

**OCR** is digital ink designed to meet the rigorous requirements for membrane switch/touchplate applications. OCR, when optimally printed, will hold up to the majority of the aggressive adhesives used for membrane switch applications. **OCR** was designed to work with Ricoh Gen 4 and Gen5 printheads. OCR also incorporates our proprietary cure system that enables it to **cure under both mercury vapor and LED cure systems**.

Key performance properties include:

- Excellent adhesive compatibility
  - Demonstrates chemical resistance (50 rubs) to acetone, isopropyl alcohol (99 & 70%), brake oil, Windex, and Gasoline (3 hour soak)
  - Minimal delamination, even with highly aggressive adhesives (12 lbs peel 45 degree pull on 3M 467 & 486 on polycarbonate)
  - Ability to hold up to a high number of actuations\*
  - Water and moisture resistant
  - Ability to emboss up to 150% of the based print material thickness
  - Extremely wide color gamut to match most corporate I.D./brand colors
- \*- separate actuation testing is recommended

#### Performance Properties

- Vibrant colors
- Excellent adhesion
- Dual Cure(Mercury Vapor & LED)
- Outstanding scratch resistance
- Compatible with 3M Adhesives for membrane switch applications
- Chemical Resistant

#### Curing

- Mercury Vapor
- LED 395 nM (8 watt minimum)

#### Known Compatible Presses

- Ricoh Gen 4
- Ricoh Gen 5

#### Recommended Substrates

- **Polycarbonate**
  - Lexan 8010 (with adhesive)
- **Polyester (only works with 300 LSE adhesive)**
  - .007 ST505 Melinex Heat Stabilized
  - .005 561 Melinex

#### Recommended Adhesives

- 3M 467 & 468 Adhesive
- 3M 300 LSE Adhesive
- 3M 9653 Adhesive
- 3M 9462 Adhesive

\*pretest required with each adhesive; 300 only on Polyester)

\*\*600x900 dpi, 14 picoliter drops; colors 1X, white at 1.5X for best adhesive properties

#### Lightfastness

The OCR ink system is currently undergoing simulated weather/lightfast testing in a Xenon Arc unit (ASTM-3424-11 Method 4). Accelerated weathering is a reference standard only and cannot precisely predict actual outdoor performance.

#### Storage

Care should be taken to store ink in tightly closed containers located in a cool dark place at ambient temperatures. With suitable conditions, unopened ink is expected to have a shelf life of approximately twelve (12) months.

#### Precautions

Read the Safety Data Sheet (SDS) prior to processing. It contains instructions for precautions to be taken when handling inks. If ink comes in contact with skin wipe ink off with a clean, dry cloth. DO NOT USE SOLVENT. Wash and rinse the affected areas with soap and water.

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