



# 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. Each serilor® SR blade is inspected for edge quality and profile.

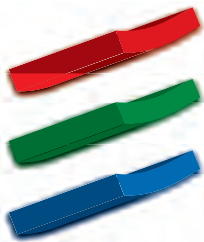
## Advantages:

- 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

### serilor® SR1 Mono layer



**Marking:** serilor® SR1 length X width X thickness Profile hardness [batch N°] MADE IN FRANCE

#### Standard hardnesses :

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 layers



**Marking:** serilor® SR3 length X width X thickness Profile hardness [batch N°] MADE IN FRANCE

Recommended when high speed automatic printing equipment is used, serilor® SR3 has a 90shA hard centre 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 combinations :

Triple medium (75/90/75shA)  
Green/white/Green

Triple soft (65/90/65shA)  
Red/white/Red

| Specifications : |                 | Tolerances :  |
|------------------|-----------------|---|
| Length :         | 3660 mm / 12 ft | ≥ 3640 mm   |
| Width :          | < 50 mm         | ±1,0 mm   |
|                  | ≥ 50 mm         | +1 / -2 mm  |
| Thickness :      | 4 - 12 mm       | +0,4mm / -0,4mm   |
| Hardness :       | 60 to 90 shA    | ±3 shA<br><small>no more than 2 shA between the 2 sides of a squeegee</small> |

## Standard Profiles:

**P0:** Straight Square Edge

**P1:** Double Bevel + Flat land  
60° angle + 1mm flat (±0,5mm)

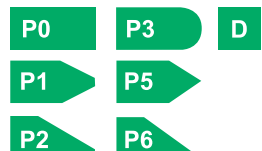
**P2:** Single bevel + flat land 45°  
angle + 1mm flat (±0,5mm)

**P3:** Round angle

**P5:** Double Bevel (V type) 60° angle

**P6:** Single Bevel 45° angle

**D:** "Diamond" square profile (±0,3mm)



## 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 and uncontrollable and creates excessive wear. It is recommended that your squeegee slightly exceeds the printed image in size, and to leave significant free space between your screen edge and both squeegee ends.

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 bends permanently 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 an impregnated cloth or in an appropriate cleaning machine. 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 extended range of diamond wheel sharpeners, please contact us for more informations).

- 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               | DIN 53505 | 75     |
| Tensile modulus at 10% elongation               | MPa               | DIN 53504 | 1.10   |
| Tensile modulus at 100% elongation              | MPa               | DIN 53504 | 4.45   |
| Tensile modulus at 200% elongation              | MPa               | DIN 53504 | 7.40   |
| Tensile modulus at 300% elongation              | MPa               | DIN 53504 | 13.30  |
| Tensile strength                                | MPa               | DIN 53504 | 50     |
| Tensile strain at break                         | %                 | DIN 53504 | 450    |
| Tear resistance (non initiated tear)            | KN/m              | DIN 53515 | 89     |
| Tear resistance (initiated tear)                | KN/m              | DIN 53515 | 22     |
| Resilience                                      | %                 | DIN 53512 | 24     |
| Abrasion loss                                   | mm <sup>3</sup>   | DIN 53516 | < 50   |
| DRC (25% of crushing during 22 hours at 70°C)   | %                 | DIN 53517 | 48     |
| Shore hardness at -5°C                          | shA               | DIN 53505 | 85     |
| Shore hardness at +80°C                         | shA               | DIN 53505 | 73     |
| Specific gravity                                | g/cm <sup>3</sup> |           | 1.18   |
| Swelling in solvent (70% dihydrofuranone basis) | %                 | ISO 175   | < 30   |

Manufactured by:



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CALL US  
888-578-5713

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### ENCORE / FIMOR North America

5404 Ashton Ct. Ste. D  
SARASOTA - FL - 34233 - USA  
Ph : +1 800 922 5138 / +1 941 921 5138  
Fax : +1 941 921 5434  
email : [sales@encoreenginc.com](mailto:sales@encoreenginc.com)



### HEADQUARTERS 210 rue du Polygone

cedex 2 - 72058 LE MANS - FRANCE  
Tel : +33 (0)2 43 40 66 00 Fax : +33 (0)2 43 40 00 95  
<http://www.fimor.fr> / email : [serilor@fimor.fr](mailto:serilor@fimor.fr)



### FIMOR China

N° B-22, Diamond Villa, Changan County  
Dongguan City, Guandong Province CHINA  
Ph : +86 769 85337821 Fax : +86 769 85337820  
email : [fimorchina@changan.net](mailto:fimorchina@changan.net)

