



# Technical Data Sheet

**A-A-56032D**  
**EPOXY MARKING INK**  
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**PRODUCT:** A two-component, catalyzed epoxy marking ink coating for metallic or other non-porous surfaces and printed wiring boards. A-A-56032D is low VOC and lead and chromate free.

**PROPERTIES:** SOLIDS(Weight) - 59% Minimum  
MAX VOC ADMIXED - 420 grams/liter (3.5 Lbs./Gal)  
COLORS - Clear & All Fed.Std 595 Colors

## **DRYING TIMES AND PROCESS INFORMATION**

DRY TO TOUCH - 2 Hours

FULL CURE TEMPS FOR BAKING - Bake 60 minutes @ 200 Degrees F

OR

Bake 45 minutes @ 250 Degrees F

OR

Bake 120 minutes @ 150 Degrees F

CURE VIA AIR DRYING – 48 to 72 Hours\*

CURE TO SOLVENT RESISTANCE – 7 Days

THINNER - MIL-T-81772B TY. II

INDUCTION TIME – 1 Hour

POT LIFE – Approximately 4 Hours

SHELF LIFE - 1 Year

\*Because of differences in humidity, temperature and substrates, a general rule for full air cure time is 48-72 hours

***Fast. Reliable. Accurate. Superior Coatings of America***

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**MIXING/APPLICATION INSTRUCTIONS:** Each of the two components should be thoroughly mixed separately. Component B is then slowly poured into component A, with constant stirring. The mixing ratio is one to one of each component by volume. Mix thoroughly and allow to induct for one hour before using. Coating is normally ready to use as packaged. If needed, reduce admixed material up to one pint per gallon with MIL-T-81772B Ty. II Thinner. Apply a mist coat and allow to dry to touch (30 Minutes). Apply a second coat to a total dry mil thickness of 1.5 to 1.8 mils. For brushing, use as is after induction time. If higher viscosity is needed, allow a longer induction time, as coating will become thicker with more dwell time.

**SURFACE PREPARTAION:** Surface must be completely clean, structurally sound, and free of all contaminants (including dirt, wax, loose paint, grease, etc.). Greasy or oily surfaces must be cleaned with solvent with care. Do not paint over moist / wet surfaces.

**PRECAUTIONS:**

KEEP OUT OF REACH OF CHILDREN.  
USE WITH ADEQUATE VENTILATION.  
AVOID CONTACT WITH SKIN AND EYES.  
READ MATERIAL SAFETY DATA SHEET BEFORE USING.  
CONTENTS ARE FLAMMABLE.

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