

PRODUCT DATA SHEET

A-A-208B/C MARKING INK

PTI ENAMEL SERIES

DESCRIPTION

A-A-208B/C covers four types of opaque stencil ink for marking on porous and non-porous surfaces. The ink covered by this specification is a rubbing and water resistant, medium drying, flat-finish stencil ink for marking metals, glass, stone, cardboard and similar porous and non-porous surfaces. It is can be applied using a stencil brush, spray can, or stencil roller.

- Type I For use on Non-Porous surfaces (Non-Pressurized Containers)
- Type II For use on Porous Surfaces (Non-Pressurized Containers)
- Type III For use on Porous or Non-Porous Surfaces (Pressurized Containers)
- Type IV For use on Porous or Non-Porous Surfaces (Stencil Rollers)

COLORS

This coating can be provided in **any color & gloss range** as designated by the Federal Standard 595C. Custom colors are also available.

COATING PROPERTIES & CHARACTERISTICS

Reducer	PTI-1022X66, PTI-1003 TYIII or Acetone
Primer	PT-522 for non-porous surfaces
Recommended Dry Film Thickness	1 mil
Weight (lbs per gallon)	9 to 10 lbs
Coatings VOC	Below 170 to 271 g/L

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.

MIXING INSTRUCTIONS

Shake component A in a paint shaker for 5 – 10 minutes for optimal results.

Reduce: Use reducer PTI-1022X66, PTI-1003 TYIII or Acetone Thinner.

- **If Brushing/Rolling:** Thin as required for application.

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APPLICATION

This product can be applied by brushing, rolling or aerosol can.

Brushing or Rolling:

1. Best application results: apply 1 full coat from 0.8 – 1 mil thickness.
2. Do not allow more than 48 hours to pass before applying the second coat.
3. Recommended Dry Film Thickness is 1-2 mils. Some colors may require thicker films to achieve hiding.

Aerosol Can

1. Shake the aerosol can, right side up, for a minimum of 60 seconds.
2. Turn the can upside down and shake.
3. After the product is shaken thoroughly you may apply by pressing on the spray nozzle.
4. Repeat shaking after every minute of spraying
5. After every use, turn the can upside down and press the nozzle down until the spray coming out is clear. This means that the nozzle is clear and has a lesser chance of clogging between uses.

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

Dry times are based on the dry film thickness between 1-2 mils (25-50 microns).

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

- Set to touch 2 hours
- Dry hard 8 hours
- Full Cure 72 hours

EQUIPMENT CLEANUP

Use clean PT-1022X66, Acetone or IPA. 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.