

FARBATOY-SPRAY



Fields of application

Two component spray painting ink/paint suited for the following substrates:

- ABS,
- Polycarbonate,
- Wood.

Different substrates may differ in printability due to difference in surface properties hence preliminary trials are essential before printing.

Application Process

These inks are suitable for spray printing over surfaces providing uniform deposition over the substrate.

Pre treatment with PU based clear coat over wood surfaces. Substrate should be wiped properly before spray painting.

Spray Printing Parameters

In order to achieve uniform composition of paint mixture a standard ratio of Ink ,Catalyst, Thinner should be thoroughly mixed.

A ratio of 6:1:4-6 where thinner percentage may be adjusted according to required viscosity based on temperature.

A spray viscosity of 15 ± 2 sec (measured using Ford cup 4 at 30°C).

For a better printability spray pressure of 3-5 kg/cm^2 should be applied. The spray gun nozzle size should be 1-1.5 mm(0.75 can be also tested for better results)

Flash off time of 5-10 mins required before second coat is applied.

Thickness of single coat measured by DFT is 20-25 μm .

Characteristics

These inks are nontoxic inks which follow global toy standards of **EN-71 Part-3, BIS 9873 Part 3 and HASBRO SRS-018 and SRS-046** stringent test requirements of heavy metals and phthalates.

The ink should be stirred homogeneously before and during spray coating.

Gloss units of 80 is obtained at 60° angle. Ink is glossy and has high opacity .

Since this is a 2-component ink system, it is required to add hardener in the right percentage and stir homogeneously.

While processing with hardener the temperature should not go below 20°C as the proper mixing won't occur at low temperatures. Also, high humidity should be avoided for proper curing.

Pre-reaction time

The ink mixture should be kept around 15 mins for pre reaction to occur.

Pot life

The pot life of ink catalyst mixture is 4-6 hrs at 30°C .Inks adhesion may decrease after the mentioned hours.

Drying

Once spray coats are applied, drying of the printed substrate should be done at 80°C for 30 mins.

The above statements are accurate to our best knowledge and belief. However, due to the great number of possible influences during the manufacture of the substrate and the variation in the application process suggest that suitability testing take place under actual conditions before production. No legally binding guarantee of certain properties or of the suitability for a definite application purpose can be derived from the above information.

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Colors

Basic shades

The basic shades consist of 8 basic colors .Moreover other colors can be made against request and wide colour shades for Pantone, HKS, RAL, NCS, etc.

BASIC COLOUR	COLOUR CODE
Yellow	SPR-2314
Standard Red	SPR-2317
Magenta	SPR-2318
Brown	SPR-2316
Standard Blue	SPR-2319
White	SPR-2313
Black	SPR-2326
silver	SPR-2320
Clear	SPR-2315

Additives

Catalyst:

Catalyst helps in increasing adhesion of ink film to the surface by chemically cross linking with the ink pigments. There is standard catalyst based on the ink composition.

Standard catalyst for this ink is CAT 159:

Catalyst 15-20% CAT 159

It should be noted that proper adhesion with hardener (chemical and physical resistance) can be attained after proper drying of coating with post treatment. Any test of adhesion should take atleast 12 hrs before performing it.

Dilutant:

Dilutant helps in adjusting the viscosity of the printing ink.

Exclusive dilutant should be used for this .Film performance may suffer due to the type of dilutant.

Dilutant DLT 170

Cleaners:

Surface should be cleaned before spraying. Poor adhesion may be caused by craters and foreign objects. Remove oil dust and mould free agents.

Universal cleaner RFR 297 can be used before spraying.

Sealing Agent:

A sealing agent provides smooth surface and better surface for spray coating

Sealing agent 5-10% EQS 275

Shelf Life

The shelf life for an unopened ink container if stored in a dark and cool room at a temperature of 15- 25 °C is 1 year. Keep away from flammable object and direct sunlight.

Precautions

For further information on safety, storage and environmental aspects concerning these products please refer to Safety Data Sheet.

Addition Technical information can be obtained from our product safety department.

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