Encres DUBUIT
INNOVATIVE INKS

D-PAD – 800 Colour System

Versatile solvent-based ink, suitable for open and closed machines
Compatible with all types of inkwell

APPLICATIONS
D-PAD is a satin/glossy, one-component pad printing ink designed for industrial and graphic applications.

SUBSTRATES
- Soft or rigid PVC
- Polystyrene
- ABS
- SAN
- Polycarbonate
- PMMA

BENEFITS
This pad printing ink is characterized by an excellent adhesion and mechanical resistance, especially when mixed with the hardener.

THINNING AND DRYING
D-PAD should be adjusted before use to the required viscosity by adding one of the following thinners (10 to 30% in weight):

- THINNER FAST: T-F
- THINNER UNIVERSAL: T-U
- THINNER SLOW: T-S

The thinner choice depends on the required speed, the quality you want to achieve and the parameters of the printing equipment.

Mixed with the fast and universal thinner, the ink has a very fast physical drying time between 30 and 60 sec at ambient temperature (20 °C).

The touch-dry time depends on the printing parameters such as cliché depth, temperature and additives used.

The complete drying time required to obtain all final mechanical and chemical properties is:

- 4 days for one component ink
- 7 days for two components ink

ASPECT
Satin/gloss finish

CLICHES & PAD PRINTING MACHINES
The curing system of D-PAD ink ensures an application in open and closed machines, if the ink's viscosity has been adjusted with the appropriate thinner.

Standard steel or photopolymer clichés can be used. An etching depth of 20-30 microns is recommended for optimum layer thickness.

D-PAD has been studied to be not corrosive, the ink ensures a smooth use with steel clichés.

Best printing results will be achieved with a pad reactivated by cleaning with a solvent such as an alcohol to remove residual silicone from pad's surface.

HARDENER & POT LIFE
In case of difficult adhesion or Polyolefin substrates (PP/PE), you must add 10% of hardener ST 305.

When mixed with ST 305 hardener, the pot life reaches around 8 hours at ambient temperature (20 °C).

The use of hardener will slightly extend the time of ink's curing. Furthermore, full curing is achieved after 4 days at a room temperature. After that time, complete adherence and physical properties are obtained.

GOLD & SILVER
D-PAD Silver 21S is ready to use.
Gold is availaible in two components in the following shades:

- Powder Rich Gold
- Powder Rich Pale Gold
- Powder Pale Gold

They are obtained in mixing the metallic powder into the varnish.

CLEANING
The pad-printing ink D-PAD can be removed from printing blocks and working materials without any difficulty, using DUBUIT's standard cleaning solvent 93801.

SURFACE ENERGY
A uniform surface energy of at least 42 mN/m is required for a good adhesion. The substrate surface should be free of graphite, silicone, dust and residues of grease or similar substances (e.g. finger prints).

PACKING
1 kg

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STORAGE

The D-PAD 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

Our color matching department works with an Xrite software and a spectrocolorimeter. It allows us to carry out any of your colour matching from 1kg. It is then necessary to give us as much information as possible about the type of substrate and its color, the screen mesh used, as well as a wet sample of the desired final shade.
If you have an Xrite software, we can also send you the IFSX files of the formulation guide. These formulation guides are also available in Excel files.

HEALTH AND SAFETY

The vast majority of printing inks and related products formulated by Encres 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.

D-PAD INK RANGE
SOLID COLOURS - 800 RANGE

ARTICLE DESIGNATION	REF.	CODE 1 KG - 1 L
Lemon Yellow	805	CDPAD805K
Yellow	810	CDPAD810K
Orange Yellow	820	CDPAD820K
Orange	830	CDPAD830K
Vermilion	840	CDPAD840K
Rubine	850	CDPAD850K
Pink	860	CDPAD860K
Violet	870	CDPAD870K
Blue	880	CDPAD880K
Deep Blue	885	CDPAD885K
Green	890	CDPAD890K
BLACK, WHITE, VARNISH		
Black	11	CDPAD011K
White	82	CDPAD082K
Varnish	090	CDPAD090K
GOLD & SILVER		
Powder Rich Gold		E10K
Powder Rich Pale Gold		E05K
Powder Pale Gold		E15K
D-PAD Silver	21S	W31560K
THINNERS		
THINNER FAST	T-F	DTFL
THINNER UNIVERSAL	T-U	DTUL
THINNER SLOW	T-S	DTSL
ADDITIVES		
Hardener	ST305	BDIV305K
Levelling Agent	ST155	BDIV155K

All basic shades 800 are included in our Colour Guide Formulation to create your own colours or to match Pantone colours. It is available on request.

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.

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