



## OFFSET MARKER INK SPECIFICATIONS

### RT012 INK (RoHS Compliant)

Allen Avionics RT012 Ink is a one part, air-drying, semi-paste ink for use on all open ink plate marking machines for direct or offset printing. White or Black color inks are available in 4 ounce tubes. Colors can be supplied on special order. Call factory for availability. Available colors are blue, brown, gray, brilliant green, orange, red, tan, lavender and yellow. RT012 Ink can be used on almost any surface, porous or non-porous, such as plastics (polyethylene, epoxy, nylon, bakelite, phenolic, G10, polyester, melamine), metal, glass, wood, fiberglass, ceramics, paper, rubber and painted surfaces.

RT012 Ink can be used where very good abrasion resistance is required and where reduced solvent resistance is acceptable. Drying time depends on the surface porosity, ink thickness and room environments. Marked surfaces will develop good handling strength in approximately 12 hours. Best adhesion is gained in 72 hours. To accelerate drying time, RT012 may be temperature cured at the following schedules:

- 15 hrs. @ 150°F (66°C)
- 4 hrs. @ 200°F (93°C)
- 1 hr. @ 250°F (121°C)

This ink is ready to use right from the tube. No "setting time". **Mixing may be required after storage.** Using thinners is not recommended. Thinning will adversely affect this ink. Store in a cool place and use within six months. Only the purchaser can determine the suitability of this ink for any application.

---

### MT260 INK (RoHS Compliant)

Allen Avionics MT260 Ink is a two-part epoxy ink for use on all open ink plate machines for direct or offset printing. White or Black color inks are available in 8 fluid ounce kits. Each kit consists of two components: Part "A" and Part "B" totaling 8 fluid ounces. Inks are packaged in plastic containers. Colors are available on special order and are supplied in the same 8 fluid ounce kits. Standard EAI colors are available: red, orange, brown, yellow, green, blue, violet, gray and silver.

MT260 Ink can be used on all non-porous surfaces such as plastics (epoxy, nylon, bakelite, phenolic, durez, melamine), metals and glass. MT260 Ink will air dry to a tough, scratch-resistant film in 24 hours at room temperature. For applications where resistance to solvents and abrasion is most important, one of the following elevated temperature cure schedules should be used:

- 24 hrs. @ 70°F (21°C)
- 4 hrs. @ 180°F (82°C)
- 1 hr. @ 300°F (149°C)
- 0 min. @ 350°F (177°C)

When MT260 is heat cured, it will exhibit superior adhesion, excellent resistance to abrasion and solvents such as acetone, alcohol, ether, freon and most other flux-removing solvents. Meets: CID A-A56032A Type I and II. Formerly: MIL-I-43553b

**MT260 Mixing instructions:** For all colors except silver, use 1 part "A" to 1 part "B" by weight. For silver, see mixing instructions enclosed with ink. **After mixing, a 30 minute "WAIT PERIOD" is required before use** to achieve the best results. Under normal conditions the MT260 Ink has a 4 to 5 hour pot life. Workable life on ink plate can be up to 3 hours depending on color, volume and room environments. Higher than normal room temperatures will shorten pot life. Using thinners is not recommended. Thinning will adversely affect this ink. Store in a cool place and use within six months.

## ***Offset Marking Ink Specs (continued)***

Only the purchaser can determine the suitability of this ink for any application. **Mixing may be required after storage.**

---

### **HT175 INK** (RoHS Compliant)

Allen Avionics HT175 Ink is a very slow-drying, heat-curing, semi-paste ink for use on all open ink plate marking machines for direct or offset printing. White or Black color inks are available in 4 fluid ounce tubes. Other colors are available on special order and are also packaged in 4 ounce tubes. Standard colors are available: red, blue, green, orange, brown, gray, yellow, violet, and silver.

HT175 Ink can be used for marking materials that can tolerate an elevated temperature cure schedule. Recommended materials include thermal-setting epoxies, metals, glass, neoprene, phenolic, polyester and other non-porous surfaces. After proper curing, HT175 will exhibit superior adhesion, excellent resistance to abrasion and to solvents such as acetone, alcohol, freon and all other flux- removing solvents.

HT175 Ink must be heat cured at a minimum temperature of 175°F (80°C) for 4 hours. Lower temperatures will not effect a complete cure. The optimum temperature for best resistance to abrasion and solvents is 350°F (176°C). A curing time of 5 minutes or more is required. Good results will be achieved when the following cure schedules are used:

5 min. @ 350°F (177°C)  
15 min. @ 300°F (149°C)  
2 hrs. @ 250°F (121°C)

This ink is ready to use right from the tube. "No setting time". **Mixing may be required after storage.** Store in a cool place and use within six months. Only the purchaser can determine the suitability of this ink for any application. Meets: CID A-A56032A Type I and II. Formerly: MIL-I-43553b

---

### **APPLIES TO ALL OF THE ABOVE INKS:**

- Use only a BIODEGRADABLE Cleaner to remove ink from machine. Other solvents may cause damage to rollers and pad.
- Using thinners is not recommended. Thinning will adversely effect ink.
- Use only Allen Avionics rollers and pads. Other rollers may shorten life of ink on machine.
- Keep pads stored below 60C and for no more than 1 year as this material used to make the pads can degrade with high temperature and time.
- All inks should be stored in a cool place. Refrigeration should be used for any extended storage. Shelf life for properly stored inks will be a minimum of six (6) months.
- For up-to-date Material Safety Data Sheets (MSDS) for all of the above inks and cleaner check our Web-Site ([www.allenavionics.com](http://www.allenavionics.com)).

### **STATEMENT OF LIABILITY**

Neither the manufacturer nor the seller shall be liable for any injury, loss or damage arising from the use of these products. The only obligations of the manufacturer or the seller shall be to replace the product found to be defective. The purchaser or user of these products should before, use of the product, determine whether it is suitable for that use. The user assumes all risk and liability in connection with that use. Only the purchaser can determine the suitability of this ink for any application.