

TECHNICAL INFORMATION
LASER MARKING PRODUCT

CerMark™



**RD-6012 Screen Print Metal
 Marking Material**

1.0 Product description

RD-6012 is a laser marking material for metals. It is similar to LMM-6000 but is applied to the substrate by screen printing. It can be used on a variety of bare metal substrates including stainless steel, brass, aluminum, titanium, tin, nickel, and many more. RD-6012 will not work on metals with a lacquered coating.

2.0 Product characteristics

2.1 Physical Properties	
Appearance	Smooth, gray slightly thick ink-like paste.
Volatile Organic Compounds (VOC's)	38.4% (5.53 lbs/gal)
Flash Point	>200°F / 93°C
Drying Rate	Slow
Dried Film Strength	Moderate
2.2 Strength of Product	
Screen printing allows precise control of marking area/size. No overspray as with LMM-6000, minimizes waste. Product can be screen printed on various metals, dried and laser marked at a later time.	
2.3 Recommended Application Parameters	
Application Method	Screen Print
Screen Mesh	160-200
Wet Film Thickness	25 - 35 microns
Thinner	1588 Medium
Printing Viscosity	6000-12000cps @ 25.0 °C
2.4 Curing/Drying of Product	
Drying Method	Air dry or forced drying with heat.
Drying Parameters	Air dry overnight, or force dry with heat (hair dryer) approximately 2 minutes.
2.5 Laser Marking of Product	
Laser Marking Method	Continuous wave CO2 or YAG laser
Recommended Starting Point for Settings	10-20 watts of power, writing speeds of 5 to 20 inches per second

3.0 Product Preparation

Insure that the product has been well mixed prior to use. Some settling may occur during long storage. Paste temperature should be equivalent to your printing room temperature prior to measuring viscosity or application.

4.0 Viscosity Test Method

Cerdec product viscosity is measured by a Brookfield™ RVT DVIII Viscometer using a #27 spindle, 100 rpm at 24.0 °C.

5.0 Storage Recommendations

Product must be stored in cool and dry conditions. The storage temperatures should not be below 5°C and not exceed 35°C. Settling could occur if stored for long periods of time. Before use, products must be stirred thoroughly. Partly used containers must be tightly sealed after use. If stored as recommended, a minimum shelf life of six months after the production date is guaranteed.



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