



NoriGlass OR 930

Titanium White

Outdoor Resistant 2-Component Glass Decorating Ink –
silicone free

Area of Application and General Characteristics

OR – Outdoor Resistant

- **Very high Optical Density:** **OD ~ 1 @ 30 µm Layer Thickness**
OD ~ 5 if back-printed with NoriGlass OR 960
(x-rite 361T Densitometer)
- **Very High Degree of Whiteness:** **L* ~ 86; b* ~ -0.5; through Float-Glass (white)**
1,85 mm – SCHOTT PL FI OPT(05990)
back printed with NoriGlass OR 960
(x-rite color i 7; SCE, 25 mm aperture, 6 mm lens)
- **Very high Surface Free Energy:** **σ_{total} ~ 43 mN/m**
(→Very good bondability.) **$\sigma_{disperse}$ ~ 41 mN/m**
 σ_{polar} ~ 2 mN/m
(Krüss MSA; H₂O/Diiodomethane)

If printed on second surface, NoriGlass OR 930's properties allow the best possible realization of touch panels (white frame) or capacitive touch switches for outdoor applications.

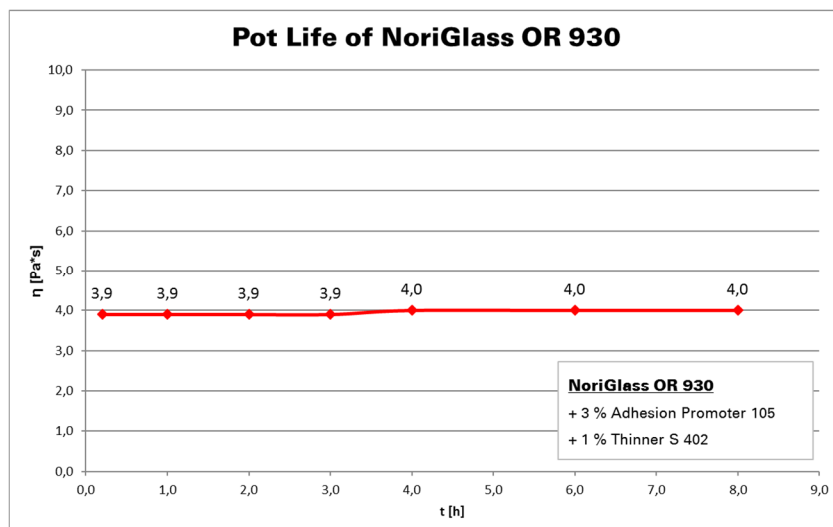
If back printed, the cured ink layer is opaque and convinces with its pure white color-shade.

Mixing Ratio

Prior to printing, NoriGlass OR 930 has to be mixed homogeneously with **3 % Adhesion Promoter 105** and the intended percentage of Thinner S 402 (5 % at most, for viscosity adjustment).

Optimal processing is stirring (blade agitator or dissolver).

Pot Life



NoriGlass OR 930

The mixture of ink and adhesion promoter must be processed within 8 hours.

Even if the ink still seems to be processable, an exceeding of the pot life will impair the adhesion and chemical resistance of the printed ink film.

Consequently, the quantity of the mixture should be limited in accordance with the amount required for the printing job.

This time span refers to a closed container and an ambient temperature of approx. 20 °C (70 °F). Higher temperatures accelerate the curing process.

Thinning

Thinner S 402

Addition: 0 – 5 %; combined addition with Adhesion Promoter 105 is possible.

Mesh

All usual screen printing fabrics and mesh counts are suitable.

Drying

Each ink layer must be dried separately, the final curing will be done after printing of the last layer.

Minimal drying: 3 min / 80 °C (175 °F)

Maximal drying: 180 °C (355 °F), time has no influence.

Overprinting of dried/cured ink layers without any negative effects on the final properties is possible within four weeks, but it is mandatory to store the prints during this time at appropriate dry and clean conditions.

Heat Curing

Heat curing of the last ink layer without loss of quality can be done directly after printing.

Minimal temperature: 150 °C (300 °F)

Maximal temperature: 180 °C (355 °F)

Minimal time: 30 min

Heat curing of dried ink layers without any negative effects on the final properties is possible within four weeks, but it is mandatory to store the prints during this time at appropriate dry and clean conditions.

Remark

A cleaned and degreased surface of the substrate is of decisive importance regarding adhesion and resistance of the baked ink layer. When cleaning, please consider that standard (glass) cleaners often leave residues of wetting agents on the surface which may impair the adhesion of the ink specially when exposed to mechanical stress or to steam (e.g. dew).

Outdoor Resistance

NoriGlass OR 930 is recommended for long-term outdoor applications, if printed on second surface.

Cleaning of Screens and Utensils

UNI-CLEANER FP61 und UNI-REIN A III

Shelf Life

The shelf life stated on the label assures the ink's and auxiliaries' (as adhesion promoter, thinner etc.) quality and refers to unopened original cans stored in a dry place at temperatures between 5 °C (40 °F) and 25 °C (75 °F).

Opened containers of Adhesion Promoter 105 must be tightly closed immediately after use as it reacts with moisture in the air.

Important

Allow the ink as well as all the auxiliaries to be added to adjust to room temperature in the closed container before use.

Printing results, to a large extent, depend on the substrate as well as the printing and application conditions. We recommend checking your printing materials under your conditions of use before performing any production runs. Materials that are supposed to be identical may vary from manufacturer to manufacturer and even from batch to batch.

In general please refer to our technical leaflet "General Information on Screen Printing Inks" which may be downloaded from our website www.proell.de, click Downloads ⇒ Solvent-Based Screen Printing Inks.

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.).

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.

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