



TECHNICAL DATA SHEET

2-COMPONENT SEMI-PASTE EPOXY A-A-56032

PRODUCT

A two-component semi-paste epoxy. Meets CID A-A-56032 (formerly MIL-I-43553) Type I, II & III.

PROPERTIES

Superior adhesion to epoxy, glass, metal or other nonporous surfaces. Excellent resistance to abrasion, MEK, alcohol, TCE, flux removers, salt, acid and alkali solutions when properly cured. Cures at room temperature.

COLORS:

Standard EIA colors: red, orange, brown, yellow, green, blue, violet, white, gray, black, and silver. VOC for Black when mixed is 3.07 lbs/gallon.

CURE CYCLES:

This is a room temperature cure ink, dries to handle in 6-8 hours and requires 4-7 days to develop solvent resistance. May also be force cured by heating at one of the following time/temperature cycles:

250 Degrees F (121 C)	30 Minutes
300 Degrees F (149 C)	10 Minutes
350 Degrees F (177 C)	6 Minutes

POT LIFE:

Under normal conditions, 4-5 hours after the two components are mixed. Higher room temperature will shorten pot life. Storage temperature 40- 90 Degrees F.



TECHNICAL DATA SHEET

SHELF LIFE:

Use within one year from date of manufacture is recommended. Storage in refrigerator is suggested.

MIXING INSTRUCTIONS:

For all colors except silver, mix 2-parts ink to 1-part catalyst by weight. For silver, mix 2.4-parts ink to 1-part catalyst by weight. Allow an induction period of 30 minutes to achieve best results.

When used with a rubber stamp, roll the ink into a thin draw down on a glass, metal or plastic plate with a Breyer roller or similar device before transferring to the stamp.

THINNER:

Use a minimum amount to achieve desired consistency. Use only recommended thinner, as use of other thinners will adversely affect this product. Use only #0126 Thinner. Thinners should be used sparingly, if at all. Excessive use of thinners will result in poor cured ink properties.

CLEANER:

Use only recommended cleaner with this product for best results.
Use #0127 Cleaner.

Neither the manufacturer nor the seller shall be liable for any injury, loss or damage arising out of the use of this product. The only obligations of the manufacturer or the seller shall be to replace any quantity of this product found to be defective or, at the option of the seller or manufacturer, to refund the purchase price. The purchaser or user of this product should, before use of the product, determine whether it is suitable for that use. The user assumes all risk and liability in connection with that use.

THE FOREGOING IS IN LIEU OF ALL OTHER WARRANTIES EXPRESSED OR IMPLIED.



TECHNICAL DATA SHEET

SUGGESTION FOR USING EPOXY INKS

For best results, when using epoxy inks, surfaces to be printed must be clean and dry. The work area must also be clean including the air. Any acid or alkaline contamination will result in poor adhesion and poor chemical resistance of the cured ink.

When using two-part epoxy inks, the portions of ink and catalyst must be weighed accurately and mixed thoroughly. These two-part epoxy inks are cured at room temperature, however, they may be force cured by heating. Please refer to the recommended cure schedule on the data sheet for the particular ink you are using. When the pot life of the ink is ending, the ink becomes increasingly difficult to manipulate, resulting in poor printing. Do not add thinner at this time. To prevent poor adhesion and poor chemical resistance in the cured ink, discard the “old” ink and mix fresh portions of the ink and catalyst together.

One component epoxy inks do not require separate catalyst. The catalyst is already incorporated, and the ink requires heat to cure. The minimum temperature for satisfactory cure is 250 degrees F. Heat shortens the shelf-life of the one component inks, so for best results, store in a cool place. Discard any ink that acts rubbery or that is over one year old.

Semi-paste Epoxy inks are recommended for manual or automatic rubber stamp and offset equipment. For manual applications, place a small amount of ink (mixed with catalyst if using a two-part system) on a smooth, flat, clean plate of glass, aluminum or stainless steel. Roll it out to a very thin film and ink the rubber stamp from there. This gives a sharper and clearer print than the silkscreen versions of the Epoxy inks.

Thinners should be used sparingly, if at all. Excessive use of thinners will result in poor cured ink properties. If a lower viscosity ink is required, use the silk screen Epoxy inks or call for technical assistance.