

PRODUCT DATA SHEET

TT-I-558 INK, MARKING STENCIL, ENAMEL PTI SPECIALTY SERIES

DESCRIPTION

TT-I-558 covers one type and one grade of opaque stencil ink for marking non-porous surfaces. The ink covered by this specification is a light and weather-resistant, medium drying, flat-finish stencil ink for marking metals, glass, stone, and similar non-porous surfaces. It is intended primarily to be used with an ordinary wood-handle stencil brush and stencil board. It may also be used with a hand-lettering brush or may be applied by spray or roller coater.

COLORS

This coating can be provided in every color and gloss range 595C FED STD. Custom colors are NOT available.

COATING PROPERTIES & CHARACTERISTICS

Specification	TT-I-558
Recommended Primer(s)	PT-522
Reducer	PT-1003TYIII & PT-1022X66
Toxicity	No known toxicity when used under normal conditions
Solids Content	28% – 32%
Viscosity	20 – 50 centipoise or 18 – 25 seconds in a #2 Zahn Cup
Weight per gallon	8 lbs/gal ± 0.3

SHELF LIFE

Shelf life is only applicable for materials stored in unopened and undamaged original factory filled containers.
1 year when stored between 50°-85° Fahrenheit.

CLEANING

All parts must be chemically or mechanically cleaned, film free, by an industry recognized cleaning specification or method.

MIXING INSTRUCTIONS

For thinning, **PT-1022X66** reducer should be used. If **PT-1022X66** thinner is not available use MIL-T-81772B TY. III (PT-1003TY III). For spraying thin 4 parts paint to 1 part thinner.

APPLICATION

This product can be applied using brush, dripping, conventional air spray equipment or HVLP Spray system. Please consult with a PTI representative for specific equipment recommendations and settings.

1. Make sure pots, guns, and lines are purged and cleaned.
2. HVLP Spray Pressure: 7-10psi. Conventional Spray Equipment 15-30 psi
3. Always air-blow and tack wipe the surfaces to be painted. Parts should be grounded to prevent static.

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4. Best application results: apply 2 coats: 1 fog/tack coat & 1 full coats from 0.75 – 1 mil thickness.
5. Allow 20-30 minutes to pass before applying additional coats.

NOTE: Application of PTI products requires the use of all OSHA approved safety equipment, including proper ventilation. Additionally, PTI products require the recommended temperature/humidity conditions and film thickness ranges for optimal performance. The material, hangar, and aircraft skin temperatures should be no lower than 75° F / 25° C before, during and after application.

DRYING & CURING SCHEDULE

Air Dry Times (75°F / 25°C and 50% Relative Humidity)

- Set to touch 2 hours.
- Dry Hard 8 hours
- Full Hardness 72 hours

EQUIPMENT CLEANUP

Use clean Acetone, IPA, or PT-1070. Do not allow material to dry or cure inside any equipment.

HEALTH, SAFETY, & STORAGE REQUIREMENTS

Refer to each individual material SDS (Safety Data Sheet) for specific requirements on the health, safety, storage and handling requirements. Follow all local, state, and national regulations during surface preparation, material application and cleanup.

PRODUCT INFORMATION & DISCLAIMER

Product Data Sheets are periodically updated to reflect new information. It is important to use the latest and most recent revision for the product being used. The foregoing information is accurate to the best of our knowledge. However, due to differences in customer handling, use and method of application which are not known and are beyond our control, Products Techniques, Inc. makes no warranties as to the end result.