









Enthone M-Series & 50-Series Epoxy Inks

This guide gives supplemental information on ink properties including test information and approximate color references to the Fed-STD-595. We stopped producing custom color matches in 2006 and none of our standard colors are color matched to the Fed-STD-595 color chips. The “Fed-STD-595 Approximate Color Reference” is a visual check of our standard colors against the Fed-STD-595 color chips and a color number selected that appeared to be the closest match. In some cases notes were made on color differences. In the Fed-STD-595 numbering system the first digit indicates the gloss level (1-Gloss, 2-Semigloss, and 3-Lusterless). For the M-Series inks the gloss is between a “1” and “2”, so the best match for the color shade was selected. For the 50-Series inks the majority of inks are “1”, but the 50-120R is a “2”, and the matte inks (50-110RX, 50-710R, and 50-770R) are “3”.

For the “Fed-STD-595 Color Reference from A-A-56032” these are the color numbers that initially came from the MIS-37271 and were referenced in this specification to the corresponding M-Series ink. The MIS-37271 was incorporated into the rev B of the A-A-56032, but the reference to the M-Series colors was removed.

M-Series Permanent Marking Inks

MacDermid Enthone M-Series Thermal Two Part Epoxy Inks - Transfer Marking Ink or Manual Application								
Product	Color Description	Color Chip	Fed-STD-595 Approximate Color Reference	Fed-STD-595 Color Reference from A-A-56032	Mil-I-43553, A-A-56032 Status*	RoHS Compliant	Pb Free Assembly Compatible	Low Halogen ** (representative test values listed for total halogens, not to be used for specifications)
M-2-N	Red		No Test Data	11140	Type I, Type II, & Type III	No	Yes	N
M-3-N	Orange		Test Data 1473	x	Type I, Type II, & Type III	No	Yes	No
M-4-N	Yellow		es 13655 No Test Data	13655	Type I, Type II, & Type III	No	Y	
M-5-N	Green		Test Data 24190	x	Type I, Type II, & Type III	No	Yes	No
M-6-N	Blue		s 15180 No Test Data	15102	Type I, Type II, & Type III	Yes	Ye	
M-9-N	White		es 17925 No Test Data	17875	Type I, Type II, & Type III	Yes	Y	
M-0-N	Black		Data 17038	17038	Type I & Type III	Yes	Yes	No Test
M-0-NC	Inorganic Black		17038 M-0-NC has a Blue Tint	X	Type I, Type II, & Type III	Yes	Yes	No Test
* Inks cured with Catalyst 20/A at room temperature will not meet Type II requirements (heat cure OK). For air cure Type II use Catalyst 77 or B-13/28.								
** Low Halogen ("Halogen Free") Listed by the IEC as < 900 ppm Cl-, < 900 ppm Br-, and < 1500 ppm total halogens.								

50-Series CAT-L-INK

MacDermid Enthone 50-Series Thermal Two Part Epoxy Inks - Screen Print, Spray, or Manual Application

Product	Color Description	Color Chip	Fed-STD-595 Approximate Color Reference	Fed-STD-595 Color Reference from A-A-56032	Mil-I-43553, A-A-56032 Status*	RoHS Compliant	Pb Free Assembly Compatible	Low Halogen ** <small>(representive test values listed for total halogens, not to be used for specifications)</small>
50-100R	White		17925	Non-applicable (N/A)	Type I, Type II, & Type III	Yes	Yes	Yes (419 ppm)
50-110RX	White, Matte		37925	N/A	Type I, Type II, & Type III	Yes	Yes	Yes (541 ppm)
50-120R	White, High Hide		27925	N/A	Type I, Type II, & Type III	Yes	Yes	Yes - No Test Data
50-201AR	Lemon Yellow, Cd		x	N/A	Type I, Type II, & Type III	No	Yes	Yes (310 ppm)
50-202BR	Medium Yellow, Pb Chromate		13655	N/A	Type I, Type II, & Type III	No	Yes	Yes (406 ppm)
50-206R	Orange, Pb Chromate		12197	N/A	Type I, Type II, & Type III	No	Yes	Yes (403 ppm)
50-300R	Emerald Green, Pb Chromate		14193 50-300R Slightly More Yellow	N/A	Type I, Type II, & Type III	No	Yes	No - No Test Data
50-301R	Deep Green, Pb Chromate		14036	N/A	Type I, Type II, & Type III	No	Yes	No (1.64%)
50-400R	Ultramarine Blue		15056	N/A	Type I, Type II, & Type III	Yes	Yes	Yes (633 ppm)
50-403R	Light Blue		15180	N/A	Type I, Type II, & Type III	Yes	Yes	No Test Data
50-506BR	Deep Red Pb Chromate		11086 50-506BR Slightly More Violet	N/A	Type I, Type II, & Type III	No	Yes	No Test Data
50-507R	Medium Red, Cd		11105	N/A	Type I, Type II, & Type III	No	Yes	Yes (608 ppm)
50-508R	Medium Red, Pb Chromate		11105	N/A	Type I, Type II, & Type III	No	Yes	Yes (473 ppm)
50-600R	Chocolate Brown, Pb Chromate		#10049 50-600R Less Red Shade	N/A	Type I, Type II, & Type III	No	Yes	No Test Data
50-700R	Black, Carbon Pigment (low electrical resistance)		17038	N/A	Type I & Type III	Yes	Yes	Yes (534 ppm)
50-710R	Black, Matte Carbon Pigment (low electrical resistance)		37038	N/A	Type I & Type III	Yes	Yes	No Test Data
50-770R	Black, Matte (High electrical resistance)		37038	N/A	Type I, Type II, & Type III	Yes	Yes	No Test Data
50-771R	Black, Gloss (High electrical resistance)		17038	N/A	Type I, Type II, & Type III	Yes	Yes	Yes (467 ppm)
50-800R	Clear		N/A	N/A	Type I, Type II, & Type III	Yes	Yes	Yes - No Test Data
50-810R	Clear, Matte		N/A	N/A	Type I, Type II, & Type III	Yes	Yes	Yes - No Test Data

* Inks cured with Catalyst 20/A at room temperature will not meet Type II requirements (heat cure OK).

For air cure Type II use Catalyst 77 or B-13/28.

** Low Halogen ("Halogen Free") Listed by the IEC as < 900 ppm Cl-, < 900 ppm Br-, and < 1500 ppm total halogens.

Tested using the combustion method - total halogens.

Ink Catalysts

MacDermid Enthone 50-Series & M-Series Catalysts								
Product	Color Description	Color Chip	Fed-STD-595 Approximate Color Reference	Fed-STD-595 Color Reference from A-A-56032	Mil-I-43553, A-A-56032 Status*	RoHS Compliant	Pb Free Assembly Compatible	Low Halogen ** <small>(representative test values listed for total halogens, not to be used for specifications)</small>
Catalyst 20/A	N/A	N/A	N/A	N/A	Type I & Type III (air cure), add Type II for heat cure	Yes	Yes	No Test Data
Catalyst B-3	N/A	N/A	N/A	N/A	Type I, Type II, & Type III	Yes	Yes	No Test Data
Catalyst 5	N/A	N/A s	N/A es	Yes (150 ppm)	Type I, Type II, & Type III	Ye		
Catalyst 9	N/A	N/A s	N/A es	Yes (150 ppm)	Type I, Type II, & Type III	Ye		
Catalyst B-13/28	N/A	N/A III	Yes N/A	Yes N/A Yes (<50 ppm)	Type II, & Type			
Catalyst 45	N/A	N/A es	N/A es	No Test Data	Type I, Type II, & Type III	Y		
Catalyst 77	N/A	N/A es	N/A es	Yes (225 ppm)	Type I, Type II, & Type III	Y		
* Inks cured with Catalyst 20/A at room temperature will not meet Type II requirements (heat cure OK). For air cure Type II use Catalyst 77 or B-13/28.								
** Low Halogen ("Halogen Free") Listed by the IEC as < 900 ppm Cl-, < 900 ppm Br-, and < 1500 ppm total halogens.								