

H99 Series — Rubber Ink



TECHNICAL DATA SHEET

1. Product Description

H99 is a flexible solvent-based ink specially developed for rubber products requiring excellent flexibility, bending resistance, and durable adhesion.

The ink film maintains strong bonding performance on rubber surfaces after repeated deformation, providing reliable decoration performance for flexible rubber products.

2. Recommended Substrates & Applications

Recommended for rubber products requiring flexibility, bending resistance, and durable adhesion.

Typical applications include rubber bracelets, swimming caps, rubber footwear, protective products, seals, and other flexible rubber components.

3. Key Features

- Excellent flexibility for rubber substrates
- Strong adhesion with excellent peel resistance
- Excellent bending and deformation resistance
- Maintains print integrity after repeated movement and use
- Suitable for screen printing and pad printing

4. Printing Instructions

1. Clean rubber surface before printing to remove dust, oil, and release agents.
2. Stir the ink thoroughly before use. Select S-8 Fast-Drying Thinner, S-6 Medium-Drying Thinner, or S-9 Slow-Drying Thinner according to ambient temperature, printing speed, and image requirements.
3. If fine lines or text show spreading, feathering, or blurred edges, add the recommended slow-drying additive in a controlled amount.
4. Recommended screen mesh: 100-150T. Select the final mesh count based on ink deposit, artwork, and printing conditions.
5. Allow the printed ink film to fully cure before final performance evaluation. Air dry for 24 hours at room temperature, or oven cure at 80°C for 30 minutes.

5. Precautions & Storage

1. Always conduct a production trial before mass printing. Adhesion, drying, appearance, and resistance may vary with substrate grade, surface treatment, additives, and molding conditions.
2. Typical thinner addition is 20–30%. Adjust viscosity according to actual printing conditions and the working environment.
3. Drying time varies with substrate, ink-film thickness, temperature, and ventilation. Confirm the appropriate drying conditions before production.
4. Flammable product. Keep the container tightly closed and store in a cool, well-ventilated area away from heat, sparks, and open flames.
5. Use appropriate personal protective equipment. Avoid skin and eye contact. If the product enters the eyes, rinse immediately with plenty of water and seek medical attention.
6. Shelf life is 12 months from the date of manufacture in unopened original packaging. Re-test suitability before using expired material.

6. Technical Reference Data

Test Item	Result	Test Method / Condition
Ink Fineness	$\leq 12 \mu\text{m}$	Grind gauge
Dry-Film Gloss	$\geq 65 \text{ GU}$	60° gloss meter
Surface Drying	Hot air: 40–60°C (Recommended: 50°C)	Reference drying condition
Full Drying	Air dry for 24 hours, or oven cure at 80°C for 30 minutes	Reference drying condition
Adhesion	100/100 squares retained	1 mm × 1 mm, 100-grid cross-cut; 3M tape peel
Alcohol Resistance	No visible change	Alcohol rubbing test
Flexibility	No cracking or peeling	Repeated bending test
Stretch Resistance	No cracking after deformation	Stretch test
Abrasion Resistance	No ink removal	Manual rubbing test
Water Resistance	No visible change	Tap-water immersion at 20°C for

Note: Performance data is based on internal laboratory tests and may vary depending on substrate and application conditions. Please conduct a trial test before mass production.

7. Compliance Information

Standard colors in this series can be supplied to meet applicable RoHS, REACH, PAHs, and EN 71-3 requirements. Confirm the required regulation, test method, color, and market before ordering; supporting test reports are available for selected products upon request.

8. Important Notice

The information in this document is based on internal reference testing and is provided as technical guidance only. Because substrate grades, printing conditions, film thickness, drying, and end-use requirements vary, users must verify suitability through their own trials before production.