Encres DUBUIT
INNOVATIVE INKS

MG-PAD – 800 Color System

Solvent-based PAD PRINTING ink, two-component, for industrial application on GLASS and METAL

Compatible with all types of inkwells

APPLICATIONS
MG-PAD is a two-component pad printing ink for industrial glass and metal applications.

SUBSTRATES
- Glass
- Metal
- Ceramic

BENEFITS
This pad printing ink is characterized by excellent hardness, excellent mechanical and chemical resistance.

THINNING AND DRYING
MG-PAD thinners should be adjusted before use to the required viscosity by adding one of the following:

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

The thinner choice depends on the print parameters and the speed of production.

The touch-dry time is related to the deposit of ink printed on your support. It depends on the print settings such as the choice of cliché, the choice of thinner or the ambient temperature.

ASPECT
Very glossy

CLICHES & PAD PRINTING MACHINES
The curing system of MG-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.

MG-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
When the MG-PAD is mixed with 5% AM 9192 hardener, the pot life is approximately 6 hours at room temperature (20 °C).

The use of hardener AM 9192 requires compliance with the following instructions:

1. Add the required amount of hardener (5% by weight) and mix well.
2. Wait 15 minutes before use, this time is imperative in order to obtain the glossiness and the optimal resistances (a shorter time would be detrimental to the aspect and especially to the resistances).

Hardener	AM 9192
Dose use	95% ink 5% hardener
Time of use	6 hours
Temperature and polymerization time in an oven	100 to 130 °C 20-30 minutes
Polymerization time outdoors	7 days

CLEANING
The pad printing equipment (machine/plate) can be cleaned with the standard solvent from Encres DUBUIT: 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 metal box

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STORAGE

The MG-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.

MG-PAD RANGE
SOLID COLOURS - 800 RANGE

ARTICLE DESIGNATION	REF.	CODE 1 KG - 1 L
Lemon Yellow	805	CMGPAD805K
Yellow	810	CMGPAD810K
Orange Yellow	820	CMGPAD820K
Orange	830	CMGPAD830K
Vermilion	840	CMGPAD840K
Rubine	850	CMGPAD850K
Pink	860	CMGPAD860K
Violet	870	CMGPAD870K
Blue	880	CMGPAD880K
Deep Blue	885	CMGPAD885K
Green	890	CMGPAD890K
BLACK, WHITE, VARNISH		
Black	13	CMGPAD013K
Intense Black	14	CMGPAD014K
White	83	CMGPAD083K
Varnish	090	CMGPAD090K
THINNERS		
THINNER FAST	T-F	DTFL
THINNER UNIVERSAL	T-U	DTUL
THINNER SLOW	T-S	DTSL
ADDITIVES		
Hardener	AM 9192	E9192
Levelling Agent	ST155	BDIV155K

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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