

# Pad Printing Ink

## Type 438

### Ink Data Sheet

**NOTE: Read Material Safety Data Sheet (MSDS) Prior To Use**

#### **Application:**

Ink Type 438 is a 2-component ink which is processed with hardener 440. This product is especially suited for printing onto silicone rubber substrates. Ink 438 does not contain conventional solvents (100% solids).

#### **PAD PRINTING:**

Ink Type 438 is supplied in paste form. This ink is recommended for sealed cup as well as open ink well pad printing systems.

Ink Type 438 will not dry until heat is applied. The transfer pad will not transfer the complete film thickness & it is necessary to clean the remaining ink after use. (Pad cleaner 1411121)

Recommended cliché depth for pad printing is 23 to 25 microns, depending on type of cliché. The ink can be applied single or double hit. If a double hit is required, additional cure time may be needed.

Recommended room temperature: 70-78 degrees F. Recommended room humidity 30-50 %

**PROCESSING:** Using a gram scale combine the ink 438 with the hardener 440. The mixing ratio of ink to hardener is 10:1 by weight.

#### **ADDITIVES:**

Thinner: Thinner VD For most applications 15 to 30% by weight.

Special: 439 Adhesion Promoter when needed 1 to 2% by weight.

Other: Fuller 33 at 6 % by weight for write-on capable Ink

#### **DRYING & CURING:**

An oven-cure for 15 minutes at of 160°C is recommended. The pot life of the ink & hardener mixture is approximately 24 hours.

INK-438 conforms to RoHS, REACH, US C.O.N.E.G. Legislation and European Standard EN 71, Part 3 Safety of Toys.

**STORAGE OF ALL PRODUCTS:** At room temperature 60 to 80 Degrees F with low humidity.

*\*\*Since operating conditions and applications are beyond our control, Trans Tech cannot 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.*



#### **Trusted Partner for Your Product Decorating Needs**

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