

ACE Series Thermal Set Ink

Excels for Exterior Use On Metals

Formulated for exterior applications, ACE Series Thermal Set Ink offers excellent adhesion and hardness for metal. Extremely durable, weather resistant high gloss finish for general OEM use, nameplates, equipment panels, automotive parts, as well as graphics projects such as outdoor signage.

STANDARD COLORS

High Cover White*	ACE-203
Black*	ACE-204
Primrose Yellow*	ACE-205
Lemon Yellow*	ACE-206
Medium Yellow*	ACE-207
Orange*	ACE-209
Fire Red*	ACE-210
Flag Red*	ACE-211
Deep Red*	ACE-212
Magenta*	ACE-213
Light Blue*	ACE-214
Perma Blue*	ACE-215
Navy Blue*	ACE-216
Ultra Blue*	ACE-217
Emerald Green*	ACE-218
Perma Green*	ACE-219
Clear*	ACE-200
Halftone Clear*	ACE-201
Rollercoat Clear*	ACE-202

TRANSPARENT COLORS

Transparent Yellow*	ACE-231
Transparent Orange*	ACE-232
Transparent Red B*	ACE-238
Transparent Magenta*	ACE-233
Transparent Violet*	ACE-234
Transparent Blue*	ACE-230
Transparent Green*	ACE-235

METALLICS

Pale Gold*	ACE-225
Rich Gold*	ACE-226
Silver*	ACE-228
Bright Silver*	ACE-229

*Heavy metal compliant



SUBSTRATES

Metals, including mill finished, anodized aluminum and some powder coated.

BAKE/CURE

ACE SERIES INKS WILL NOT CURE BY AIR DRYING

Bake Dry:

- 300°F for 15 minutes
- 350°F for 8 minutes
- 400°F for 4 minutes
- Flash-off 30 seconds at 500°F.

Equipment: Batch oven with convection air or industrial conveyor dryer (non-textile) are preferred. IR panels may provide sufficient cure if belt will

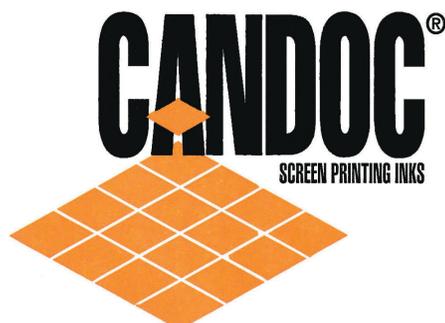
STENCILS	SCREEN MESH	SQUEEGEE
Direct method emulsions, capillary films	260 to 300 Monofilament	All types, 60 to 80 durometer

MODIFIERS

- Reducer:** ACE-250
- Retarder:** ACE-251
- Flow Promoter:** ACE-252
- Wash Up:** W110

COVERAGE

Approximately 1200 - 1500 Sq. Ft / Gal.



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Note: Information contained in Cudner & O'Connor printed matter is based on laboratory and field tests. Because we cannot control actual production conditions, no warranty is expressed or implied. Careful testing is always recommended prior to production. Consult with our Technical Services Department on all application issues.