

## MIX-HF Ink series

### (2 pack type, high transparent ink)

MIX-HF ink is a highly transparent 2 pack type ink that also can be used for back print for TOC-HF and MIR mirror ink. Normally, Mirror ink is printed on polycarbonate substrate and mirror surface becomes cloudy when it is back-printed by ordinary screen ink. By back-printed with MIX-HF ink, the mirror surface does not become cloudy.

<b>Applications</b>	Display, Home appliance nameplate		
<b>Special Features</b>	<ul style="list-style-type: none"> <li>• Forms a highly transparent printed ink layer.</li> <li>• Back printing on MIR Mirror ink improves scratch resistance and ink layer resistance.</li> <li>• No intentional use of Halogen (Chlorine Cl, Bromine Br) compounds in raw materials.</li> </ul>		
<b>Substrate</b>	PC sheet		
<b>Dilution</b>	C-002 SOLVENT (standard) Dilution:15%		
<b>Catalyst/Promoter mixing</b>	210 CATALYST 3%	200 CATALYST 9% (For use in Film insert molding)	Pot life: 5 to 8 hrs.
	*The ink will turn to gel after the pot life has expired. Be sure to mix only enough to use		
<b>Additives</b>	Not required		
<b>Recommended Cleaner</b>	Screen Cleaner L2		
<b>Mesh</b>	T 300 mesh (Coverage is about 35~45m <sup>2</sup> /kg at 300 mesh)		
<b>Drying</b>	80°C 30 min	<u>Over print</u> Each layer 80°C 10 min (tack-free) Final layer 80°C 30 min	
	*For film insert molding applications, drying at 80°C for 60 min after binder printing is recommended.		
<b>Standard Colors</b>	HF000 MEDIUM HF001 VICTORIA HF169 SCARLET	HF179 RED HF239 LIGHT YELLOW HF399 BLUE	HF589 MAGENTA HF619 WHITE HF919 BLACK HF939 NC BLACK

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**Caution**

- Due to the possibilities of contamination with halogen compounds, only designated solvents and catalysts can be used.
  - Please check the squeegee rubber, emulsion, materials and substrates before use, as they may contain halogen compounds.
  - In the forming process such as vacuum forming, pressure air forming, and mold forming, as well as in insert molding processes that integrate injection molded resin, a complex set of factors affect the performance of the final product, including the selection of printing materials and inks for design printing, printing conditions, printing sequence, drying method and conditions, selection of molding resin, mold design (gate shape, type and position, number of gates), and conditions set during injection molding.
  - Preliminary testing under actual conditions is strongly recommended before a commercial run.
  - When using Binder, the halogen free “IMB-HF006 Binder” (for various type of substrate) or “IMB-HF009 Binder” (for PC substrate) is recommended. Separate instruction manual is available.
  - Ink shelf life: 24 months from production date, unopened.
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**Safety**

UN No.: Not classified in the definition  
UN Classification: Not classified in the definition

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**Handling**

- Use safety gloves and eyeglasses to protect skin and eyes. If the ink comes in contact with skin, wash with soap and plenty of water (or lukewarm water) and consult with a doctor.
  - Containers should be closed tightly after use and stored in a cool and dark place.
  - SDS is available upon request. Please request a copy and read it carefully before handling the products.
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**Resistance**

Test item	Test Conditions	Test results
Adhesion	JIS K 5600-5-6:ISO2409 (Cross-cut), 1mm interval 6×6, cellophane tape and peel	0(no peel)
Cold	-40°C、240 hrs., check appearance and peel off from the substrate	No defect
Heat	90°C、240 hrs., check appearance and peel off from the substrate	No defect
Humidity	65°C、95%RH 250 hrs., check appearance and peel off from the substrate	No defect
Accelerated Weathering	(Xenon lamp) Weather-meter, 200 hrs., BP Temp.63+/-3°C, Raining rate 18 min/120 min, check color fade and peel off	No defect
Light Fastness	Fade meter 600 hrs., check color fade and peel off	No defect

\*Test conditions 【MIX-HF 919 BLACK】 【C-002 SOLVENT 15%】 【210 CATALYST 3%】  
【80°C 30 min】 【T 300】 【Substrate: Polycarbonate】

\*Above resistance test results are measured results in our laboratory and they are not guaranteed values.

\*Information contained in this catalog may change without prior notice.

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