

Application

D-PAD is a satin/gloss 1-or-2 component pad-printing ink designed for industrial and graphic applications. It adheres on a variety of plastics such as hard and soft PVC, Polystyrenes, ABS, SAN, Polycarbonates, PMMA, as well as on wood, paper, cardboard and metallic substrates.

Cliché & Pad-printing Machines

- D-Pad is compatible with all existing open or closed pad printing system. The ink contains no ferromagnetic component, in order to avoid any risk of magnetization in closed machine system.
- The curing system of D-Pad ink ensures a user-friendly application in open and closed machines, on condition that the ink's viscosity has been adjusted with the appropriate diluent.
- Standard steel or photopolymer clichés are suitable. A etching depth of 20 to 25 µm is recommended for optimum layer thickness. The absence of corrosive components in the ink ensures a smooth use with steel clichés.
- Best printing results will be achieved with a pad re-activated by cleaning with alcohol like solvent so as to delete residual silicone at the pad's surface. Too old pads with rough surface should be avoided.
- Apart from rotary machine, this ink is applicable for all existing machines of the industry at high speed production.

Physical properties

This pad printing ink exhibits excellent flexibility, mechanical and chemical resistance, especially when mixed with the appropriate hardener. Thanks to the high-covering pigments of D-Pad, less ink is needed to achieve outstanding printing results. D-Pad's pigments aren't suitable for out-door exposure, but a light fast version could be manufactured on request.

Finish

Satin/gloss finish

Additives



Thinning & Drying:

The Pad Printing ink should be adjusted before use to the required viscosity by adding one of the following thinners :

Fast Thinner :	H4144
Medium Thinner :	H4281
Slow Thinner :	H4282



Mixed with fast and medium thinner, the ink has a very fast physical drying between 30 and 60 seconds at 20°C ambient temperature, which enables to handle the printed substrate shortly after printing. The touch dry time depends on printing parameters such as cliché depth, room temperature and additives used.

A complete drying time of at least 24h is needed to reach all final mechanical and chemical properties.

Starting quantity of thinner : 15%.

Hardener & Pot Life :

When mixing with hardener H4283, the pot life reached at an ambient temperature of 20°C will be about 8 hours.

The use of hardener will slightly extend the duration of ink's curing. Furthermore, the inks will need at least 3 days drying at ambient temperature in order to achieve its complete adherence and physical properties.

You may add 10% hardener.

D-PAD

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Leveling agent

The additive ST 155 will eliminate surface defaults such as bubbles, pinholes, and will help reaching a smooth surface aspect.

Because of the large diversity of plastics, recycling materials and copolymers, we strongly recommend that you carry out pre-production trials to assess suitability of D-Pad to the substrate.



Cleaning

The pad-printing inks D-Pad can be removed from printing blocks and working materials without any problem, using Dubuit's standard cleaning solvents Solvent G and 93801



STANDARD SHADES

MID YELLOW	710
GOLD YELLOW	720
MANDARIN	730
VERMILLON	740
DARK RED	750
PINK	760
VIOLET	770
PRIMARY BLUE	780
EMERALD GREEN	790
BLACK	701
WHITE	702

Surface energy

A uniform surface energy of at least 38 Dyne/cm² 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).

Pantone colors

Mixing formulations exist to match colors of the Pantone color guide. Please contact us to get the formula.

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 guaranty is applicable to inks stored in a dry, dark, well-aired environment at a temperature between 15-25 °C (59-77 °F).



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

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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.**