



## DYNACOLOR™ DATA SHEET

### THERMOCHROMIC METAL DECORATING INK

#### DESCRIPTION

**DYNACOLOR™** thermochromic metal decorating inks, in printed form, are a pastel color below a specific temperature, and change to colorless or to another, lighter color as they are heated through a defined temperature range. These inks are available in various colors and activation temperatures. Standard activation temperatures are 15, 31 and 45° C (59, 88 and 113° F). Other activation temperatures are also available, from -5° C to 65° C. The activation temperature is defined as the temperature above which the ink has completely changed to its final clear or light color end point. The color starts to fade at approximately 4° C below the activation temperature and will be in between colors within the activation temperature range. The color change is “reversible,” i.e., the original color will be restored upon cooling. See Color Availability Chart for a complete list of available colors. **DYNACOLOR™** metal decorating ink is ideal for beverage cans and other aluminum substrate items.

#### SPECIAL CARE & USE INSTRUCTIONS

**DYNACOLOR™** ink is very sensitive to all solvents in its wet form. Please ensure that the ink is kept free of all solvents. The press must be dry when ink is added to it. Do not add anything to the ink itself without first consulting CTI. Remove all regular ink from the fountain prior to clean up.

**DYNACOLOR™** has a tendency to flow poorly, and the pigment will hang back in the rollers if the keys are left open and the stripe is too narrow. We recommend having the highest dwell time possible and leaving the keys at relatively low settings.

The most important consideration relative to application of **DYNACOLOR™** on metal cans is that the background color of the can must be white or very light before printing **DYNACOLOR™** on top of it. Otherwise, the color change will be poor because of the transparency of the **DYNACOLOR™** ink and the reflectance of the metal. The undercoat must be opaque and light in color to give a good color shift of the overprinted **DYNACOLOR™** ink.

#### STORAGE AND HANDLING

**DYNACOLOR™** inks have excellent stability when stored away from heat. The material is combustible and should not be used near open flame. Store Below 90° F. Should be used within six months of purchase. Storage longer than twelve months is not recommended. Consult product MSDS prior to use.

#### SENSITIVITY

Thermochromic materials are sensitive to adverse environmental conditions. These are listed below, along with a description of the nature of the sensitivity, and recommendations with regards to them.

**LIGHT:** Most significantly, long exposure to UV and some fluorescent lights can degrade color intensity and changing characteristics of the ink. Extreme exposure of more than several days of direct sunlight may degrade the color of the ink, though it will probably still change colors. More than 600 hours of a strong fluorescent light may also cause a loss of color in the thermochromic. This is true of many differ-

ent pigments and dyes. In handling these materials, a good rule of thumb is to assume that they are about as sensitive to light as fluorescent pigments are.

**HEAT:** Extended exposure to very high temperatures, i.e., 100° F or higher, can also degrade the pigment. The effect of light exposure seems to be additive over time. However, with heat, the exposure only has an effect if a given temperature is constantly maintained for a given amount of time. For instance, if a printed piece is left in a car on a hot day, out of the sun, at a temperature of around 130° F for eight hours, one might see slight degradation of the piece. If the same piece is left in the car on a cooler day, say 100° F for the same amount of time, no degradation would be seen. This could happen for months on end before any degradation was seen, as long as the piece were returned to a cooler temperature for the other sixteen hours of the day. If the piece were left in an environment where it remained at 100° F for many days, one might then expect to see a reduction in color. In other words, the effect is time- and temperature-dependent.

**CHEMICALS:** Thermochromic materials are sensitive to chemical exposure as well. Since it is very unlikely that the printed piece will come into contact with deleterious chemicals under normal conditions, this should not be of great concern. On the other hand, because of the chemical sensitivity and softness of this ink, it also has excellent anti-alteration properties.

**CONCLUSION:** In short, this ink should be stored in a cool, dry place, away from direct exposure to light, especially sunlight. This is true of both the printed ink and the wet ink. Ink in the can should be used within six months of receiving it. If the color or color reaction is compromised in a security environment, one need only to continue to verify the authenticity of the document by other means; ghost watermark, bleed through inks, etc. We predict that with proper handling, the failure rate of the ink will be less than one half of one percent, and as mentioned above, this means that one need only continue to verify authenticity and not redeem the document for cash until confirmation is established.

**NOTE REGARDING HYSTERESIS:** Reversible thermochromics exhibit what is referred to as “hysteresis.” In other words, if a standard “Body Temperature” ink is raised to an extreme temperature, say above 150° F (as with a curing unit), then left to cool under normal ambient conditions (65° to 75° F), the ink may not achieve its full color, even after it reaches room temperature. Although, under normal circumstances the ink should have full color up to 7-8 degrees below the stated activation temperature, once exposed to this kind of temperature “spike,” one may need to lower the ink’s temperature to below 50° F to gain improved behavior. **ALL APPLICATIONS USING COLOR-CHANGING INKS OF ANY KIND SHOULD BE THOROUGHLY TESTED PRIOR TO APPROVAL FOR PRODUCTION.**

For further information or assistance, please contact Chromatic Technologies, Inc. at (888) 294-4CTI.

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