Technical Data Sheet

Leaded Effect (LEI)

Two-Part Three Dimensional Ink

CONVENTIONAL

Always test ink on substrate prior to production run. Please refer to the MSDS for safety precautions.

Description: A special two-part epoxy screen ink formulated to acheive a three dimensional leaded effect when printed on glass or metal. This can be considered a tremendous advantage over regular lead used in the construction of stained glass. The leaded effect series is a non-leaded product. This ink contains a material that will cause the printed line to a raise a small amount when baked. This acts to enhance the three dimensional appearance.

Qualities: • Satin Finish • 3D Leaded Appearance • Interior Durablility

Substrates: • Glass • Metal

Stencil: Use a Lacquer Proof or Direct Emulsion Film, Photographic, or Water-soluble Hand-cut Stencils

Coverage: 400-500 sq/ft. per gallon depending on ink deposit

Screen: 65 to 120 mesh recommended for most applications.

Mixing: Should be mixed by volume, at a ratio of 3.5 parts ink to 1 part catalyst. After mixing, allow to stand for about 20 minutes. This amount of time is required for molecular orientation.

Pot Life: Approximately 2 1/2 hours following 20 minute stand time for a 2/3 gallon mixture. The larger the mixture, the shorter the life.

Cure Parameters: Bake at 300-350 F for 3 to 4 minutes or 200-250 F for 5 to 6 minutes, depending on the size of the substrate. It is important that the oven temperature remain stable during curing. Hot spots in the oven will have an adverse effect on the ink.

Die Cutting/Creasing: Not recommended.

Additives: LEI03 Catalyst, LEI48 Flow Additive, LEI94 Thinner, and LEI95 Retarder

Cleaner: LEI96 Screen Wash for best results.

Storage: Store tightly, shut in a cool, dry, and dark place for minimum shelf life for 6-12 months.

Sizes: 1 Gallon Pail, 5 Gallon Pail, 30 Gallon Drum, 55 Gallon Drum

Products:				
	3909	Clear	3869	White
	3573	Metallic (Silver)	3596	Black
	3760	Metallic (Gold)		

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