



PRODUCT DATA SHEET

W HARDENER

DESCRIPTION:

W Hardener is a non-MDA epoxy hardener which is designed for use with PC 401 Solder Mask, and PC 421 and PC 441 Legend Inks. In addition to improving the rheological consistency and stability of these materials, W Hardener offers many process advantages.

PHYSICAL PROPERTIES			
Color:	Off-White to Tan	% Solids:	61 – 63%
Odor:	Mild to None	Viscosity:	55 – 85 kcps

POT LIFE:

W Hardener extends the pot life of all compatible materials to three days with no significant change in rheology, given appropriate storage conditions (65°F > T < 90°) .

MIXING RATIOS:

The mixing ratio for W Hardener with PC401 and PC421 is 12.5 parts per 100 parts by weight, or 125 grams per kilogram. The mixing ratio for W Hardener with PC 441 is 10 parts per 100 by weight, or 100 grams per kilogram

DIRECTIONS FOR USE:

Mixing: * 20 minute hold is recommended after mixing

By weight:

Mix 10 parts by weight of W Hardener with 100 parts by weight of PC 441 Legend Ink.
Mix 12.5 parts by weight of W Hardener with 100 parts PC 421 Legend Ink or PC 401 Solder Mask.

By Pail:

Open the ink container and make a depression in the center of the ink. Place the entire contents of the appropriately pre-measured W Hardener in the depression. Close the

container and shake on a mechanical shaker for 5 minutes. Open pail and scrape down the sides and corners. Replace the pail on the shaker and continue shaking another 10 minutes.

Surface Preparation Consult Technical Information Bulletin 101-1,2,3 for specific surface preparation recommendations, or refer to "PC 401 Solder Mask Processing Recommendations Sheet" (TI-129).

Screening Recommendations: Consult PC 401 Solder Mask Processing Sheet for specific screening recommendations.

Cure Cycle: Solder Mask and Legend Ink mixed with the proper amount of W Hardener will cure in 25 minute at 275°F (135°C) .

STORAGE AND SHELF LIFE:

For optimum performance, W Hardener should be stored at temperatures no lower than 65°F (18°C), and no higher than 90°F (32°C). Material stored at temperatures outside the required range should be kept at 75-80°F (24-27°C) for at least 24 hours prior to use for designed screening properties. There is no limitation on the shelf life of the uncatalyzed material if stored properly. For optimum screening performance, 1 year is recommended.

CAUTION:

Keep away from heat and flames. May cause irritation. Avoid contact with eyes or prolonged contact with skin. Wash exposed areas with soap and water; flush eyes with water for 15 minutes. Wash clothes before re-use. Use adequate ventilation, avoid exposure for long periods of time. If inhaled, remove to fresh air, give oxygen and artificial respiration, if needed. Do not take internally. If swallowed, give water or milk, induce vomiting. Seek medical attention.

The above information is based on our experience and is, to the best of our knowledge, true and accurate. However, since the exact conditions and methods of use of the described products are beyond our control, both the information and the products are offered without guarantee or warranty with regard to their use. Nothing in the above information shall be construed as a recommendation to use the described products in violation of any patent rights.

For more information, contact
Clark International, Inc.. P.O. Box 8808, Rancho Santa Fe, CA 92067
Telephone: 858.227.3087 Fax: 858.759.3087
www.ClarkInt.com