



NORIPHAN[®] XWR

Halogen-Free Ink System for IMD/FIM Technology

Advantages:

1. Extremely high wash out resistance
2. Extremely high cohesion in compound
3. Extremely long screen opening time

Ink System

Mild solvent-based two-component screen printing ink.

Films

PC films and PET films after pre-tests.

Colors

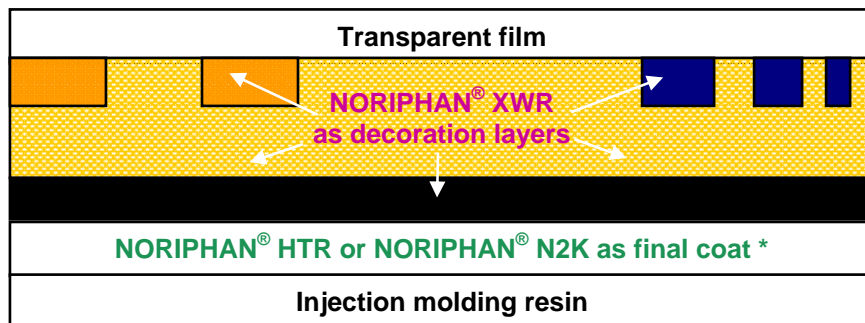
Halogen free basic colors (see NORIPHAN[®] HTR-HF color chart) and effect colors (see effect color charts).

Ink Recipe

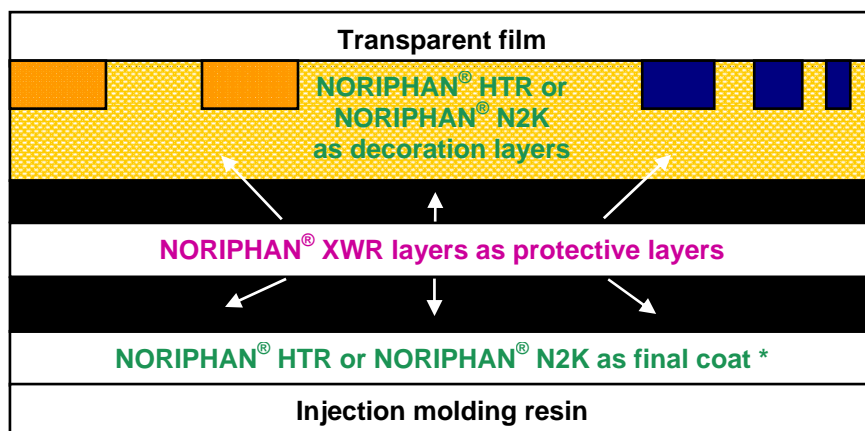
- 100 % NORIPHAN[®] XWR ink
- 10 % Hardener 8125
- 5 – 10 % Retarder NORIPHAN[®] XWR 097 (depending on graphics)

Printing Sequence

NORIPHAN[®] XWR as decoration ink



NORIPHAN[®] XWR as protective ink



* Final coat: to avoid sticking to the heated forming tool.

Pot Life	6 hours at room temperature (25 °C / 75 °F).
Mesh Count	Polyester mesh between 77-48 threads/cm (195-48 threads/inch) and 150-31 threads/cm (380-31 threads/inch).
Drying	<ol style="list-style-type: none"> 1. <u>for stack resistance of each printed layer:</u> <ol style="list-style-type: none"> a) 1. section: Jet drying at 80 to 90 °C (175 to 195 °F) 2. section: IR-drying 3. section: cooling <p>or</p> <ol style="list-style-type: none"> b) 1. section and 2. section: IR drying 3. section: cooling 2. <u>for wash out resistance after final coat NORIPHAN® HTR or NORIPHAN® N2K:</u> box oven drying with air exchange e.g. for 1 h at 90 °C (195 °F).
Forming	High Pressure Forming: preheated films and optimized forming conditions. Other methods after pre-tests.
Injection Molding	PC, PC/ABS, PMMA, TPU and other injection molding resins compatible with final coat.

This is a test product which is still in development. For this reason, no assurances are currently given as to type conformity, processability or long-term performance characteristics. Therefore, the customer uses the product entirely at their own risk with no guarantee.

Before starting a production run, it is necessary to test samples of each newly designed part systematically with regard to the specifications for the intended use (e.g. climatic chamber, resistance, etc.).

See Technical Information for processing details about NORIPHAN® HTR and NORIPHAN® N2K.

The information contained in the technical information/instruction sheets or other product information sheets is based on product testing conducted by Pröll. Because printing and environmental factors critically affect each individual ink application, the above mentioned information and instructions represent only general recommendations concerning product characteristics and directions for use and should not be construed as representing express warranties regarding the product. The information and instructions in no way release the purchaser from his obligation to verify and test the inks and their application for the specific request, regarding: product characteristics, weather resistance, mixing proportions, gloss, thinning, special mixtures, printability, drying speed, cleaning, effects on or of other materials to be contacted and safety precautions. All details contained in the instruction sheet "General Information on Screen Printing Inks" are to be considered. The further manufacture and use of products containing our inks by the purchaser takes place beyond our control, and the responsibility for further application and use of our product resides solely with the purchaser. Pröll disclaims any warranties, express or implied.

This information supersedes all previous technical information.