



Description

Ready for use special ink for printing onto silicone rubber insulated electric wires.

Basis	Solvent based synthetic resin
Application method	Gravure printing, e.g. Medek & Schörner KS or RSD Technik GmbH
Form of supply	All international colour shades, e.g. RAL, IEC 304 and also metallic shades available

Technical Data*

Solid content	30 – 55 % depending on the shade ISO 3251
Density	0,8 - 1,4 g/cm ³ depending on the shade ISO 2811-1 at 23°C
Viscosity	30"/4 mm; 60"/6 mm depending on the shade EN ISO 2431 at 23°C (DIN-cup)
Flash point	+ 5°C ISO 1523

Instruction

Preparation Before using add the whole content of the bottle R911 (crosslinker) to one container with 18215. Stir well before use. Processing time after mixing ink and crosslinker R911: 8h

Dilution HERKULA Special thinner 18291 (medium drying) or 18292 (retarder) to readjust the viscosity in the machine.

Curing After printing a further thermal treatment at 150°C is advisable. Print on hot insulations approx. 100°C e.g. after extruder

Line speed Up to 300 m/min

Cleaning HERKULA Special thinner 35014

Information



Shelf life: 12 months in a well closed can



Standard packaging: 1 l can



Check Material Safety Data Sheet as well as instructions on the label



It is advisable to pre-cool the silicone rubber after extrusion by means of ambient air or water jet (residual water must be blown of). Depending upon the insulation it may be necessary to use a gas flame before and/or after print. Do not use the ink longer than 8 hours when working from an open container



No influence on the electrical characteristics, resistant to benzene directly after printing, fast to abrasion, pigments are free of lead and other heavy metal

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