

# MIRROR SILVER H5996

# MIRROR PLUS SILVER H6000

Screen printing inks for obtaining mirror effects  
Economic alternative to the process of silvering

## APPLICATIONS

Mirror Silver inks H5996 and Mirror Plus H6000 are solvent-based screen printing inks for creating mirror-like surfaces or having the appearance of chromium. It is possible to print on transparent substrates such as polycarbonate, PMMA, rigid PVC, pre-treated PET and glass.

Mirror effect is made only when printed on the reverse side of the materials (second surface print) and when viewed through the top of first surface of the substrate.

Mirror Silver Plus H6000 provides the clearest mirror effect.

These inks are ready for use. Use only enough ink for printing during 5-10 minutes. Add ink in small amounts throughout the print in order to maintain stability in the screen. Mix the ink before printing under low shear (manually).

*These inks do not contain silicone; however, silicone oil residue (component of certain tension corrector and screen inks) can cause fish eyes or holes pins. Make sure to use only very clean tools and well degreased screens before printing.*

## SUBSTRATES

PC, PMMA, rigid PVC, pre-treated PET, glass

## DRYING

These inks may be dried at room temperature during 20-30 minutes or dried in a 50-60 °C (122-140 °F) oven for 10-15 minutes. A combined drying "tunnel rack" optimizes the mirror effect compared to a simple drying on racks. Drying at higher temperature may affect the mirror-like appearance. The gloss of the mirror depends on drying conditions and on the printing substrate and its surface. The surface hardness is optimal after 5 hours minimum. The surfaces must be clean, dust-free and free of fingerprints to obtain the best results.

The mirror finish cannot be obtained by printing on the first surface!

## OVERPRINTING

These inks are not compatible with lamination adhesives.

To increase the mechanical strength (scratch resistance) and chemical resistance (corrosion) it is recommended to apply a varnish, a black or a white, over the entire surface.

The metallic pigment used tends to delaminate and will be the most sensitive part when testing the tape interface.

Even when overprinted, the metallic film is not completely protected against atmospheric attacks.

## MIRROR LIKE EFFECT

- PETP/PETG: Medium
- PVC: Good
- PC: Very Good
- PMMA: Excellent
- GLASS: Excellent

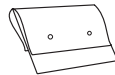
On some materials (e.g. PET, glass...), hardener AM 9192 can be added (5%) to improve adhesion. The pot-life of the mixture is around 2 hours. It will alter a little bit the mirror effect compared to the non-modified product.

Overprinting Mirror Silver H5996 and H6000 on other ink is not recommended.



## SCREENS

Depending on the required graphics and the percentage of thinning, the best mirror like effects are obtained with meshes from 90 to 120 lpcm. Screens must be solvent resistant and correctly insulated.



## SQUEEGEES

Polyurethane 70-80 Shore



### MILEAGE

Depending on the mesh used and the type of substrates, the yield reaches 35-50 m<sup>2</sup> per kg ink.



### CLEANING

Solvents H, ECO N Solvent 9380

Consult our Eco System document, available on request.



### STORAGE

The guaranteed shelf life of our inks, undiluted, in the original, unopened container is applicable to inks stored in a dry, well-aired environment at a temperature between 15 to 25 °C (59-77 °F).

These 2 references are guaranteed 6 months from the date of manufacture.

### HEALTH AND SAFETY

The vast majority of printing inks and related products formulated by Encre DUBUIT contain no substances of very high concern (SVHC) candidates for authorization (as of June 25, 2020) in concentrations greater than 0.1% by mass. 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.

*Encre 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.*

