee slightly exceeds the printed image in size. Make certain to leave significant free space between both ends of your squeegee and the inside of your frame.

Gently insert the squeegee in a machine or hand holder. Use appropriate squeegee thickness to avoid forcing the blade in the holder. If the holder construction allows for it, regularly change the printing side of the squeegee to minimise the effect of bending with speed and pressure. Rotate your squeegee: do not wait until mechanical & chemical wear permanently bends back your blade to replace it by a fresh one and allowing it to relax, flat, for up to 24 hours.

### • CLEANING

Remove excess of ink with a cardboard or a soft cloth. Wash blade with a cloth saturated with appropriate cleaning chemicals. Avoid the use of aggressive chemicals, in particular ink thinners. Let the squeegee rest and the chemicals evaporate before re-use or sharpening.

### • SHARPENING

**serilor®SR** squeegee blades can be sharpened by all methods commonly used in the screen printing industry (Fimor offers an extensive range of diamond wheel sharpeners, please contact us for more information).

- Belt grinders
- Wheel sharpeners
- Knife cutting machines

Sharpen dry squeegees only. Never allow a squeegee with solvents to be sharpened and don't wash a hot, freshly sharpened blade with chemicals. Do not try to grind excessive material in one pass.

Precision printing requires a preventive sharpening to accommodate the squeegee edge to the holder shape.

### • STORING / SHELF LIFE

For all medium or long term storage, blades must be kept flat, unrolled, especially prior to use. Store in a dry cool place away from any direct source of light. If the squeegee is exposed to extreme temperature and humidity conditions, its hardness characteristics may be altered.

### PHYSICAL AND CHEMICAL SPECIFICATIONS (for 75 shA SR1 grade)

| PROPERTIES                                     | Units           | Norms    | Values  |
|--|-----------------|----------|---------|
| Shore hardness at 20°C                         | shA             | DIN53505 | 75      |
| Tensile modulus at 100% elongation             | MPa             | DIN53504 | 3.0     |
| Tensile modulus at 200% elongation             | MPa             | DIN53504 | 4.2     |
| Tensile modulus at 300% elongation             | MPa             | DIN53504 | 5.2     |
| Tensile strength                               | MPa             | DIN53504 | 46.8    |
| Tensile strain at break                        | %               | DIN53504 | 1350    |
| Tear resistance (non initiated tear)           | KN/m            | DIN53515 | 68.3    |
| Tear resistance (initiated tear)               | KN/m            | DIN53515 | 27.2    |
| Abrasion loss                                  | mm <sup>3</sup> | DIN53516 | 20      |
| DRC ( 25% of crushing during 22 hours at 70°C) | %               | DIN53517 | 64      |
| Density  |                 |          | 1.24    |
| Working temperature                            | °C              |          | -10/+60 |
| Storage temperature                            | °C              |          | +15/+25 |



DISTRIBUTOR



MADE IN FRANCE

[www.fimor-serigraphy.com](http://www.fimor-serigraphy.com)

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