

PROCESSING GUIDELINES

Storage

The ink should be stored in a cool, dry place away from direct sunlight and with adequate ventilation. The shelf-life of the ink in unopened containers is a minimum of 6 months at 20°C. Do not freeze the ink.

Mixing

The ink should be used as supplied (dilution should be avoided). To re-disperse any solids that settle during prolonged storage, the ink should be gently mixed by hand, taking care to reach the bottom of the container. Vigorous mixing can lead to air entrapment and is unnecessary.

Screen Printing

The ink may be used with either manual or semi-automatic screen printers. Screen mesh size will serve to determine print thickness achieved and both stainless steel and polyester screens may be used. A standard polyester screen with a mesh size of 325 wires / inch and an emulsion thickness of 5 µm will result in a cured deposited thickness of typically 18 µm. Use either one or two print passes depending on the application.

Curing

The physical properties of the cured film are dependent on the conditions that are employed during cure and the customer should run a cure ladder experiment to establish optimum cure conditions with their curing equipment.

In-house curing has been done using a UVP BC-300 bench-top system fitted with a medium pressure mercury bulb at 300 watts/inch intensity at a belt conveyor speed of 30 ft/min in air. This equates to 0.3 - 0.4 J/cm² as measured with an EIT, Power Puck II radiometer.

Clean-up

Any uncured product can be cleaned with isopropanol.