

## 1. APPLICATION FIELDS:

Versatile one or two component ink for pad and screen printing on:

- ABS,
- acrylic glass,
- rigid PVC,
- pre-treated PE and PP,
- coated surfaces (wood),
- SAN,
- PA,
- PET,
- polycarbonate,
- polystyrene,
- paper and carton

While printing on plastics such as ABS, acrylic glass and styrene tension corrosion can appear while using certain solvents.

Substrates may differ in their chemical structure or method of manufacture. A test for suitability must always be carried out before printing. Antistatic, Mould Release Agents and Slip Additives may have negative effects on adhesion, and should be detected and removed prior to printing.

## 2. CHARACTERISTICS:

This glossy, physically drying and chemical reactive printing ink exhibits good mechanical and chemical resistance, as well as a good flexibility.

The T200 series is

- **free from phthalates and BPA as well as cyclohexanone, butyl glycolate and aromatic solvents**

Provided they are printed in a proper and professional way, the printing inks of series T200 can be applied to the non-food contact surface of food packaging materials and articles.

The T200 series can be printed with fast drying units up to 4000 parts/hour in pad and screen printing machines.

A special product test is recommended prior to production.

The used raw materials comply with the limits of metal elements stipulated by the actual EEC regulation *EN 71-3 (Safety of Toys), part 3* (Migration of Certain Elements).

*For Gold- and Silver as well as Metallic inks it is recommended to proof if the thresholds for aluminum, copper and zinc are respected.*

## 3. RANGE OF COLOURS:

The basic ink mixing system consists of 10 basic colours and may be used for the mixing of a wide colour shade range. Field proven mixing formulations exist for Pantone®, HKS, RAL, NCS, etc.

### 3.1 Basic colours:

Light Yellow	M 01	T200-2000
Medium Yellow	M 02	T200-2001
Orange	M 03	T200-3000
Light Red	M 05	T200-3001
Pink	M 06	T200-3002
Violet	M 07	T200-5000
Blue	M 08	T200-5001
Green	M 09	T200-6000
White	M 11	T200-1000
Black	M 12	T200-9000
Clear Base	M 0	T200-0001

### 3.2 Euro-Colours / 4-Colour Process Printing Inks:

For 4-colour process printing according to ISO 2846, 4 Euro-basic colours are available:

Process -Yellow	T200-2002
Process - Magenta	T200-3003
Process - Cyan	T200-5002
Process - Black	T200-9001

### 3.3 Special products:

White (high opaque)	T200-1004
Black (high opaque)	T200-9002
Printing White	T200-1007
Printing Black	T200-9023
Raster Paste (max. addition 10%)	T200-0005
Overprinting Lacquer	T200-0006

#### 3.3.1 Bronze Colours:

Silver (1-C)	T200-4000
Gold (1-C)	T200-4001

## 4. ADDITIVES:

### 4.1 Thinner:

Prior to production, the printing ink has to be adjusted to the printing viscosity by the addition of thinner.

Addition Thinner 25-35%

Thinner, slow 600-1.800 parts/hour	100VR1453
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Thinner, standard 1.800-2.800 parts/hour	100VR1450
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Thinner, fast 2.800-5.000 parts/hour	100VR1440
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# SERIES T200

## 4.2 Screen printing process:

For screen printing we will recommend to use the thinner 100VR1453 as well as the retarder 100VR1170.

Thinner, slow	(addition 25-35%)	100VR1453
Retarder	(addition 15-25%)	100VR1170

## 4.3 Hardener:

The mixing addition is approximately 10%.  
At 21°C a pot life of minimum 48 hours can be achieved.

Hardener, standard	(addition up to 20%)	100VR1433
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Please note that the final chemical and physical resistance as well as the maximum adhesion of the ink film will only be achieved after 36 hours at 21°C.

During processing and drying of the printed ink film the temperature should not be lower than 15°C. Otherwise the chemical cross linking is stopped. Also avoid high humidity for several hours after printing as the hardener is sensitive to humidity. While using hardener please note that multicolour jobs have to be printed during 36 hours. The completely dried ink layer cannot be overprinted any-more.

## 4.4 Levelling Agent:

The levelling of the ink surface can be optimised by use of a levelling agent. It must be noted that excessive addition of levelling agent can have a negative influence on the over printability.

Levelling Agent	(max. addition 0,5- 1%)	100VR133
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## 5. PROCESSING INSTRUCTIONS:

### 5.1 Pre-treatment:

Pre-treatment of polyolefins (PE/PP) must be performed by Flame Treatment or CORONA-discharge. In case of PE, surface tension needs to be at least 42 mN/m (Dynes/cm), in case of PP at least 52 mN/m (Dynes/cm).

### 5.2 Stencil / Cliché / Pad / Printing Equipment:

The inks of T200 series can be printed with all commonly available screen printing meshes. They can be used with all screen printing machines with screen printing stencils currently used for industrial applications.  
During the pad printing application the inks can be used in open as well as closed systems.  
However, it has to be noted that type (screen) and etching depth of the cliché, shape and hardness of the pad, the adjustment of the ink (addition of thinner and/ or retarder) as well as printing speed may influence the printing result.

## 5.3 Drying Conditions:

At 21°C the inks of T200 series will be dry-to-handle within 30-35 seconds.

While adding hardener to the ink, crosslinking after application will take approximately 36 hours at 21°C. To accelerate the ink drying the use of hot air blower units or infrared lamps is recommended.

In order to avoid, that the printed parts stick together, a cooling section must be installed after heat treatment unit.

## 6. CLEANING:

Clichés/knife or screen/squeegee as well as other working materials can be cleaned with the RUCO Universal cleaner 100VR1442. For the cleaning of the pads alcohol can be used or please refer to the instructions of the pad manufacturer. If cleaning is not performed by fully automatic cleaning equipment, protective gloves must be worn.

Universal Cleaner	100VR1442
Bio degradable Cleaner	100VR1272

## 7. SHELF LIFE:

A shelf life of 12 months is guaranteed when storing the inks at 21°C in the original packing container, excluded bronze colours (9 month) and effect inks (6 month). At higher storage temperatures the shelf life will be reduced.

## 8. PRECAUTIONS:

For further information on the safety, storage and environmental aspects concerning these products please refer to the Material Safety Data Sheet (MSDS).

Additional technical information can be obtained from our Product Management Department.

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