

Ink Technical Data Sheet - 417

Ink type **417** is a glossy, two-component, opaque, fast drying ink formulation. When fully cured, it provides outstanding resistance to: Abrasion / Chemicals / Diluted Acids / Diluted Alkalis / Mechanical wear / Oil & Grease / Organic Solvents / Perspiration / Product Contents. (See back side of sheet for recommended substrates)

Use Instructions

Read Material Safety Data Sheets Prior To Using

Ink type **417** is a two-component product supplied in paste form. Hardener must be added for production use. Ink and hardener should be thoroughly mixed prior to adding thinner. During use, the ink viscosity may be adjusted with thinner (as needed). A retarder may be added to slow drying rate during printing. (Required for high room temperatures or multi-color use) Under most conditions, ink pot life will not exceed 8 hours. Recommended room temperature: 70-78 degrees F. Recommended room humidity: 30-50 %

Additives

See Additives Chart for More Listings

Hardener: BH/N HARDENER 4:1 Ratio by weight

Thinner: THINNER B	5 To 20 % by weight	Faster
VD THINNER	5 To 20 % by weight	Medium
THINNER BGA	5 To 20 % by weight	Slower

Retarder: TPD RETARDER 1 to 3 % by weight

Drying & Curing

Ink type **417** dries to the touch within 30 seconds at room temperature. Drying time may be reduced with forced hot air @ 200 - 400 Degrees F. Normally, full cure is achieved after 5 to 6 days depending on curing temperature, time, and humidity. Heat curing is necessary for better adhesion and performance results.

Colors

Custom Colors Available Upon Request

Ink Type 417 is available in:

- * 23 Standard Opaque Colors
- * Standard Metallic Colors
- * Process colors
- * C-Mix 2000 Color Matching System

Our NT Series Inks conform to US C.O.N.E.G. Legislation and European Standard EN 71, part 3 Safety of Toys (1989) For special applications - examples, Medical, Automotive, MIL-STD please call

Use & Storage Information

***For more information see Material Safety Data**

Sheets*Ink type **417:** Stir ink thoroughly before removing from container. Reseal lid tightly after using.

Shelf Life: 2 years (Original sealed container)

Hardener: Reseal container immediately after using. Hardener is humidity sensitive. As moisture is absorbed the viscosity first increases, then starts forming crystals. Do not use when crystals first appear.

Shelf Life: 1 year (Original sealed container)

Thinner: **Shelf Life:** 2 years (Original sealed container)

Storage of Products: At room temperature 60 to 80 Degrees F with low humidity

Recommended Printing Substrates (Type 417 continued)
May Require Pretreatment

SUBSTRATE NAME / CHEMICAL NAME	ASTM / ISO ABBREVIATIONS	PLASTICS FAMILY	TRADE NAME
THERMOPLASTICS			
Acrylonitrile-Butadiene- Styrene	(ABS)	ABS	Cyclac
Polymethyl Methacrylate	(PMMA)	Acrylic	Acrylite
Cellulose Acetate	(CA)	Cellulosic	Tenite
Polyphenylene Oxide*	(PPO)	Polyphenylene	Noryl
Polyamides	(PA)	Polyamides	Nylon
Polycarbonate	(PC)	Polycarbonate	Lexan
Polypropylene *	(PP)	Polyolefin	
Polyvinyl Chloride Rigid	(PVC)	Vinyl	
METALS			
Aluminum	(Al)		
Anodized Metal			
Steel			
Miscellaneous Metals			
FLEXIBLE PLASTICS			
OTHERS			
Polycarbonate / ABS			Cycloy

****Since operating conditions and applications are beyond our control, Trans Tech can not guarantee results, nor assume liability for any problem that may arise.**

The user should test the suitability of the product for its intended application. No warranty for results obtained, expressed or implied, can be assumed by Trans Tech.