

**AM-P Series Pad Print Ink is a solvent-based/conventional Pad Print ink that has been formulated to meet adhesion requirements for most plastics, such as polycarbonate, polycarbonate blend, or pre-treated polyester substrates.**

## Substrates

- Polycarbonate
- Polycarbonate blends
- Primed / pre-treated polyester

Substrate guidelines are focused on commercially available materials that are intended for the particular market of the ink when processing the inks according to these technical data. Although technical information and guidance on the use of this product is given in good faith, it is the sole responsibility of the customer to choose the appropriate product for the end-use requirements.

## User Information

### Coverage

1,200-1,800 square feet (111–167 square meters) per gallon depending upon ink deposit.

### Catalyst

As an adhesion promoter, AM-PH Hardener works and can be applied up to 10 percent by weight to AM-P inks. For the ink mixture, this will create a usable pot life of 8 hours..

### Printing

Inks of the AM-P Series are formulated for ready pressing. Prior to printing, thoroughly combine the ink. Improper mixing can lead to inconsistent output of the color and the ink.

Keep ink temperature between 65 ° -90 ° F (18 ° -32 ° C) for optimal print output and cure. Lower temperatures increase the viscosity of the ink, decreasing flow and increasing the thickness of the film. High temperatures lower the viscosity of the ink, thereby reducing the concept of print and film thickness.

Pretest for evaluating optimum printing parameters for a given set of variables / conditions for ink, substrate, curing.

AM-P Series inter-mixing with other inks other than the AM-P Series is not recommended by Automated Marking Solutions.

## Drying / Curing Parameters

Drying: It is recommended AM-P ink needs to be heat-dried immediately after printing. Until subsequent layers are printed and dried, the ink film needs to be dry to touch.

To initially dry each layer of ink to contact and start the curing process, use conveyORIZED dryers set at temperatures of 150 ° F- 195 ° F (66 ° C-90 ° C). However, following this initial drying will not remove all the solvent.

## Clears / Varnishes

Mixing Clear / Overprint Clear: AM-P99 Clear may be used to reduce the density of colors. Glitter and other additives may be added at up to 10% by weight.

## Common Performance Additives

Prior to each application, all additives should be combined thoroughly. Check additive modification to the ink before fabrication. Inks that contain additives should not be combined with other inks.

Example for additives: Ink at 100g with 8% of an additive is calculated as:

$$100\text{g ink} + 8\text{g additive} = 108\text{g total}$$

Reducer: Use AM-P112 Thinner to reduce the viscosity of these inks. Add up to 15% by weight.

## Storage / Shelf Life

Closed containers are held at temperatures between 18 ° -25 ° C (65 ° -78 ° F). A shortened life can occur if products are stored outside of these recommendations. Do not return ink, whether mixed or not, taken from the inkcup or well back to the original container; store it separately to prevent contaminating unused ink.

Standard AM-P Series items are useable for a period of at least 48 months from the date of manufacture.

## General Information

### Ink Handling

All personnel mixing and handling these products must wear gloves and eye protection. Clean up

## AM-P Series Conventional Pad Print Ink

spills immediately. Wipe the ink off with a clean, dry, absorbent cloth if the ink is in contact with the skin (do not use a solvent or thinner). With soap and water, wash the area affected. For further guidance and warnings please review the appropriate (SDS / MSDS).

### Adhesion Testing

It is imperative to check adhesion on a fully cured print:

**Cross hatch tape test:** use a cross hatch tool or a sharp knife to cut through ink film only; then apply 3M #600 clear tape on cut area, rub down, wait for 1 minute and rip off at a 180 degree angle. Ink should only come off in actual cut areas.

### Manufacturer's Product Offering

Based on information from our raw material suppliers, these ink products are formulated to contain less than 0.06% lead. If exact heavy metal content is required, independent lab analysis is recommended.

### Standard Printing Colors

Standard Printing Colors have excellent opacity and flow characteristics. These colors are intended to work as supplied.

### Packaging / Availability

AM-P Inks are supplied in 1 kilo containers.  
 AM-P powders are supplied in 1lb containers

### Additives

AM-PH	Hardener
<b>AM-P112</b>	Thinner
AM-PR	Retarder/Slow Thinner

Additional colors not shown below:

#### AM-P98 Black

Can be used by itself or as the "K" in CMYK printing. Mix 50% with AM-P99 clear to create halftone

#### AM-P200 CMYK Cyan

#### AM-P201 CMYK Magenta

#### AM-P202 CMYK Yellow

Mix the above 50% with AM-P99 Clear to create halftones

#### AM-P99 Clear

# COLOR GUIDE FOR

# AM-P INKS



**AM-P03**  
Bright Red  
Pantone: 199



**AM-P04**  
Dark Red  
Pantone: 186



**AM-P05**  
Bright Orange  
Pantone: 2028



**AM-P06**  
Bright Yellow  
Pantone: 101



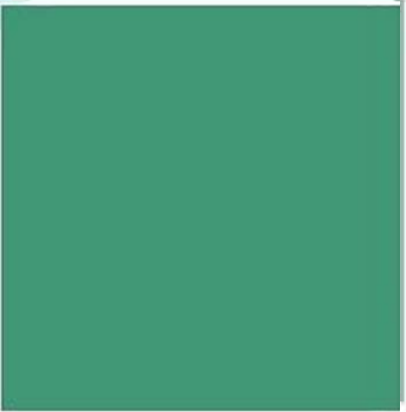
**AM-P07**  
Yellow  
Pantone: 108



**AM-P08**  
Medium Yellow  
Pantone: 109



**AM-P13**  
Grass Green  
Pantone: 347C



**AM-P09**  
Dark Green  
Pantone: 334



**AM-P10**  
Deep Blue  
Pantone: 2195



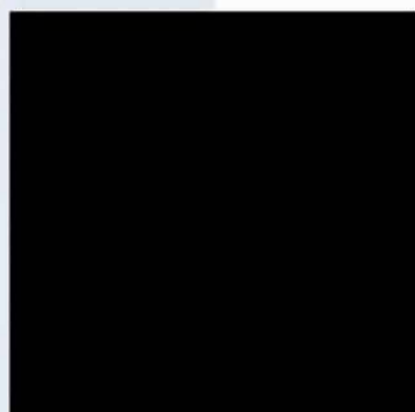
**AM-P11**  
Bright Blue  
Pantone: 072



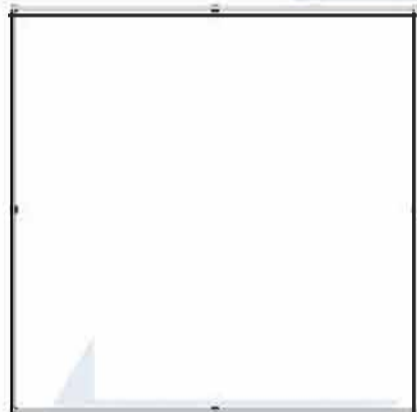
**AM-P12**  
Violet  
Pantone: Violet C



**AM-P108**  
Brown  
Pantone: 7631



**AM-P01**  
HD Black



**AM-P02**  
HD White

## METALLICS

Provided as powder.  
Mix with AM-P99 Clear



**AM-P68**  
Metallic Silver



**AM-P81**  
Metallic Gold



**AM-P73**  
Metallic Rose Gold

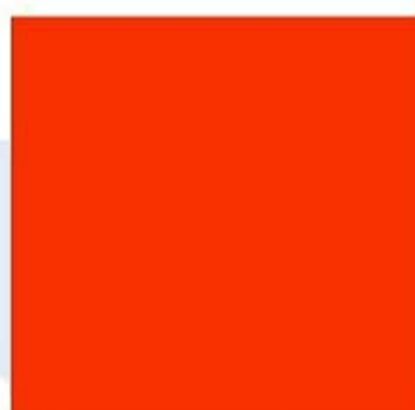
Also available: AM-P82 Pale Gold. Similar to Vegas Gold

## FLUORESCENTS

Provided as powder.  
Mix with AM-P99 Clear



**AM-P18**  
Fluorescent Red



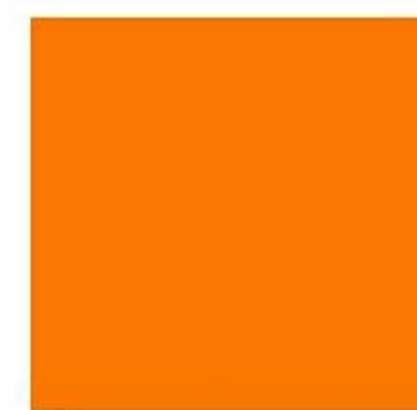
**AM-P19**  
Fluorescent  
Red/Orange



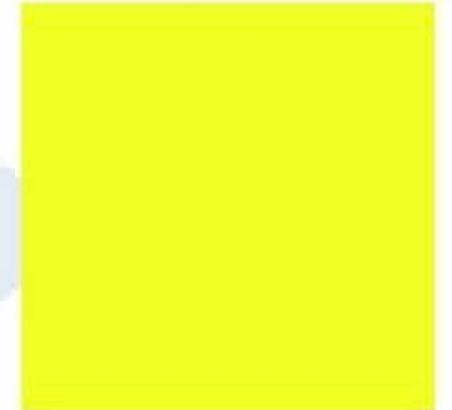
**AM-P20**  
Fluorescent Pink



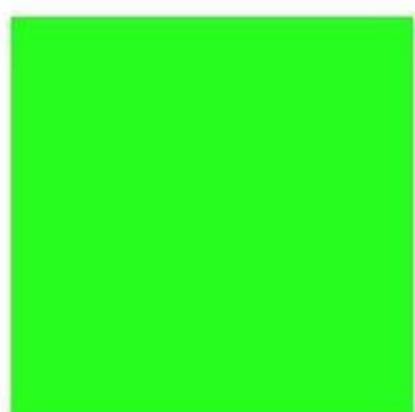
**AM-P21**  
Fluorescent  
Magenta



**AM-P16**  
Fluorescent  
Orange/Yellow



**AM-P17**  
Fluorescent Yellow



**AM-P14**  
Fluorescent  
Green



**AM-P15**  
Fluorescent  
Blue

**Please Note:** The ink tones in this electronic document are only an approximation of the real pad printing ink tone. All Pantone colors available by mixing.

**Important:** Depending on substrate color and material, ink tone deviations are possible.

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