

Series

XFM

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Type: solvent

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Printing process: screen printing

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Ink type: one and two-component

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Finish: glossy

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Materials: ABS, Lacquered surfaces, plasticized PVC, Polycarbonate, Polymethacrylate (PMMA), Polystyrene, rigid PVC, SAN, treated Polyester, Wood

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Main features:

- . Glossy
- . Moderate coverage
- . Good flexibility
- . Quick drying
- . Good light fastness
- . Excellent solidity for external applications
- . Soluble during printing

Thermoplastic substances are sensitive to tension cracks, especially PS and PC, due to the solvents present inside the ink. Pre-tests are absolutely essential for such printing applications.

XFM series mixed with hardener has a pot life of approx. 8h (at 20°C).

Higher temperatures and humidity will reduce pot life

(recommended temperature 20-25°C and low moisture content in the workplace).

Used as 2-component ink, XFM series has to be mixed with hardener at a specified ratio prior to processing.

Thinner is added after addition of hardener.

The mixed ink should be allowed to pre-react for approx. 15 minutes prior to print.

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Certifications: CLP/GHS (EC 1272/2008), Conflict minerals free, EN 71-3, Reach (EC 1907/2006), RoHS

The EN 71:3 Directive is valid for standard shades of one component inks, two component inks, Ink system and Process colors, HD shades and for all not standard shades which do not contain metallic shades, metallic pastes or fluorescent pigments or inks.

In order to clarify any doubt on not standard shades, it is always recommended to provide us a specific request.

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Eco-sustainability (free of): Animal origin ingredients, Aromatic Hydrocarbons, Azo dyes, Bisphenol A (BPA), Formaldehyde, G-B Ester, Latex, Melamine, PAH, Persistent organic pollutants, Phthalates (listed in RoHS directive)

Note: shades in the fluorescent color chart contain formaldehyde.

Note: inks are formulated without aromatics naphthas, potential IPA contaminations are minimal.

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Outdoor resistance (years): 2

The ink is recommended for outdoor exposure.

The pigments' solidity rate is between 7 and 8 DIN on the WOOL scale.

In case of mixing with the transparent bases 70 TR or TP, or with white 160 or 60 BN, the light fastness and atmospheric agents decrease.

If you want to increase the outdoor solidity, it's recommended to add 5-7% of UV adsorber to the ink.

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Drying process: 10 minutes at room temperature

XFM series dries physically by evaporation of solvents or through chemical reaction.

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Drying times depend on various factors:

- . Thickness of printed ink layer (single print, multi-layer print).
- . Type and amount of thinners/retarders used.
- . Type of oven
- . Drying temperature
- . Type of substrate on which the ink is deposited.

Ink dries physically by evaporation of solvents:

- . 15-20 minutes at room temperature (depending on local conditions)
- . 45 sec at 50°C in an air circulation oven.

(The test performed in our laboratory was carried out under the following conditions: 8 mt / min, 120.34 screen printing mesh, medium thinner Diluente Vinilico at 15%, air circulation oven).

Two-component drying by polymerization:

When the Series XFM is added with the relative hardener, at the beginning the ink dries physically, followed by the polymerization reaction which takes place at room temperature (20°C) in at least 5-7 days.

If the printed film is heated in an oven at 80°C for about 10 minutes, the polymerization is completed within 48 hours.

Mechanical and chemical solidity:

Alcohol	
Detergents	as two-components
Flexibility (Elasticity or Bending)	good
Greases	as two-components
Oils	as two-components
Sunlight-proof	as two-components
Surface hardness (Abrasion)	
Weather-proof	as two-components

The tests must be carried out 5-6 days after complete polymerization.

Colours range: EXTRA - M, SEGNALETICA

170	12-S	23-S	38-S	66-S	77-S				

Please refer to the Glossy, Metallic, Fluorescent and Ink System ink color charts.

The Ink System are 12 colour shades for mixing of RAL, PMS and HKS colours.

The metallic shades are available only by mixing the relative pastes with the Transparent Base XFM 70 TR.

Gold paste 75 10-20%

Gold paste 76 10-20%

Gold paste 77 10-20%

Bronze paste 78 10-20%

Silver paste 79-050 10-15%

The metallic pastes composed with the relative transparent base XFM 70 TR, due to their particular composition, can oxidize.

The pot-life of the compounded METALLIC PASTES is about 8 working hours.

In the Ink System color chart are present the shades:

1080 yellow, 1081 magenta, 1082 blue, 1083 black, TP paste (CMYK), necessary for making four-color prints.

In the range are also included the following shades :

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160 HD Opaque white

165 HD Opaque black

165 S Non magnetic black

## Auxiliaries and additives:

VINILICO medium thinner	15%	
LH-DL slow thinner	15%	
XF-DR fast thinner	15%	
XFH-N Green hardener	5%	for outdoor applications. isocyanate content < 0,1%
XFH hardener	10%	
XFH-N hardener	10%	for outdoor applications
Retarder paste	10%	max
M 2000/S levelling agent	1%	
Universal antifoam agent	1,5%	
Antisilicone/s	1,5%	
UV Adsorber	8%	
NPT matting powder	2%	6% max

## Ink removal:

DACS solvent

Lavaggio telai solvent

Aprimaglia Spray

## STORAGE:

Please keep the cans in a dark place, at temperature of 15-25°C.

If the recommended temperature is higher than the suggested one or the cans are not completely closed, the shelf life and the qualities are drastically reduced.

## CLASSIFICATION:

Before using this ink, consult the relevant safety data sheets available.

The safety data sheets provided comply with the REACH regulation (EC 1907/2006).

The hazard classification and related labelling are compliant with the CLP / GHS regulation (EC 1272/2008).

## OTHER INFORMATION:

For more information on SERICOM ITALIA srl products, refer to the website [www.sericom.it](http://www.sericom.it)

## NOTE:

Our technical consultancy activity, carried out orally, in writing or through tests or experiments, takes place on the basis of our best knowledge.

However, the same must be considered as information without any binding value, also as regards any third party industrial property rights.

This does not exempt the customer from performing his own checks on the products supplied by us in order to estimate the suitability or otherwise of the procedures and for the purposes intended.

The application, use and transformation of the products take place outside our control possibilities and therefore fall under the exclusive responsibility of the customer.