

ALLEN AVIONICS, INC.

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TECHNICAL DATA SHEET January 1, 2010

PART NUMBER: MT260 EPOXY INK

This information is believed to be reliable, but the suitability of the products must be judged by the individual user. They are subject to change without notification or obligation. No warranty or liability by ALLEN AVIONICS, INC. or results is expressed or implied.

The MT260 ink series is a two-part, epoxy paste ink for use on direct or offset printers. White or black ink is available in 12-ounce kits. Each kit consists of 8-ounces of Part "A" and 4-ounces of Part "B". The MT260 ink can be used on all non-porous surfaces such as glass and most plastics (epoxy, nylon, bakelite, phenolic, durez, melamine, etc.)

DRYING/CURING

This series is a two-part paste ink. When Part "A" is combined with Part "B", this ink will fully cure at room temperature in 3 days. For applications where resistance to solvents and abrasion are most important, one of the following elevated temperature cure schedules should be used: 21 degrees Celsius for 24 hours, 82 degrees Celsius for 4 hours, 149 degrees Celsius for 1 hour, or 177 degrees Celsius for 20 minutes.

The curing time begins once the substrate has reached the curing temperature. Substrate material, ink thickness, and oven temperature will affect the curing time. An industrial oven with forced vented air is recommended.

ACCESSORY CHEMICALS

Use only Allen Avionics CL120 cleaner to remove ink from machine and all other parts that come in contact with ink. Other solvents may cause damage to rollers and pads.

SHELF LIFE: 12 Months

The shelf life begins on the month following the ship date. Optimum storage temperature is between 5 and 10 degrees Celsius in the original unopened container. Allow ink to warm gradually to room temperature before use.

OTHER TECHNICAL DATA

- Use only Allen Avionics rollers. Other rollers may shorten life of ink machine.
- Prints baked at 121 degrees Celsius for 1 hour have withstood autoclaving for 15 minutes at 121 degrees Celsius.
- When MT260 is heat cured, it will exhibit superior adhesion and excellent resistance to solvents such as acetone, alcohol, ether, freon and other flux removing solvents.

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- For correct mixing, use 2 parts "A" to 1 part "B" by weight or volume. AFTER MIXING, A 20-MINUTE "WAIT PERIOD" IS REQUIRED BEFORE USE. The MT260 ink has a six hour pot life. Workable life on ink plate can be up to 3 hours depending on color, volume and room environments. Store in a cool place and use within 12 months.
- Colors other than black and white may be ordered on a special order basis.

IMPORTANT NOTES

The materials used in formulating this product may present health or safety hazards as defined by the OSHA Hazard Communications Standard. Always consult the Material Safety Data Sheet for specific hazard information before using this product.

The performance (transfer, adhesion, and permanence) of any ink is directly related to the cleanliness of the surface being printed. The surface must be free of all matter or contamination.

Please contact ALLEN AVIONICS, INC., directly, for assistance with custom colors, application questions, related inks for other application methods, or any other application questions.

November 29, 1993