



## Description

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Perma PM Inks are fast printing single or two component inks used in a wide variety of pad printing applications. These high gloss inks show very good resistance to chemicals such as alcohol, inorganic acids, cleaning agents, and fuels. PM Inks can also withstand heat exposure up to temperature of 260°F with no adverse effects.

## Applications

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|---------------|-------------------------|
| * Polystyrene | * Metals                |
| * ABS         | * Acrylics              |
| * SAN         | * Polycarbonates        |
| * PVC         | * Polypropylene         |
| * Polyamide   | * Duroplastic Materials |
| * Glass       |                         |

**Note:** When increased chemical resistance is required, hardener should be added to ink. When printing on polypropylene, surface should be pretreated with a flame or corona process prior to printing.

## Mixing Instructions

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Thoroughly mix all thinners, hardeners, and matting agents with the ink prior to use.

**Thinning Solvents** – Mix ratio by weight: 20-30% thinner

RA-50 Thinner	Fast
RA-100 or *RA-150 Thinner	↓
RA-200 Thinner	↓
RA-300 Thinner	↓
RA-400 Retarder	Slow

\*Contains no Cyclohexanone

**Hardener** – Mix ratio by weight: 1 part hardener to 10 parts ink

	<u>Ink Pot Life</u>	<u>Substrate Restrictions</u>
HG-300 Hardener	6-8 hours	None

**Matting Agent** – Mix ratio by weight: up to 10%

MA-100 Additive

## **Drying and Curing**

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Perma PM Ink dries to the touch within seconds, but resistance testing should not be performed until ink has fully cured. Under normal ambient conditions, two component Perma PM Ink requires 7 days to completely cure. Increasing drying temperature will significantly reduce cure time and improve adhesion.

Following is the recommended cure time for specific temperatures:

<u>Temperature</u>	<u>Cure Time</u>
Ambient	7 Days
140°F	2 Days
250°F	20 Minutes

## **Cleaning**

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Perma RA-200 Thinner are recommended for cleaning Perma PM Inks. All equipment and utensils should be cleaned immediately after use. Once Perma PM two component ink has hardened, it will become solvent resistant and extremely difficult to clean.

## **Storage**

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Perma PM Inks, RA Thinning Solvents and HG-300 Hardener should be stored at room temperature between 15° and 25° Celsius.

Perma PM Inks and RA Thinning Solvents can be stored up to 4 years in a tightly sealed container without any adverse effects to the product quality.

Perma HG-300 Hardener should be used within 3 months from date of delivery. Opened hardener containers should be immediately sealed after use to prevent chemical reactions with moisture in air.

## For Additional Information

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