



# *Teca-Print Corp.*

*Swiss Pad Printing Technology, America Standards*



## **UV PAD PRINTING INK CATALOG**

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06.09.2004/Lgg  
TPC860\_en1.doc

# Technical Data Sheet TPC 860, UV - Curing Pad Printing Ink

## UV - Curing Pad Printing Ink TPC 860

### Application

UV-curing pad printing ink range TPC 860 is a new system for universal applications. Due to the high quality UV-curing Epoxy-resins contained it meets highest demands.

A variety of substrates can be printed with these pad printing inks. In addition to rigid and plasticised PVC, pre-treated polyolefines, polycarbonate and various polystyrene modifications TPC 860 inks are also suitable for glass, paper, duroplastics and metal surfaces.

Due to the different properties of printing materials, even within the same material range, printing tests are absolutely necessary.

### Properties

UV- curing pad printing inks TPC 860 show the following properties:

- good opacity
- low tendency to yellowing
- good adhesion on different substrates
- high gloss
- adjustable flexibility
- very good transfer properties from pad to substrate
- additional post-curing by heat application is possible after UV-curing
- shadow free print with good contour sharpness

### Colour Shades

The colour shades of the TPC 860-NT range show heavy metal free pigmentation and correspond to EN 71, part 3, safety of toys, migration of certain elements.

### Ink Colour Programme

### Standard Shades

TPC 860/60-HD-NT white, highly opaque  
TPC 860/65-NT black  
Other shades can be manufactured subject to our special ink shade regulation.

### Process Colour according to European Scale

TPC 860/180-NT yellow  
TPC 860/181-NT magenta  
TPC 860/182-NT cyan

### Mixing System Base Colours

TPC 860/GF-01-NT primrose  
TPC 860/GF-02-NT golden yellow  
TPC 860/GF-03-NT orange  
TPC 860/GF-04-NT scarlet  
TPC 860/GF-05-NT magenta  
TPC 860/GF-06-NT red  
TPC 860/GF-07-NT violet  
TPC 860/GF-08-NT blue  
TPC 860/GF-09-NT green  
TPC 860/GF-11-NT white  
TPC 860/GF-12-NT black  
TPC 860/GF-13 varnish

### Adjustment for Pad Printing

Prior to processing pad printing inks TPC 860-NT are adjusted with thinner VD. Viscospatula time = 6 ...10 sec.

In the event of static discharge on the printing surface, our Antistatic Paste AP brings a splash-free printing quality.

Recommended range = 3 ... 5 %. More than 5 % results in less opacity.

Liquid anti-static products produce fewer positive effects.

### Processing

The following processing parameter have to be followed:

*Plate:*



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All kinds of clichés can be used, however due to their better resistance steel plates are preferred. Criteria for choice of plates are comparable to those of conventionally drying pad printing inks.

#### *Plate depths:*

Plate with an etching depth of 16...24 µm.

#### *Type and quality of pad:*

Processing of TPC 860-NT should be carried out with Long-Life-Pads with an unworn surface (hardness 54 Shore-00).

#### *UV-curing*

Pad printing inks TPC 860 only cure under UV-radiation (approx. 2000mJ/cm<sup>2</sup>) within a wavelength of 250- 410 nm.

Then curing can be accelerated by heat application. The chain-polymerisation caused by the UV-light will continue at room temperature.

For difficult substrates we recommend to dry at 100°C for a period of 10 minutes.

### **Cleaning**

For cleaning of stencils and tools our universal cleaning agent RE can be used.

### **Packing**

TPC 860-NT inks are available in 1 liter cans (approx. 1.06 qt.).

### **Shelf Life**

For information regarding shelf life please see tin label.

### **Marking**

Read material safety data sheets prior to processing.

The material safety data sheets according to 91/155/EWG contain marking in compliance with the regulation on dangerous working materials as well as instructions for precautions when processing, handling and storing as well as first aid.

The information given in the material safety data sheet refers to processing as described in this technical leaflet.

**The statements in our leaflets and safety data sheets are based on our present experiences, however they are no assurance of product properties and do not justify a contractual legal relationship. They serve to advise our business associates, but it is absolutely necessary to make your own printing tests under local conditions, with regard to the intended purpose prior to starting the job. - All former leaflets are no longer valid. August 2002.**



11.11.2004/Lgg  
TPC790\_en1.doc

# Technical Data Sheet

## TPC 790, UV - Curing Pad Printing Ink

### UV - Curing Pad Printing Ink TPC 790

#### Application

TPC 790 is a UV-curing pad printing ink which was especially developed for ABS material. However, also SAN, polystyrene, PVC and other substrates can be printed.

The modified TPC 790 is suitable for polyamide, also glass-fibre reinforced. This adjustment will also show adhesion on various metals. TPC 790 shows a lower degree of gloss than TPC 780.

Pretests are absolutely necessary!

#### Colour Shades

The colour shades of the TPC 790-NT range show heavy metal free pigmentation and correspond to EN 71, part 3, safety of toys, migration of certain elements.

#### Ink Colour Programme

*Process Colour according to European Scale*

TPC 790/180-NT yellow  
TPC 790/181-NT magenta  
TPC 790/182-NT cyan

#### Mixing System Base Colours

TPC 790/GF-01-NT primrose  
TPC 790/GF-02-NT golden yellow  
TPC 790/GF-03-NT orange  
TPC 790/GF-04-NT scarlet  
TPC 790/GF-05-NT magenta  
TPC 790/GF-06-NT red  
TPC 790/GF-07-NT violet  
TPC 790/GF-08-NT blue  
TPC 790/GF-09-NT green  
TPC 790/GF-11-NT white  
TPC 790/GF-12-NT black  
TPC 790/GF-13 varnish

#### Adjustment for Pad Printing

Prior to processing pad printing inks TPC 790-NT are adjusted with 10 ... 20 % thinner VD or VS (quicker). Retarder = VG.

Viscospatula time = 6 ... 10 sec.

In the event of static discharge on the printing surface, our Antistatic Paste AP brings a splash-free printing quality.

Recommended range = 3 ... 5 %. More than 5 % results in less opacity.

Liquid anti-static products produce fewer positive effects.

#### Processing

The following processing parameter have to be followed:

##### *Plate:*

All kinds of clichés can be used, however due to their better resistance steel plates are preferred. Criteria for choice of plates are comparable to those of conventionally drying pad printing inks.

##### *Plate depths:*

Plate with an etching depth of 16...24 µm.

##### *Type and quality of pad:*

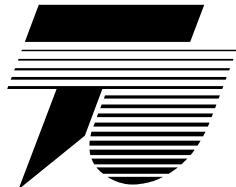
Processing of TPC 790-NT should be carried out with AntiStatic-LongLife-Pads with an unworn surface (hardness 54 Shore-00).

##### *UV-curing*

Pad printing inks TPC 790 only cure under UV-radiation of suitable wavelength and intensity. Drying parameter depend on layer thickness, colour and substrate.

Curing energy should be between 500 and 1000 mJ/cm<sup>2</sup>. Maximum chemical and abrasion resistance will be achieved after a period of 24 hours.

NOTE: Cured prints are difficult to overprint. Therefore, there should be no intermediate



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## TPC 790, UV - Curing Pad Printing Ink

curing in multi-colour printing. Cure after printing all layers.

### **Cleaning**

For cleaning of stencils and tools our universal cleaning agent RE can be used.

### **Packing**

TPC 790-NT inks are available in 1 liter cans (approx. 1.06 qt.).

### **Shelf Life**

For information regarding shelf life please see tin label.

### **Marking**

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06.09.2004/Lgg  
TPC780\_en1.doc

# Technical Data Sheet TPC 780, UV - Curing Pad Printing Ink

## UV - Curing Pad Printing Ink TPC 780

### Application

TPC 780 is a UV-curing pad printing ink which was especially developed for ABS material. However, also SAN, polystyrene, PVC and other substrates can be printed.

Pretests are absolutely necessary!

### Colour Shades

The colour shades of the TPC 780-NT range show heavy metal free pigmentation and correspond to EN 71, part 3, safety of toys, migration of certain elements.

### Ink Colour Programme

*Process Colour according to European Scale*

TPC 780/180-NT yellow  
TPC 780/181-NT magenta  
TPC 780/182-NT cyan

*Mixing System Base Colours*

TPC 780/GF-01-NT primrose  
TPC 780/GF-02-NT golden yellow  
TPC 780/GF-03-NT orange  
TPC 780/GF-04-NT scarlet  
TPC 780/GF-05-NT magenta  
TPC 780/GF-06-NT red  
TPC 780/GF-07-NT violet  
TPC 780/GF-08-NT blue  
TPC 780/GF-09-NT green  
TPC 780/GF-11-NT white  
TPC 780/GF-12-NT black  
TPC 780/GF-13 varnish

### Adjustment for Pad Printing

Prior to processing pad printing inks TPC 780-NT are adjusted with 10 ... 20 % thinner VD or VS (quicker). Retarder = VG.

Viscospatula time = 6 ... 10 sec.

In the event of static discharge on the printing surface, our Antistatic Paste AP brings a splash-free printing quality.

Recommended range = 3 ... 5 %. More than 5 % results in less opacity.

Liquid anti-static products produce fewer positive effects.

### Processing

The following processing parameter have to be followed:

#### *Plate:*

All kinds of clichés can be used, however due to their better resistance steel plates are preferred. Criteria for choice of plates are comparable to those of conventionally drying pad printing inks.

#### *Plate depths:*

Plate with an etching depth of 16...24 µm.

#### *Type and quality of pad:*

Processing of TPC 780-NT should be carried out with AntiStatic-LongLife-Pads with an unworn surface (hardness 54 Shore-00).

#### *UV-curing*

Pad printing inks TPC 780 only cure under UV-radiation of suitable wavelength and intensity. Drying parameter depend on layer thickness, colour and substrate.

Curing energy should be between 500 and 1000 mJ/cm<sup>2</sup>. Maximum chemical and abrasion resistance will be achieved after a period of 24 hours.

NOTE: Cured prints are difficult to overprint. Therefore, there should be no intermediate curing in multi-colour printing. Cure after printing all layers.

### Cleaning

For cleaning of stencils and tools our universal cleaning agent RE can be used.



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# Technical Data Sheet TPC 780, UV - Curing Pad Printing Ink

## Packing

TPC 780-NT inks are available in 1 liter cans (approx. 1.06 qt.).

## Shelf Life

For information regarding shelf life please see tin label.

## Marking

Read material safety data sheets prior to processing.

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06.09.2004/Lgg  
TPC770\_en1.doc

# Technical Data Sheet TPC 770, UV - Curing Pad Printing Ink

## UV - Curing Pad Printing Ink TPC 770

### Application

UV-curing pad printing ink range TPC 770 is suitable for printing onto rigid and plasticized PVC, polycarbonate, polyester, polyamide, duroplastics, coated surfaces and various polystyrene modifications.

Due to the different properties of printing materials, even within the same material range, printing tests are absolutely necessary.

### Properties

UV- curing pad printing inks TPC 770 show good printability even if printing speed is high and the plates used are deeply etched.

Chemical resistance is good. They also show a very good abrasion resistance.

### Colour Shades

The colour shades of the TPC 770-NT range show heavy metal free pigmentation and correspond to EN 71, part 3, safety of toys, migration of certain elements.

### Ink Colour Programme

#### Standard Shades

TPC 770/60-NT white  
TPC 770/65-NT black

#### Process Colour according to European Scale

TPC 770/180-NT yellow  
TPC 770/181-NT magenta  
TPC 770/182-NT cyan

#### Mixing System Base Colours

TPC 770/GF-01-NT primrose  
TPC 770/GF-02-NT golden yellow  
TPC 770/GF-03-NT orange  
TPC 770/GF-04-NT scarlet

TPC 770/GF-05-NT magenta  
TPC 770/GF-06-NT red  
TPC 770/GF-07-NT violet  
TPC 770/GF-08-NT blue  
TPC 770/GF-09-NT green  
TPC 770/GF-11-NT white  
TPC 770/GF-12-NT black  
TPC 770/GF-13 varnish

### Adjustment for Pad Printing / Auxiliary agents

Printing consistency is adjusted with 5-15% thinner VD, VS (quicker) or retarder ZG.

Viscospatula time = 6 ...10 sec.

In the event of static discharge on the printing surface, our Antistatic Paste AP brings a splash-free printing quality.

Recommended range = 3 ... 5 %. More than 5 % results in less opacity.

Liquid anti-static products produce fewer positive effects.

### UV-curing

Pad printing inks TPC 770 only cure under UV-radiation of suitable wavelength and intensity. Drying parameter depend on layer thickness, colour and substrate.

Curing energy should be between 500 and 2000 mJ/cm<sup>2</sup>. Further processing and stacking of the prints can be carried out immediately after drying, however maximum chemical and abrasion resistance will only be achieved after a period of 24 hours.

### Processing

The following processing parameter have to be followed:

#### Plate:

All kinds of clichés can be used, however due to their better resistance steel plates are



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# Technical Data Sheet

## TPC 770, UV - Curing Pad Printing Ink

preferred. Criteria for choice of plates are comparable to those of conventionally drying pad printing inks.

### *Plate depths:*

Plate with an etching depth of 16...24 µm.

### *Type and quality of pad:*

Processing of TPC 770-NT should be carried out with AntiStatic-LongLife-Pads with an unworn surface (hardness 54/64 Shore-00).

### *UV-curing*

Pad printing inks TPC 770 only cure under UV-radiation of suitable wavelength and intensity. Drying parameter depend on layer thickness, colour and substrate.

Curing energy should be between 750 and 2000 mJ/cm<sup>2</sup>. Further processing and stacking of the prints can be carried out immediately after drying, however maximum chemical and abrasion resistance will only be achieved after a period of 24 hours.

NOTE: Cured prints are difficult to overprint. Therefore, there should be no intermediate curing in multi-colour printing. Cure after printing all layers.

### **Cleaning**

For cleaning of stencils and tools our universal cleaning agent RE can be used.

### **Packing**

TPC 770-NT inks are available in 1 liter cans (approx. 1.06 qt.).

### **Shelf Life**

For information regarding shelf life please see tin label.

### **Marking**

Read material safety data sheets prior to processing.

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materials as well as instructions for precautions when processing, handling and storing as well as first aid.

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**April 2000**



06.09.2004/Lgg  
TPC760\_en1.doc

# Technical Data Sheet TPC 760, UV - Curing Pad Printing Ink

## UV - Curing Pad Printing Ink TPC 760

### Application

For printing onto pre-treated polypropylene. Due to various degrees of polymerisation as well as contents and fillers the substrate polypropylene shows an undefined printability. Therefore printing tests in production conditions are absolutely necessary.

### Colour Shades

The colour shades of the TPC 760-NT range show heavy metal free pigmentation and correspond to EN 71, part 3, safety of toys, migration of certain elements.

### Ink Colour Programme

*Process Colour according to European Scale*

TPC 760/180-NT yellow  
TPC 760/181-NT magenta  
TPC 760/182-NT cyan

### *Mixing System Base Colours*

TPC 760/GF-01-NT primrose  
TPC 760/GF-02-NT golden yellow  
TPC 760/GF-03-NT orange  
TPC 760/GF-04-NT scarlet  
TPC 760/GF-05-NT magenta  
TPC 760/GF-06-NT red  
TPC 760/GF-07-NT violet  
TPC 760/GF-08-NT blue  
TPC 760/GF-09-NT green  
TPC 760/GF-11-NT white  
TPC 760/GF-12-NT black  
TPC 760/GF-13 varnish

### Adjustment for Pad Printing

Prior to processing pad printing inks TPC 760-NT are adjusted with 10 ... 20 % thinner VS or VT (quicker). Retarder = VG.

Viscospatula time = 6 ... 10 sec.

In the event of static discharge on the printing surface, our Antistatic Paste AP brings a splash-free printing quality.

Recommended range = 3 ... 5 %. More than 5 % results in less opacity.

Liquid anti-static products produce fewer positive effects.

### Processing

The following processing parameter have to be followed:

#### *Plate:*

All kinds of clichés can be used, however due to their better resistance steel plates are preferred. Criteria for choice of plates are comparable to those of conventionally drying pad printing inks.

#### *Plate depths:*

Plate with an etching depth of 16...24 µm.

#### *Type and quality of pad:*

Processing of TPC 760-NT should be carried out with AntiStatic-LongLife-Pads with an unworn surface (hardness 54 Shore-00).

#### *UV-curing*

Pad printing inks TPC 760 only cure under UV-radiation of suitable wavelength and intensity. Drying parameter depend on layer thickness, colour and substrate.

Curing energy should be between 750 and 1500 mJ/cm<sup>2</sup>. Maximum chemical and abrasion resistance will be achieved after a period of 24 hours.

NOTE: Cured prints are difficult to overprint. Therefore, there should be no intermediate curing in multi-colour printing. Cure after printing all layers.

### Cleaning

For cleaning of stencils and tools our universal cleaning agent RE can be used.



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# Technical Data Sheet TPC 760, UV - Curing Pad Printing Ink

## Packing

TPC 760-NT inks are available in 1 liter cans (approx. 1.06 qt.).

## Shelf Life

For information regarding shelf life please see tin label.

## Marking

Read material safety data sheets prior to processing.

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06.09.2004/Lgg  
TPC750\_en1.doc

# Technical Data Sheet TPC 750, UV - Curing Pad Printing Ink

## UV - Curing Protective Varnishes TPC 750

### Base

Based on pre-polymerised acrylates added with inorganic extenders.

### Application

Ink type TPC 750 has been developed as protection varnish for e.g. key pads, etc. is suitable for printing onto ABS, PC, PMMA and other plastics.

Due to the different properties of the printing materials, even within the same material range, printing tests are absolutely necessary.

### Properties

UV-curing pad printing varnishes TPC 750 show good printability and chemical resistance. They also show a very good abrasion resistance.

There are two versions available:

TPC 750/70-01-MT matt  
TPC 750/70-02-NT glossy

### Auxiliary agents

UV-curing pad printing varnishes TPC 750/70-00 and TPC 750/70-00-MT come in a ready-to-print consistency. If additional modification should be required for special reasons (e.g. bad drying or curing) the following universal additives are available for these UV-curing varnishes.

TPC 750/UV-A – sensitiser addition up to 2%

TPC 750/UV-V – thinner addition up to 5%

If possible the use of additives should be avoided as improper use, especially over-dosage, could result in a negative change of the original product properties.

Printing consistency is adjusted with 10-15% thinner or retarder:

Thinner VT  
Thinner VS  
Retarder VG

In the event of static discharge on the printing surface, our Antistatic Paste AP brings a splash-free printing quality.

Recommended range = 3 ... 5 %. More than 5 % results in less opacity.

Liquid anti-static products produce fewer positive effects.

### UV-curing

Protective varnishes TPC 750 / 70/00 and TPC 750 / 70/00-MT only cure and polymerise to a stable, resistant ink film under application of UV-radiation within a wave-length between 250 ... 410 nm.

Curing-parameters depend on the applied layer thickness, surface properties and temperature.

Curing energy should be between 500 and 1500 mJ/cm<sup>2</sup>. Further processing and stacking of the prints can be carried out immediately after drying, however maximum chemical and abrasion resistance will only be achieved after a period of 24 hours.

At room temperature drying speed will be about 3 m/min with 2x80 W/cm radiators.

This corresponds to an energy value of approx. 2000 mJ/cm<sup>2</sup>.

### Radiator

High pressure mercury lamps with an efficiency of 80–120 W/cm are used to produce the required UV-radiation. Their emission spectrum is approx. 250-410 nm with maximum values at certain wavelengths.



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TPC750\_en1.doc

# Technical Data Sheet

## TPC 750, UV - Curing Pad Printing Ink

The main problem with the radiators is the fact that the emitted spectrum does not always correspond to the absorption spectrum of the UV-curing pad printing inks and thus affects the curing speed. (Pretests in reference to UV-curing are absolutely necessary).

### Processing

The following processing parameter have to be followed:

#### *Plate:*

All kinds of clichés can be used, however due to their better resistance steel plates are preferred. Criteria for choice of plates are comparable to those of conventionally drying pad printing inks.

#### *Plate depths:*

Plate with an etching depth of 16...22 µm.

#### *Type and quality of pad:*

Processing of TPC 750 should be carried out with Anti-Static-Long-Life-Pads with an unworn surface (hardness 54 Shore-00).

### Cleaning

For cleaning of stencils and tools our universal cleaning agent RE can be used.

### Packing

TPC 750 inks are available in 1 liter cans (approx. 1.06 qt.).

### Shelf Life

For information regarding shelf life please see tin label.

### Marking

Read material safety data sheets prior to processing.

The material safety data sheets according to 91/155/EWG contain marking in compliance with the regulation on dangerous working materials as well as instructions for

precautions when processing, handling and storing as well as first aid.

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**April 2000**



## Reference Chart:

## UV - Pad Printing Inks Adhesion onto Substrates

		Groupe C					
System >	UV - Ink.	UV - Ink.	UV - Ink.	UV - Ink.	UV - Ink.	UV - Ink.	
Ink ref. >	TPC 750	TPC 760	TPC 770	TPC 780	TPC 790	TPC 860	
Puv mJ/cm <sup>2</sup> >	500 ... 1000	750 ... 1500	500 ... 2000	500 ... 1000	500 ... 1000	2000	
SUBSTRATE →	Specials >	Varnish	PP - Ink			versatile	versatile
<b>Polyolefine</b>							
pretreated polyethylene	PE		(+)	o		+	++
pretreated polypropylene	PP		+++	+		++	++
<b>Thermoplasts</b>							
Styrene	PS / SB		+++	o	+++	++	++
Styrene-polymerisate	ABS	+++	++	o	+++	+++	++
"	SAN		++	o	+++	+++	++
"	ASA		++	part. +	++	++	++
Linear Polyester	PET-A, E, P		++	+		++	
	PET-G		++	++		++	
Polyvinylchloride	PVC hard		+++	part. +	+++	+++	++
	PVC soft	+++	o	o			++
Polyacrylate Compounds	PAN						
Polymethylmethacrylate	PMMA	+++	pretr. ++	+	o / ++	o / ++	
Polymethacrylate Comp.	AMMA, MBS				o / ++	o / ++	
Polybutylerterphthalate	PBTP		pretr. +	o		+ / ++	
Polycarbonate	PC	+++	++	++	+++	+++	++
Polyamide	PA		pretr. +	o		+++ / ++	
Polyurethane	PUR						
Cellulose Acetate	CA						
Cellulose Acetobutyrate	CAB						
<b>Polyoxide</b>							
Polyoxymethylene	POM / POM-C		o	o		o	
<b>Thermosets</b>							
Thermosets (general)				++			++
Phenoplasts	MPF / PPO						++
Aminoplasts							++
<b>Ferrous Metals</b>							
stainless steel	V2A, V4A			+			+
steel / iron	Fe			++		++	++
<b>Non-ferrous Metals</b>							
Alu, oxidised/brushed	Al			++		++	++
plated chrome	Cr			o		o	++
copper	Cu					++	++
brass	MS					++	++
nickel / plated nickel	Ni						+
tin / plated tin	Sn				+	+	
zinc / plated zinc	Zn						
<b>Lacquered Surfaces</b>							
1-component lacquer				++	+	+	
2-component lacquer				++			
UV-lacquer	( CD 's )			+		+	
Powder lacquer				++			
<b>Other Materials</b>							
glass, ceramics	part. enamelled					o	++
uncoated wood							++
paper / cardboard							++
keyboards/golfballs	acc. to surface	+++					
<b>Elastomers</b>							
untreated rubber	rubber						
Thermoplastic elastomers	misc. TPE			part. +		part. ++	
Please read the technical data sheets on the respective pad printing inks and additives.							
All information is based on laboratory tests in conjunction with practical experience and daily usage.							