



# TECHNICAL DATA SHEET

**TECHNICAL DATA SHEET  
AMS 3145  
EPOXY MARKING INK**

**PRODUCT:** A two-component, catalyzed epoxy marking ink coating for metallic or other non-porous surfaces and printed wiring boards. AMS 3145 is low VOC and lead and chromate free.

**PROPERTIES:**

SOLIDS (Weight)..... 59% Minimum  
MAX VOC ADMIXED..... 420 grams/liter (3.5 Lbs/Gal)  
COLORS..... Clear & All Fed.Std 595 Colors

**DRYING TIME:**

SET TO TOUCH..... Within 1-2 Hours  
CURE TO HANDLE..... Bake 60 minutes @ 200 Degrees F  
THINNER..... MIL-T-81772B TY.II  
SHELF LIFE..... 1 Year

**MIXING/APPLICATION INSTRUCTIONS:** Each of the two components should be thoroughly mixed separately. Component B is then slowly poured into component A, with constant stirring. The mixing ratio is one to one of each component by volume. Mix thoroughly and allow to induct for one hour before using. Coating is normally ready to use as packaged. If needed, reduce admixed material up to one pint per gallon with MIL-T-81772B Ty.II Thinner. Apply a mist coat and allow to dry to touch (30 Minutes). Apply a second coat to a total dry mil thickness of 1.5 to 1.8 mils. For brushing, us as is after induction time. If higher viscosity is needed, allow a longer induction time, as coating will become thicker with more dwell time.

**SURFACE PREPARTAIION:** Surface must be completely clean, structurally sound, and free of all contaminants (including dirt, wax, loose paint, grease, etc.). Greasy or oily surfaces must be cleaned with solvent with care. Do not paint over moist / wet surfaces.

**PRECAUTIONS:**

KEEP OUT OF REACH OF CHILDREN.  
USE WITH ADEQUATE VENTILATION.  
AVOID CONTACT WITH SKIN AND EYES.  
READ MATERIAL SAFETY DATA SHEET BEFORE USING.  
CONTENTS ARE FLAMMABLE.