SIGMA® Multi-Purpose Series Ink and Additive Usage Guide

	Single Component	MP200 Hardener (10% by wt.)	HR2 MP201 Glass Hardener (10% by wt.)	HR5 MP202 Adhesion Promoter (10% by wt.)	Polbond MP203 (5% by wt.) *Shortens pot life of the ink *and life of the pad	HR9 Pretreat (Corona of Flame)	Low Temperature Bake 175° - 20 min.)	High Temperature Bake 300° - 20 min.)
ABS/SAN	•							
Acrylic Glass (PMMA)	•							
Anodized Aluminium		•		•				
Glass, Ceramics and Chrome			•		•		•	
Metals		•						
PETG, PETA	•							
POM (Delrin)		•				•		•
Polyamide (Nylon, Kevlar)		•						
Polycarbonate	•							
Polyester	•			•				
Polyethylene, Pre-treated	•			•		•		
Polypropylene, Pre-treated	•					•		
Polyurethane		•						
Polystyrene	•							
Powder Coated Surfaces		•						
PVC, Rigid	•							
PVC, Flexible	•							
Phenolic			•		•			
Textiles, Cotton	•							
Textiles, Synthetics	•							
Varnished Surfaces	•							
Paper, Corrugated Board	•							
Wood	•							

Legend & Notes:

•*Recommended*

Catalysts: Ink hardeners and adhesion promoter must be mixed into the pre-measured ink supply before thinning.
Thinning: Adjust viscosity by using Thinner (10) to 15-30% by weight of ink, depending on application.
Ink Speed: Speed of the ink can be further adjusted by using Fast Thinner (2) or Retarder (8 or 4).