



## Description

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Perma 21F Series inks are high gloss two component inks used for printing a wide variety of materials. When fully cured they have exceptional resistance to common chemicals, grease, cosmetics and detergents. Perma 21F inks possess excellent adhesion to difficult printing surfaces such as aluminum, copper, brass and steel. They can also be used for laminating applications where a high heat resistance is needed.

## Applications

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|-------------|-------------------------|
| * Melamines | * Metals                |
| * Glass     | * Coated Metals         |
| * Ceramic   | * Treated Polypropylene |
| * Phenolics | * Treated Polyethylene  |

**Note:** Polypropylene and polyethylene require surface be pre-treated with a flame or corona process prior to printing.

## Mixing Instructions

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### Thinning Solvent

21F-000 Thinner	Fast Evaporation
21F-200 Retarder	Slow Evaporation

### Hardener

21F-100 Hardener	Ink Pot Life: 6-8 hours
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### Hardener Mixing Ratio (by weight)

<u>21F Series Ink</u>		<u>21F-100 Hardener</u>		<u>21F Thinner</u>
4 parts	to	1 part	+	5-10%

## **Drying and Curing**

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Perma 21F Series ink dries to the touch within 30 seconds, but resistance testing should not be performed until the ink has fully cured. Under normal ambient conditions, Perma 21F ink requires 72-96 hours to completely cure. Increasing drying temperature will significantly reduce cure time and improve ink adhesion.

## **Cleaning**

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Perma RA 200 thinner is the recommended cleaning solution for all Perma 21F Series inks. All equipment and utensils should be cleaned immediately after use. Once ink has hardened, it will become solvent resistant and extremely difficult to clean.

## **Storage**

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Perma 21F Ink and Thinning Solvent should be stored at room temperature between 15° and 25° Celsius. It can be stored up to 1 year in a tightly sealed container without any adverse effects to the product quality.

Perma 21F-100 Hardener should be used within 6 months from date of delivery. Opened hardener containers should be immediately sealed after use to prevent chemical reactions with moisture in the air.

## **For Additional Information**

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