

# Huizhou Yirun Silicone Co.,Ltd. /Ganzhou Xinguang Silicone Co.,Ltd.

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**XG silicone ink Dipping silicone ink for ropes. Tipping silicone ink for webbing.**

**How to tip cord by silicone coating?**

**Silicone cord dipping process:**

## **1<sup>st</sup> Dipping silicone Clear 1 layer**

Dipping silicone XG-20S-1 100G  
Silicone fast dry catalyst XG-KB-1 10G 10% (10G silicone to mix with 1G catalyst)  
Silicone thinner XG-128AH 1200G 120-% (10G silicone to mix with 12G thinner)  
To dip one time and wait about 30-40 minutes to get ink layer surface dry by room temp,after ink layer surface dry to heat cut. Surface drying time depends on catalyst type and the weather. If hot and dry weather ink can dry faster.

**If need hard hand feel then to dip hard hand feel dipping silicone XG-60S layer 1 time to instead of XG-20S-1.**

Dipping silicone (hard hand feel) XG-60S 100G  
Silicone mid dry catalyst XG-60SZB 10G 10% (10G silicone to mix with 1G catalyst)  
Silicone thinner XG-128AH 120G 120% (10G silicone to mix with 12G thinner)

## **2<sup>nd</sup> Color dipping silicone to dip 2 layers**

Dipping silicone XG-20S-1 100G  
Silicone color pigment 3-5G 2-4% (10G silicone to mix with 0.2-0.4G color pigment)  
Silicone fast dry catalyst XG-KB-1 10G 10% (10G silicone to mix with 1G catalyst)  
Silicone thinner XG-128AH 120-150G 120-150% (10G silicone to mix with 12-15G silicone thinner)

**To dip 2 layers color dipping silicone ,If fast dry catalyst get ink dry too fast and waste too many materials then can chose fast dry catalyst and slow dry catalyst 50% and 50% to get ink mid dry,If weather too hot that mid dry is also dry too fast then can chose slow dry catalyst XG-MB-1.**

**For the second time color silicone ink dipping ,to shack and remove the excess dipping ink if needed.**

## **3<sup>rd</sup> Dipping glossy or matte silicone for top coating dipping**

**A.Glossy silicone dip one layer ( supper glossy effect need,normal glossy no need )**

Glossy silicone XG-399-2 100G  
Silicone fast dry catalyst XG-KB-1 10G 10% (10G silicone to mix with 1G catalyst)  
Silicone thinner XG-128AH 100G 100% (10G silicone to mix with 10G silicone thinner)

**B1st.Matte silicone to dip one layer**

Matte silicone XG-136M-1 100G  
Silicone fast dry catalyst XG-KB-1 10G 10% (10G silicone to mix with 1G catalyst)  
Silicone thinner XG-128AH 200G-250G 200-250% (10G silicone to mix with 20-25G thinner)

If matte effect turn white,then to mix with 10-20% Dipping silicone XG-20S-1 can solve the problem.

After finished to wait for at least 1-2 days to get silicone ink 100% dry .

**B2nd.Soft smooth matte silicone to dip one layer**

Soft smooth matte            XG-866M-6      100G

Silicone fast dry catalyst    XG-866B-2      5G    4%    (10G silicone to mix with 0.4G catalyst)

Silicone thinner              XG-128AH      200G-300G    200-300%    (10G silicone to mix with 20-30G silicone thinner)

If need fast dry to mix with 1% more catalyst.

**New matte dipping silicone after finished dipping better to cure by 80 degree for 30 minutes to get good fastness and easy cured. If without oven heating then have to wait for at least 1-2 days to make sure silicone ink 100% dry.**