

# 6800

Very high gloss

Various rigid plastics

## APPLICATIONS

The ink series 6800 is a glossy fast drying ink used for printing on a wide variety of rigid substrates: PVC, polystyrene, acrylic sheets (PMMA...), polycarbonate, ABS. This ink series can also be used on polypropylene with the adjunction of 10% hardener ST305.

## SUBSTRATES

- PVC
- Polystyrene
- Acrylic sheets (PMMA...)
- Polycarbonate
- ABS
- Polypropylene
- Solid prints or on objects (displays, illuminated signs...)

## BENEFITS

6800 series combines high resistance to petroleum, oil and grease, with great mechanical resistance. This ink can be thermoformed and thermo-soldered. Thanks to these properties it is particularly adapted for printing onto POP displays, lightsigns, home appliances (front panels), etc.

For the decoration of acetyl resin «Delrin», it is imperative to carry out a flame treatment after printing. When the coverage is not a requirement, the addition of 6890 varnish improves the brightness and increase the abrasion resistance.

## SPRAYING

This ink can be applied with a spray gun. It can be diluted with H Thinner prior to use.

## SPECIFIC OPACITIES

When printing on dark substrates, we can provide, upon request, high covering shades (heavily pigmented).

## SPECIAL PRECAUTIONS

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

Because of a large diversity of substrates, we recommend to carry out trials prior to the full production.

## ASPECT

Satin/glossy ink

## THINNING

Between 5 and 20%.

- Fast curing: ECO Rapide R
- Medium curing: ECO Moyen M
- Slow curing: ECO retarder
- Retarder with high stability: H6130

Drying: Around 30 seconds and 80 °C, 1 to 3 minutes at ambient temperature

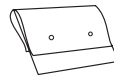
## PRINTING EQUIPMENT

Semi-automatics or automatics machines



## SCREEN MESH

The recommended mesh is 90 th/cm to 120 th/cm (229 th/inch to 305 th/inch).



## SQUEEGEES

Recommended with this ink: single, double or triple durometer polyurethane blades with hardness between 75 and 65 shore.



## DRYING/CURING

This ink cures only by evaporation of the solvent. Only for information, with 20% of thinner ECO R and a 120 threads/cm screen, drying time at ambient temperature will be: 4 to 6 minutes and drying time at 50/55 °C: 20 to 30 seconds.



## CLEANING

Solvents ECO N, screen opener H5726

## PACKING

1 kg & 5 kg





### STORAGE

The 6800 ink series are guaranteed to be stable in their original, unopened packaging; they have a shelf life of 24 months. Storage should be at a temperature between 15 and 25 °C (59-77 °F)

### 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...

### METALLIC SHADES

They can be obtained by mixing varnish 6890 with silver powders.

### 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 in 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. Encre 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 Encre DUBUIT contain no substances of very high concern. 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.

### EVALUATION OF LIGHT FASTNESS

The safest method of evaluation involves exposing the printed media in its actual atmosphere: the disadvantage of this method is the duration that must be equal to the desired time. The accelerated method allows to test the printed media in a specific device. In comparing the evolution of printing relative to standard stallions, we can deduct the strength indices (according to standard NFT 30-057):

1 = very poor - 2 = poor - 3 = moderate  
4 = pretty good - 5 = good - 6 = very good  
7 = excellent - 8 = outstanding.

Light fastness is the maintenance over time of the colour and intensity of a print. Not to be confused with the weather resistance or other factors than light which can decrease printing durability: moisture, air pollution, substrate, heat, cold, etc...

Light Fastness depends on the nature of the light (day or artificial light) and on light intensity (climate, season...). The strength of a print can vary with the thickness of ink deposit (the thinner the ink thickness, the weaker the light resistance) and the nature of the substrate. The strength of an ink depends on the components used (some binders or pigments are more resistant than others to light) and the percentage of dye or of the quantity of white pigment in the ink. Thus we should now that:  
Low intensity = loss of resistance.  
Pastels Tons = loss of strength.



**6800 RANGE  
SOLID COLOURS - 300 RANGE**

| ARTICLE DESIGNATION                                     | REF.  | CODE 1 KG - 1 L | CODE 5 KG - 5 L |
|---|-------|-----------------|-----------------|
| Primavera Yellow  | 300   | C068300K        |                 |
| Mid Yellow  | 310   | C068310K        |                 |
| Golden Yellow   | 320   | C068320K        |                 |
| Mandarin  | 330   | C068330K        |                 |
| Vermillion  | 340   | C068340K        |                 |
| Dark Red  | 350   | C068350K        |                 |
| Pink  | 360   | C068360K        |                 |
| Violet  | 370   | C068370K        |                 |
| Primary Blue  | 380   | C068380K        |                 |
| Emerald Green   | 390   | C068390K        |                 |
| <b>WHITE, BLACK &amp; VARNISH</b>                       |       |                 |                 |
| Black   | 11    | C068011K        |                 |
| Opacity   | 80    | C068080K        | C068080C        |
| Covering White  | 82    | C068082K        | C068082C        |
| Mat Extra Opaque White                                  | 12180 | C068083K        | C068083C        |
| Varnish   | 90    | C068090K        |                 |
| <b>ADDITIVE</b>   |       |                 |                 |
| Hardener  | ST305 | BDIV305K        |                 |
| <b>METALLIC SHADES</b>                                  |       |                 |                 |
| Rich Gold   |       | C068460K        |                 |
| Pale Rich Gold  |       | C068462K        |                 |
| Pale Gold   |       | C068464K        |                 |
| Silver  | 21S   | C068470K        |                 |
| Fluorescent Shades                                      |       | C068800K        |                 |
| <b>TRANSPARENT COLORS: PLEASE CONTACT US</b>            |       |                 |                 |
| <b>LAST FASTNESS SHADES (6800SL): PLEASE CONTACT US</b> |       |                 |                 |

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.