

NorCote Metallic Paste & Ink Guidelines		Maximum amount of paste/ink into Clear or Standard Color						
		038P**	040 P	042 P	044 P	046 P	240*	242*
		Silver Powder	Gold Paste	Silver Paste	Red Gold Paste	Copper Paste	Rich Gold Ink	Silver Ink
	Particle Size	13um	35um	35um	35um	35um	3um	10um
	Metal	Aluminum	Bronze	Aluminum	Bronze	Bronze	Bronze	Aluminum
<b>Standard</b>	% Metal Content	74	50	50	50	50	34	10
<b>Ink Series</b>	<b>Clear recommended</b>							
ALL	XXX-000 or XXX-049	10-20%	25-30%	15-20%	25-30%	25-30%	40%	40%
<b>POP Inks</b>	<b>Clear recommended</b>							
UV9	UV9-011 Metallic Mixing Clear	10-20%	20%	8%	20%	20%	40%	40%
GN	GN-011 Metallic Mixing Clear							
VL	VL-011 Metallic Mixing Clear							
DC	DC-010 Mixing Clear							
XL6	XL6-011 Metallic Mixing Clear							

#### **Mesh**

Metallic pastes contain large particles. For this reason we recommend using a mesh count of 305 threads per inch (120/cm) or lower to avoid plugging the mesh. The metallic inks contain smaller particles allowing the printer to use mesh counts of 355 threads per inch or lower.

#### **Color**

Metallic prints can look totally different before and after printing due to leafing, overlapping of particles. When viewing color be aware that the print will appear darker when viewed at an angle instead of viewing straight on. Pigmented inks in the same series may be added to modify the metallic color. Caution: Inks decrease in brilliance after 24 hours when added to other inks. Mix only enough ink for one day. UV metallic inks are not lightfast and will tarnish when subjected to outdoor conditions.

#### **Cure**

As metallic inks can be difficult to cure, Norcote would recommend doing a scratch test as well as the crosshatch tape test, (ASTM#D3359-97), after exiting the curing unit and cooling to room temperature. The tape test alone may not give a true reading when printing metallic.

#### **Shelf Life**

The pastes alone have a shelf life of 6 months from the date of manufacture when stored in a tightly closed black container in a cool dry area. Store the 040 Gold paste between 18C-35C to avoid solidifying. If this occurs, reliquify the paste by placing it in an area with temperatures of 25C-35C. The 240 Rich Gold Ink and 242 Silver ink are warranted for 3 months from the date of manufacture when stored under the proper conditions.

\*The 240 and 242 are finished inks with limited adhesion prior to adding to a clear base. Please test and confirm adhesion to the substrate before a production run.

\*\*Requires Haz-Mat shipping fee.



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