

Last update :  
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TDS Reference :  
DG 334 /12500

# 12500



### Application

12500 series is a solvent-based, two-component ink designed for high-speed multi-color printing on pre-treated PE or PP containers and objects, treated by flaming or Corona (bottles, buckets, capsules, bottle cases, bottle caps), as well as thermo-setting resins such as Bakelite®.

### Advantages

The fast-curing 12500 series is characterized by its excellent adhesion, great resistance to abrasion and numerous chemical agents, detergents, cosmetics, etc. Its suitability to a wide range of substrates makes it a reliable option for container makers.

### Finish

High gloss.

### Machines

High-speed machines ; Semi-automatic or automatic machines



### Screens

The recommended mesh is 90 to 120 threads/cm (230 threads/in to 305 threads/ in).



### Cleaning

Dubuit's standard cleaning solvents are : Solvent H, ECO N Solvent and 93801 solvent.



### Squeegee

Recommended with this ink : single, double or triple durometer polyurethane blades with hardness between 85 and 75 shores.



### Thinning

Various diluents are available according the needed curing speed :

Fast curing : ECO Rapide R  
Medium curing : ECO Moyen M  
Slow curing : ECO Lent L  
Retarder : ECO Retardeur RTD



### Curing

The 12500 series has the great advantage to be mixable with two different hardeners.

**Hardener 12593** added at a 8 to 10% ratio, extends the pot life of the mix up to 6 months in a closed container. It reduces ink consumption and makes the ink easier to use on the long run.

**Hardener N°3** accelerates the curing speed without curing in the screen. The pot life once activated is only a few days. The curing process is carried out in two stages:

	Drying conditions	Drying speed using the hardener 12500 N°3
#1	Either drying at ambient temperature	1 to 3 min at ambient temperature
	Or drying at 80°C	About 30 seconds
#2	Polymerization at ambient temperature	3 to 4 min at ambient temperature
	Or Polymerization at 80°C	About 2 min

# PRODUCT SELECTION CHART

STANDARD SHADES		PRODUCT
PRIMAVERA YELLOW	300	C125300K
MID YELLOW	310	C125310K
GOLD YELLOW	320	C125320K
MANDARIN	330	C125330K
VERMILLON	340	C125340K
DARK RED	350	C125350K
PINK	360	C125360K
VIOLET	370	C125370K
PRIMARY BLUE	380	C125380K
EMERALD GREEN	390	C125390K
BLACK	11	C125011K/C
COVERING WHITE	82	C125082K/C
EXTRA COVERING WHITE	83	C125083K/C
VARNISH	090	C125090K/C

PIGMENT CONCENTRATES	12500 SERIES
PRIMAVERA YELLOW 305	C125305K
MID YELLOW 315	C125315K
MANDARINE 335	C125335K
VERMILLON 345	C125345K

## Color Matching

Dubuit offers a full in-house color matching service from 1 kg. Please provide as much information as possible regarding the type of substrate, color, mesh used...

## Surface energy

A uniform surface energy of at least 42 Dyne/cm<sup>2</sup> is required for a good adhesion. The substrate's surface should be free of graphite, silicone, dust and residues of grease or similar substances (e.g. finger prints).

## Storage

Standard shades have a guaranteed shelf life of 1 year from their date of shipment from our factory, undiluted, in the original, unopened container. The above guarantee is applicable to inks stored in a dry, dark, well-aired environment at a temperature between 15-25 °C (59-77 °F).

## SPECIAL REQUIREMENTS

Further colors are available on demand :

Rich Gold 25S  
 Pale Rich Gold 25S  
 Pale Gold 25S  
 Silver 21S  
 Fluorescent shades

It is possible to intensify our ink's colors by adding 12500 pigment concentrates. For more details on use and price please contact our technical support department.



## Standard and Legislations:

For full details about our inks' conformity with current standards, please refer to the document ECO SYSTEM LABEL by Encres Dubuit.

Material safety data sheet available at : <http://www.edubuit.com/msds/> or [export@encresdubuit.com](mailto:export@encresdubuit.com)

Dubuit guarantee the quality of our products. We cannot however guarantee the finished results because we exercise no control over an individual operating procedures. Our responsibility is limited solely to the exchange of ink or varnish. The quality of a substrate to be printed can vary, as can an ink being overprinted; therefore the above information is given in good faith based on the state of our art and prior experience. This statement also applies to our technical assistance. When using our inks and varnishes on a new substrate or when changing operating procedures, we strongly recommend testing before use in a production situation to ensure full compatibility. **Please refer to our General Conditions of Sales.**