

### 8500 SERIES



#### Application

The 8500 is a bi-component, solvent-based ink series. This multipurpose ink adheres on a large number of different substrates : glass, metal, lacquered metals, treated PE, thermosetting resins such as Bakelite...

#### Advantages

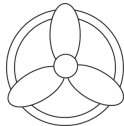
8500 inks adhere on diverse substrates. It is highly resistant to abrasion and chemicals such as detergents, solvents and alcohols when fully cured.

#### Finish

High gloss, very good opacity.

#### Machines

Semi-automatic printers.



#### Hardeners / Drying :

8500 series is bi-component and should therefore be mixed with a hardener before use. The hardener differs according to the substrate. The standard 8592 hardener can be used in most cases.

Mixing ratio for colors : 20% hardener, 80 % ink

Mixing ratio for whites : 15 to 20 % hardener, 85 to 80% ink

**Important :** When mixing hardener 8599 with 8500 inks to print on glass, beware of waiting 30 to 45 min before use of the mixture. This will help to obtain the optimal gloss and mechanical resistances. In case of adhesion problems, you may use the hardener AM9192.



#### Screens

The recommended mesh is 77 th/cm to 120 th/cm (196 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.

Please find below the selection chart for our hardeners:

Hardener	substrate	Ratio	Pot life	Drying speed	Curing speed
8592	Treated PP and PE, glass, metals, lacquered metals	80% ink 20% hardener	5 to 6 hours	Ambient temperature : 15 to 20 min 50/55°C : 8 to 10 min	Ambient temperature : 5 to 6 days 50/55°C : 15 to 20 min
8597	Treated PP sheets (Priplak) , thermosetting resins ("Bakelite)	90% ink 10 % hardener	8 to 10 hours	Ambient temperature : 20 to 30 min 50/55°C : 15 to 20 min	Ambient temperature : 8days 50/55°C : 20 to 25 min
8599	Glass and silver substrates	90% ink 10% hardener	8 to hours	Ambient temperature : 15 to 20 min 50/55°C : 8 to 10 min	Ambient temperature : 5 to 6 days 50/55°C : 15 to 20 min

STANDARD SHADES		PRODUCT
PRIMAVERA YELLOW	300	C085300K
MID YELLOW	310	C085310K
GOLD YELLOW	320	C085320K
MANDARIN	330	C085330K
VERMILLON	340	C085340K
DARK RED	350	C085350K
PINK	360	C085360K
VIOLET	370	C085370K
PRIMARY BLUE	380	C085380K
EMERALD GREEN	390	C085390K
BLACK	11	C085011K/C
COVERING WHITE	82	C085082K/C
EXTRA COVERING WHITE	83	C085083K/C
THIXO BASE	098	C085098K/C
VARNISH	090	C085090K/C

PROCESS COLORS		PRODUCT
MAGENTA 8520		C085420K
YELLOW 8530		C085430K
CYAN 8550		C085450K
BLACK 8515		C085415K

### **SPECIAL REQUIREMENTS**

Available <u>on demand only</u> :	Available <u>on demand only</u> :
Rich Gold 25S	Fluorescent shades
Pale Rich Gold 25S	Transparent shades
Pale Gold 25S	Pigment concentrates
Silver 21S	Process colors

**Because of the large diversity of substrates, we recommend to carry out pre-production trials.**



### **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.**

OPAQUE SHADES		PRODUCT
PRIMAVERA YELLOW H0861		C085H0861K
LEMON YELLOW H0881		C085H0881K
LIGHT YELLOW H0860		C085H0860K
GOLDEN YELLOW H0958		C085H0958K
ORANGE H0957		C085H0957K
INTENSE RED H0858		C085H0858K
LIGHT RED H0978		C085H0978K
CARMIN H0973		C085H0973K
CYCLAMEN H0882		C085H0882K
PALE GREEN H0989		C085H0989K
EMERALD GREEN H0870		C085H0870K
MID GREEN H0870		C085H0988K
LIGHT BLUE H0868		C085H0868K
KING BLUE H0994		C085H0994K
BROWN RED H0993		C085H0993K
BROWN H0990		C085H0990K



### **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

### **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).