



# TRUBOND 396

## INKJET GLUE

### Chemical basis

Preparation of polymers in solvents

### Characteristics

Density (20 °C)	approx. 0.93 g/cm <sup>3</sup>
Viscosity (25 °C)	approx. 25 mPa·s
Viscosity (45 °C)	approx. 14 mPa·s

### Shelf-life / Packaging

12 months under proper storage conditions | Containers of 4 kg

### Application

TRUBOND 396 is a particular inkjet glue with strong cohesive power for the tile decoration. It is a transparent solution without solids in suspension and contains particular polymers with cohesive power to bind fine powders or fine grits on the tiles, allowing the decoration of all possible designs and effects desired by digital printing technology. Usually, TRUBOND 396 is integrated in the production line as follows:

1. Engage/glaze application;
2. If required apply primers (for example DIGICER PRIMER 007 or DIGICER PRIMER 008);
3. Inkjet color decoration + adding TRUBOND 396 in the last or last two bars;
4. Immediately after the digital printing machine (1-2 m distance), application of fine grits or fine powder with traditional machine for grits application;
5. Suction or blowing to eliminate the excess of materials.

The inkjet glue applied with inkjet heads can be rapidly absorbed by the tile's support, depending on the production conditions; to achieve the cohesive effect of the powder or grits, we recommend increasing the open time of the inkjet glue to arrive wet under the grits or powder application. To increase the open time as necessary we recommend as follows:

1. Use inkjet heads with high discharge of ink;
2. If possible, use two bars of application (two applications overlapping);
3. Use possibly the 100 % of covering (bitmap) always in binary way;
4. Use the primers of the DIGICER PRIMER series (additives for surface treatment) to increase the open time;
5. Adjust the distance to the powder application unit to optimize the cohesive performance.

