

# 8500

Excellent adhesion on diverse substrates such as glass, metal, lacquered metal...  
High resistance to abrasion and chemicals.

## APPLICATIONS

The epoxy ink series 8500 has an excellent adhesion to many plastics and metal substrates (glass, metal, lacquered metal, treated polyethylene and polypropylene), a very high surface hardness, excellent gloss and very good resistance to abrasion, chemicals, solvents and alcohol.

When fully cured, 8500 ink is resistant to most household and cosmetic products, detergents, and common solvents.

H5215 hardener is suitable in most cases. 15% can be added in whites and colours. On some substrates, such as glass, adhesion is sometimes very difficult. Use of AM9192 hardener allows improving the ink adhesion on difficult substrates.

However, for particular applications, depending on the substrate type to print and the type of decoration (solid Colour or fine details), it is necessary to use a specific hardener. Refer to our selection chart hereunder.

## NOTE:

The use of AM9192 hardener needs to follow the instructions below:

1. Add 10% by weight and mix well.
2. Wait 30-45 minutes before use, this time is imperative to obtain the optimum glossiness and surface resistance (shorter time will considerably affect the appearance and especially the resistance. On thermosetting resin such as Bakelite use the 8597 hardener in an amount of 10 to 15%.
3. When printing in multi-colours with colors superposition, there is a risk of inter-layer incompatibility if the intermediate drying is too high. Depending on the hardener chosen, it is imperative to carry out a test before running a production. The adhesion control must be done 48 hours after leaving the oven. Indeed, at the exit of the oven the ink can still be a little fragile on the surface. The H5215 hardener presents the least risk in color superposition but does not offer the same resistance as the AM9192 and 8534 hardeners. The hardener 8534 presents the most risks at high temperatures; once the intermediate drying has been set, it is essential to perform a final curing at 150 °C for 30 minutes.

## Special case:

Polypropylene sheets: this type of substrate is corona treated during its production but the duration of this treatment is limited in time. Therefore, we recommend checking the surface tension before printing in measuring the surface energy of the substrate to be printed.

## Caution:

Primrose yellow 300 and medium yellow 310 shades as well as their concentrates degrade at temperatures above 120 °C.

## SUBSTRATES

- Plastics
- Glass
- Metal
- Lacquered metal
- Treated Polyethylene and Polypropylene

## ASPECT

High gloss

## THINNING

Various diluents are available according to the needed curing speed (5-20%):

- Fast curing: ECO Rapid
- Medium curing: ECO Moyen
- Slow curing: ECO Lent
- Retarder: ECO Retardeur

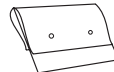
## PRINTING EQUIPMENT

Semi-automatic printers



## SCREEN MESH

Mesh 77 to 120 thread/cm



## SQUEEGEES

SR1 or HR1 type (one layer), 85 or 75 shore



## DRYING/CURING

Hardener	Substrates	Ratio	Pot Life	Drying speed
<b>H5215</b>	Treated PE and PP, glass, metal, lacquered	85% ink 15% hardener	8 hours	<b>80 °C for plastics</b> 30 to 45 minutes <b>80 à 120 °C</b> <b>for glass &amp; metal</b> 30 to 45 minutes
<b>8597</b> Flexible hardener for powder mixing	Treated PE and PP, glass, metal, lacquered	90% ink 10% hardener	8 to 10 hours	<b>80 °C for plastics</b> 30 to 45 minutes <b>80 à 120 °C</b> <b>for glass &amp; metal</b> 30 to 45 minutes
<b>AM9192</b>	Glass and metal substrates if adhesion with the H5215 insufficient	90% ink 10% hardener	4 hours	<b>80 à 120 °C</b> <b>for glass &amp; metal</b> 30 to 45 minutes
<b>8534</b>	Glass	90% ink 10% hardener	6 to 8 hours	<b>150 °C</b> 30 minutes



## CLEANING

Solvents G, 93801

## PACKING

1 kg & 5 kg



## STORAGE

The guaranteed shelf life of our inks, undiluted, in the original, unopened container is applicable to inks stored in a dry, well-aired environment at a temperature between 15 to 25 °C (59-77 °F).

- Gamme 8500 standard range + whites, blacks and bases: 36 months
- Varnish 8500 090: 18 months
- Special products, hardeners: 1 year

## COLOUR MATCHING

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

Available on request only:

- Rich Gold 25S
- Pale Rich Gold 25S
- Pale Gold 25S
- Silver 21S
- Fluorescent shades
- Transparent shades
- Process colour

## FLUORESCENT SHADES

They have to be used on white background. The pot life of these inks is about three months from the date shown on the packaging. The light resistance is limited in time, especially in outdoor exposure.

## ADDITIVES AND SPECIAL PRODUCTS

Do not forget that additives must not be incorporated systematically into the inks, but must be used with caution as their dosage and their field of use can often present risks. The special products we deliver are of consistent quality. Encres DUBUIT cannot guarantee the work using these products. Indeed, they cannot influence neither the working methods nor the operating parameters.

## HEALTH AND SAFETY

The vast majority of printing inks and related products formulated by Encres DUBUIT contain no substances of very high concern (SVHC) candidates for authorization (as of June 25, 2020) in concentrations greater than 0.1% by mass. Our products comply with the requirements of Directives 2011/65 / EU (RoHS 2), 2015/863 / EU (RoHS 3) and 94/62 / EC (heavy metal concentration levels present in packaging). For more information about our regulatory compliance, please consult our Eco System document, available on request.

The 8500 Series should not be used for printing food packaging material that is not recognized as an appropriate barrier (plastic, cardboard, paper and labels affixed to these media).



<b>8500 INK RANGE SOLID COLOURS - 300 RANGE</b>	
<b>PRODUCT DESCRIPTION</b>	
	REF
Primary Yellow	300
Mid Yellow	310
Gold Yellow	320
Mandarin	330
Vermillion	340
Dark Red	350
Pink	360
Violet	370
Primary Blue	380
Emerald Green	390
<b>BLACK, WHITE, BASE &amp; VARNISH</b>	
	REF
Black	11
Covering White	82
Extra Covering White	83
Thixo Base	098
Varnish	090
<b>OPAQUE SHADES</b>	
Pale Yellow	H0860
Primary Yellow	H0861
Lemon Yellow	H0881
Gold Yellow Gold	H0958
Orange	H0957
Light Red	H0978
Bright Red	H0858
Carmine	58682
Cyclamen	H0882
Pale Green	H0989
Emerald Green	H0870
Mid Green	H0988
Light Blue	H0868
King Blue	H0994
Brown Red	H0993
Brown	H0990
<b>METALLIC SHADES (ON REQUEST)</b>	
Rich Gold	
Pale Rich Gold	
Pale Gold	
Silver	25S
<b>PROCESS COLOURS</b>	
Magenta	8520
Yellow	8530
Cyan	8550
Black	8515
<b>ADDITIVES</b>	
Standard Hardener	H5215
Flexible Hardener	8597
Hardener	AM9192
Hardener	8534

Encres DUBUIT guarantees the quality of our products. However, we cannot guarantee the final result, because we exercise no control over 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 well as an overprinted ink; 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 first a full-scale production to ensure compatibility. Please refer to our General Conditions of Sales.

