



DieMark® Disposable Ink Cartridge Information

Xandex offers variety of inks for all applications. Please consult the following for general information on Xandex inks to help you choose the optimal ink for your application.

Pneumatic Ink Cartridges (DM-2 & DM-2.3)



The heart of all pneumatic inking systems is the DieMark DM-2 disposable ink cartridge. The DM-2 is pre-filled and factory tuned to eliminate labor intensive inker related delays in the test area: ink mixing, refilling, adjustments, cleaning and rework. DM-2 contains 60% more ink than standard DieMark cartridges ensuring consistent dots and long life at any speed.

The DM-2 has a polypropylene ink reservoir, which is sealed by a threaded cap at the top and a thin

membrane at the bottom. The monofilament used in Electric Ink Cartridges has been replaced by a small Teflon tube encased in a stainless steel needle. When the cartridge is opened, the needle punctures the reservoir to provide ink flow.

Pneumatic Cartridge Models

DM-2 Pneumatic, 0.50" needle, Teflon tube (no filament)

DM-2.3 Pneumatic, 0.30" needle, Teflon tube (no filament)

Ink Types

Xandex 8103

Ink Type: Phenoxy with dye coloring agent

Colors: Black, Red

Characteristics: Premium ink with sodium and chloride levels certified less than 10 PPM. Opaque and highly resistant to most post-probe processes. Air dry or heat set. Acetone soluble prior to drying. Difficult to remove after cure. Flows consistently after opening for 2-3 days in DM-2s and 2 days for DM-1s. Very high in viscosity yet dries rapidly at ambient temperatures. Produces small dots. Ideal for continuous, offline inking.

Shelf Life: Four months

Configurations: **DM-1:** 5, 8, 10, 15, 20, 25, 28 and 30 mil
DM-2 & DM-2.3: A5, A6, A8

Electric Ink Cartridges (DM-1, DM-1.25 & DM-S)

Electric inkers utilize DieMark cartridges for the ultimate inking solution. DieMark cartridges offer reliable, consistent, trouble free operation with the benefit of a disposable unit. Pre-filled factory tuned cartridges are easy to use - no adjusting, refilling or cleaning. All inks utilized in the cartridges have been selected to produce consistent dots over a wide range of speeds without dripping, or skipping. Three needle configurations are available to afford optimal visual/physical inker clearance.



Electric Cartridge Models

DM-1 Nylon monofilament (5 mil also with tungsten wire), 0.75" straight needle

DM-1.25 Nylon monofilament, 1.25" straight needle

DM-S Curved needle, nylon monofilament





Xandex 8104

Ink Type: Phenoxy with dye coloring agent

Colors: Black

Characteristics: Premium ink with sodium and chloride levels certified less than 20 PPM. Opaque and highly resistant to most post-probe processes. Air dry or heat set. Acetone soluble prior to drying. Difficult to remove after cure. Flows consistently for 2-3 days after opening. Very low in viscosity yet dries rapidly at ambient temperatures. Produces large dots.

Shelf Life: Four months

Configurations: **DM-2 & DM-2.3:** A5, A6, A8

Xandex 7824 and 7824T

Ink Type: Phenoxy with dye coloring agent

Colors: Black

Characteristics: Premium ink with sodium and chloride levels certified less than 10 PPM. Very opaque and permanent. Air dry or heat set. Acetone soluble prior to drying. Difficult to remove after cure. Flows consistently for 2-3 days after opening. Use 7824T when a very thick viscosity is desired.

Shelf Life: Four months

Configurations: **DM-1:** 5, 8, 10, 15, 20, 25, 28, 30 mil; **DM-1.25:** 15, 25 mil
DM-2 & DM-2.3: A5, A6, A8

Markem® 6990

Ink Type: Phenoxy with dye coloring agent

Colors: Black

Characteristics: Premium ink - sodium and chloride levels certified less than 25 PPM. Requires heat curing. Alcohol/acetone soluble prior to cure. Flows very consistently for up to five days after opening.

Shelf Life: Four months

Configurations: **DM-1:** 5, 8, 10, 15, 20, 25, 28 and 30 mil; **DM-1.25:** 10, 15, 20, 25 mil; **DM-S:** 10, 15 mil
DM-2 & DM-2.3: A5, A6, A8

Markem® 6993

Ink Type: Phenoxy with dye coloring agent

Colors: Black, Red, Green

Characteristics: Most widely used die sorting ink. Requires heat curing. Alcohol/acetone soluble prior to cure. Flows very consistently for up to five days after opening. Green may be too transparent for some automatic die picking equipment. Contaminant levels not certified by Markem or Xandex. Periodic test data indicates less than 100 ppm Sodium and 300 ppm Chloride.

Shelf Life: Four months

Configurations: **DM-1:** 5, 8, 10, 15, 20, 25 mil, (28 & 30 mil-black and red only); **DM-1.25:** 10, 15, 20, 25 mil; **DM-S:** 10, 15 mil
DM-2 & DM-2.3: A5, A6, A8

Markem® 6997

Ink Type: Phenoxy with dye coloring agent

Colors: Black, Red

Characteristics: Requires heat curing. Alcohol/acetone soluble prior to cure. Flows very consistently for up to five days after opening. Red may be too transparent for some automatic die picking equipment. Contaminant levels not certified by Markem or Xandex. Periodic test data indicates less than 100 ppm Sodium and 300 ppm Chloride.

Shelf Life: Four months

Configurations: **DM-1:** 5, 8, 10, 15, 20, 25, 28 & 30 mil; **DM-1.25:** 10, 15, 20, 25 mil; **DM-S:** 10, 15 mil
DM-2 & DM-2.3: A5, A6, A8

