

# Water Based Screen Ink for Tempered Glass 3112WB Two-pack Screen Ink

## Technical Data Sheet

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**Smiley 3112WB** is a two-pack screen ink combining outstanding resistance to many chemicals and solvents with excellent adhesion to an extensive range of 'difficult' surfaces.

- High Opacity / Available in Gloss and Matt
- Excellent Adhesion to a wide range of substrates
- Excellent Water and Heat resistance
- Outstanding Resistance to many Chemicals and Solvents
- Good Surface Electrical Resistance
- Low Surface Tension
- Designed for Single Layer and Multilayer Printing
- Halogen Free and RoHS Compliant

### Substrates:

Tempered Glass, vitreous and stoved enamel surfaces, Aluminium, Brass and other metals, pre-treated polyethylene and polypropylene

## USER INFORMATION

### Mesh:

77-140 Mesh/cm monofilament polyester is recommended for most applications.

### Stencil:

Water Based Emulsions  
Recommended:  
6061-015 Diazo Textile Emulsion

### Squeegee

70-85 Durometer hardness Polyurethane squeegees

### coverage

70-80 M<sup>2</sup>/Kilo (140 Mesh/cm) depending upon ink deposit.

### Pre-Production Test:

Always pretest adhesion and application before each production run, as there can often be significant differences between substrates from different manufacturers and even between different batches of substrates. Pretest to determine optimum printing performance for a particular set of ink, substrate, screen, press, and drying variables/conditions.

### Printing:

Maintain ink temperature at 65°-90°F (18°-32°C) for optimum print drying performance. Lower temperatures increase the ink viscosity, impairing both flow and drying. Elevated temperatures lower the ink viscosity, reducing print definition and film thickness.

### Catalyst / Hardener Mixing

Preparation: Combine Parts A and B as described below. Proportions are important, as they will affect the performance of the cured Clear. To ensure uniformity, blend ingredients with a mechanical mixer.

#### By Weight by Volume

Part A	3112WB Inks or Varnish	100 Grams
Part B	3112-386 Hardener / Catalyst	4 Grams

After combining parts A and B, the approximate pot life of the ink will be 5 to 7 hours. Add only enough ink to the screen to be able to print for 5-10 minutes. Add additional ink in small increments throughout the print run to maintain screen stability. Maintain ink temperature at 65°-90°F (18°-32°C) for optimum print drying performance.

- Stir well before use.
- Gelatinization may occur when pot-life expires, please prepare required quantity only.
- Make sure to always use the correct Hardener / Catalyst and Reducer.

NOTE: - Failure to wash catalyzed ink from screens immediately after use will result in the irrecoverable drying of remaining ink, into the screen.

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### Drying/Curing:

- **Smiley 3112WB** dries by a combination of water evaporation and a chemical reaction between the base and the hardener  
Convection Oven stoving at :-
  - 150°C for 5-10 minutes for 1<sup>st</sup> Layer -3<sup>rd</sup> Layer printing on Tempered Glass
  - 150°C for 30-40 minutes for final Layer printing on Tempered Glass
 Drying and adhesion of ink is affected by:-
  - Drying temperature
  - Drying time
  - Grade and type of the substrate
  - Treatment degree of substrate
 For satisfactory product resistance to develop, prints should be allowed to age for 4 days after printing at room temperature.

### Thinning and Wash-up:

- Retarder: Use 3112-800 Retarder to slow down the drying time. Add up to 10%-15% by weight.
- Wash-up: Use water

## GENERAL INFORMATION

### Handling & Storage:

- **3112WB** is formulated free of lead and other heavy metals.
- It is recommended to wear suitable protective gear such as glasses and gloves. Take particular care to avoid splashes into the eyes and skin contact. If the ink comes in contact with skin, wash with soap and plenty of water. If varnish comes in contact with eyes, wash with plenty of water and consult with a doctor.
- Comprehensive information on the safety and handling of 3112WB is given in the appropriate Smiley Material Safety Data Sheet (MSDS), which are available upon request.
- Store tightly covered at temperatures between (18°-25°C).
- Tins should be kept tightly closed when not in use.

### Environmental Information:

- Do not contain ozone depleting chemicals.
- **3112WB** should be disposed properly (see MSDS) and in accordance to local regulations to avoid contamination.

### Recommended Stencil Making Products:

- Screen Preparation
  - Mesh Preparation 6050-300 – for abrasion
  - Mesh Degreaser 6050-200 – for degreasing
- Screen Emulsion
  - Diazo Textile Emulsion 6061-015
  - Screen Hardener 6050-101
- Screen Cleaning
  - Ghost Remover 6070-100
  - Stain Remover 6070-001
- Screen Reclaiming
  - Stripping Powder 6070-200

### Additional Information

For additional product information, please visit our website at <http://www.smiley.co.th>. For further information, please contact SPS personnel at [medhi@smiley.co.th](mailto:medhi@smiley.co.th).

Thank you for choosing **SMILEY**.

## PRODUCT OFFERING:

### Packaging:

**3112WB is available in 1 Kilo, 5 Kilos and 20 Kilos containers.**

Smiley Printing Solution Co., Ltd. (SPS), abides by the quality of this product. The information and recommendations that embody this Technical Data Sheet along with the technical advice are based solely on our knowledge and therefore confident to be precise. This product has been specifically formulated for screen printing. SPS cannot guarantee the precision for other possible application for the reason that manufacturing methods and other materials vary. Any liability amalgamated with the use and application of these products, users are the sole bearer of responsibility for choosing appropriate product for end-users' requirement. This Technical Data Sheet is provided for the technical purpose in the usage of this product and users are expected to follow current recommendation.

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