

PermaMark Pad Printing Ink Selection Guide

This chart is only a guideline for the selection of inks and auxiliaries for printing on a specific substrate. Permanency testing should be conducted before final ink selection. Please refer to the corresponding technical bulletins for each ink.

Ink Type		AP	TF	PO	PM	SS	SG	21F	PL	NP	FL	CI	21H	21Q	Thinning Solvents
		(1 or 2 part)	(1 part)	(1 part)	(1 or 2 part)	(1 part)	(1 part)	(2 part)	(1 part)	(1 or 2 part)	(1 part)	(1 part)	(1 part)	(1 part)	
Substrates	Acrylics	R	R		R	R	R	R			R		R	R	<u>RA Series</u> <i>fast</i> RA-100 RA-150 RA-200 RA-250 RA-300 RA-400 <i>slow</i>
	Coated Substrates	O	O			O	O	R	O				O	O	
	Duroplastic Materials	O			O			O							
	Glass				O*			O				O			
	Wood	R	R			R	R	R	R						
	Ceramics											R	O	O	
	Leather	O	O					O	O						
	Metal and Nonferrous Metal	O			O			R	R			R	O	O	
	Phenolic Material	O						O				R			
	Polyamid	O			O			O							
	Polycarbonate	R	R		R	R	R	R	R		R		R	R	
	Polyester Treated	R	R					R	R				O	O	
	Polyester non-Treated								R						
	Polyethylene Treated	O		R				R	R		O				
	Polypropylene Treated	O		R	R			R	R	R					
	Polypropylene non-Treated			R						R					
	Polystyrene, ABS, SAN	O	O		R	R	R	O			R		R	R	
	Polyurethane	O						O							
	PVC Rigid	R	R		R	R	R	R	R		R		R	R	
PVC soft, Pressure Sensitive Film	R	R			R	R	R	R							
Cure Method	Air Dry	X (1 part)	X	X	X (1 part)	X	X		X	X	X				<u>CI Series</u> <i>fast</i> 21B-200 X Base <i>slow</i>
	Chemical (hardener)	X (2 part)			X (2 part)			X		X					
	Heat											X			
	UV Light												X	X	
	Oxidative														
Colors	High Opaque	X			X										<u>UV Series</u> 21H-000 <u>21F Series</u> 21F-000
	Standard	X	X	X	X	X	X	X	X	X		‡	‡		
	Basic	X	X	X	X	X	X	X	X	X					
	Specialty	X	X	X	X	X	X	X	X	X	X				
Auxiliaries	Thinner Series	RA	RA	RA	RA-150	RA	RA	21F	RA	RA	RA-250	21B	21H	RA	
	Thinner Percentage	20-30	20-30	20-30	20-30	25-30	25-30	5-10	20-30	20-25	20-30	0-10	0-10	0-10	
	Hardener	HG-100			HG-300			21F-100		HG-200					
		HG-200													

R = Recommended O = Occasionally

‡ = Available in Black, White, & Limited Colors

*When used with hardener and heat cured.

AP060010; Iss. 03/12; Rev. 10.0