

# Technical Brief

## Silk-Screening Korogard®

Korogard sheet is easily printed on as long as the recommended inks are used.

### Screening

A good copy can be achieved by using the following recommendations provided to us by Advance Process Supply Co., a silk-screening company based in Chicago that has had considerable experience silk-screening the haircell side of ABS.

The best success resulted with an ink mixture consisting of 2.2% T-972 thinner, 10.9% 850 ABS Halftone Base, and 86.9% ABS 540 red ink (or any color) by weight. The screen mesh used was 230 HI-FLYON with the 747 Emulsion Sensitized with the Raysol Diazo Sensitizer. The prints were made with a flood stroke with the screen about 1/4" (6.35mm) above the Korogard. The squeegee used was the Polyplastic type.

Advance Process Supply company is no longer in business. Naztar now supplies their inks. If you need more information, please contact Naztar at (708) 439-8668.

## Mechanically Fastening Korogard®

If solvent bonding is not feasible for your specific application, Korogard thermoplastics can also be mechanically fastened. Some guidelines are listed below.

Where rigid fasteners are used, consideration must be given to the thermal expansion differential between Korogard and any other material to which it will be joined. To allow for this differential, holes oversized by 1/16" (1.59mm) in diameter should be drilled into the Korogard. Failure to allow for thermal expansion differentials may result in objectionable buckling during temperature changes.

Where mechanically fastened Korogard assemblies are to be subjected to high stress, the use of nylon or rubber washers or large-headed fasteners is recommended to prevent the fastener heads from pulling through the Korogard. Also keep in mind that high tension should not be used when riveting Korogard.

Other options for fastening include the use of foam tapes or velcro. For more information on fastening Korogard, contact your local Korogard distributor.

The suggestions and data in this document are based on information we believe to be reliable. They are offered in good faith, but without guarantee, as conditions and methods of use of our products are beyond our control. We recommend that the prospective user determine the suitability of our materials and suggestions before adopting them on a commercial scale.



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