

## HAC-series

HAC-series is a family of two-part reaction urethane ink developed for printing on Hard-coated acrylic, PC and PET,etc.

### **Specifications**

**Ink type** : Two-part reaction inks using an isocyanate hardener.

**Usage** : Hard-coated acrylic, PC and PET,etc.

**Finish** : Flat and semi-gloss

**Drying time** : Natural or forced drying

Set to touch in 40 minutes at room temperature(25°C): 20 minutes by forced drying at 60-80°C.

Hard dry in 4 days at room temperature (25°C); 60 minutes by forced drying at 60-80°C.

**Mixing ratio** : Main agent : Hardener = 10 : 1

Use within the pot life 6-8 hours since the mixture will turn to gel or lose its designed physical properties.

**Diluent** : Standard solvent T-926

Slow dry solvent T-927

Retarder T-980

**Notes** : HAC-hardener is very sensitive to humidity, so HAC inks should be used as soon as possible after opening.

## HAC-series ink film test result

Item	Condition						Result
Hardness	Pencil hardness 45° x 100g						3H
Adhesion	Peeling test at 1mm pitch crosscut test using cellophane tape						100/100
Water resistance	Soaked in water for a week						Not affected
Cold cream resistance	Applied cold cream (Kao made) on the printed surface after thermal shock resistance test						Not affected
Methanol resistance	Rubbed 50 times with methanol at 1kg load						Not affected
MEK friction resistance	Rubbed 30 times with MEK at 1kg load						Not affected
Gasoline resistance	Rubbed 100 times with gasoline at 1kg load						Not affected
Weather resistance	1000 hours of Sunshine Weather-O-meter						Not affected
Thermal shock resistance	°C	80	R/T	-20	R/T	x 20 cycles	100/100
	Hours	2	0.5	2	0.5		

- R/T = Room temperature (25°C)

Ink = HAC-120, HAC-Conc 710 Black

Material = Acrylic plate

Drying condition = 60°C x 30min. + 1 week at room temperature