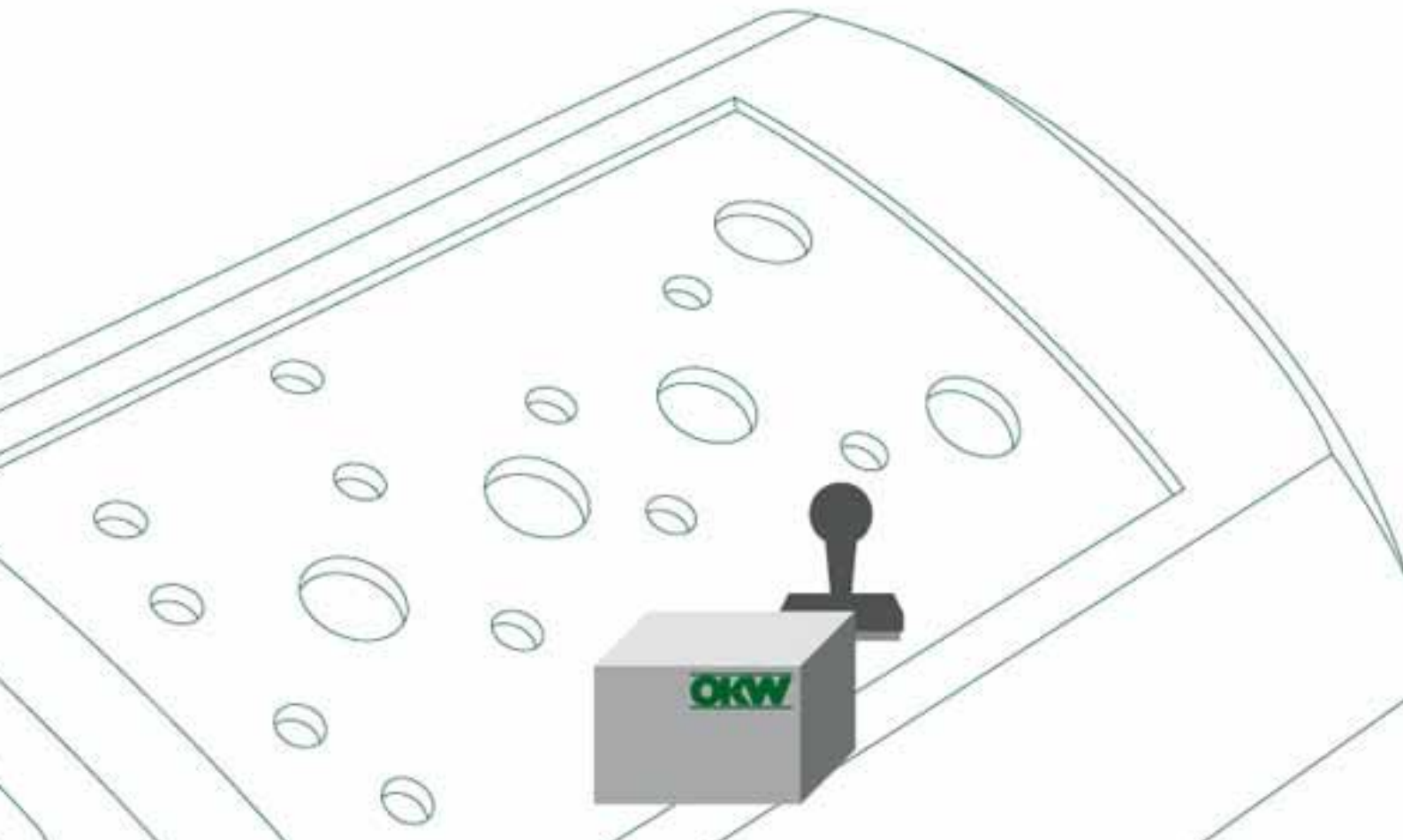




SILK-SCREEN / TAMPO PRINTING



SERVICES

Depending on the printing format and type of case, we can offer you silk-screen printing and/or tampo printing. Colour definition according to sample, range of dyes, RAL, Pantone or NCS.

Incomplete information makes the working process complicated and time-consuming. We should therefore like to inform you in the following of the specifications required to ensure smooth implementation, from the formulation of the requirements through the inquiry to the order. Please, follow also the technical references, general tolerance etc.

DESIGN EXAMPLES



GENERAL INFORMATION

- Part-No. Of the standard enclosure of tuning knob
- Repeat order with/without modification
- Quantity
The number of pieces delivered may vary by +10% from the order quantity.
For order quantities that are not to be undershot, please give us specific notification.
- Intended price
- Required delivery period
- Part-No. and designation of the additional parts
If orders are placed, additional parts are given an OKW Part-No. The delivery of these parts must be announced on time with information of our Part-No.
Please note this on the delivery note for shipment. No quality tests are carried out on additional products by the incoming merchandise department.

Scheduled delays of complete shipments due to late supply have to be borne by the customer.

LABELLING / PRINTING

- according to the drawing no., status, date (if required date of receipt)
- according to sample
- according to last delivery with/without modification
- according to sketch

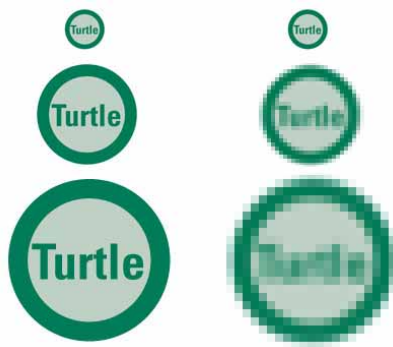
Please give the following information:

on the labelling (colour, size, full font information)

on the part (upper or lower part, tongue or groove part etc.)

on the side (which side is to be modified?)

- Layout Print file must be a vector graphics (no raster graphics!) in Corel-Draw or EPS format.
Scale 1:1, minimum resolution 300 dpi.,
all contents must be editable!



vektor graphics

raster graphics

Vector graphics can be scaled without any loss of quality.

Otherwise there will be charges according to the complexity creating a print file. As a model for creating a print file we need a drawing/sketch that contains all machining relevant dimensions. If it is not possible to provide logos, symbols (as an image file, e.g. .jpg with min. resolution 300 dpi) or possible special fonts, slight non-conformances are possible.

Data medium: E-Mail, CD-Rom, DVD, Zip (100 MB)

TECHNICAL REFERENCES TO SILK-SCREEN PRINTING

- max. printing area 400 x 600 mm
(for recessed areas the distance from the edge must be at least 10 mm, max. depth = 1 mm)
- colour definition according to sample, range of dyes, RAL, Pantone or NCS;
colour deviation Delta E = 2.5 possible
- Egeneration of a smooth-sided film with a 1:1 scale
 - * positive, non-inverted (coated side uppermost)
 - * film exposure in 40 l/cm screen (in grey-scale mode, images)
 - * 3.0 log. Density

* min. line weight = 0.25 mm (0.71 pt), since otherwise the correct printing of cases with structured finishes is not possible; the font size must be at least 2.5 mm;
 minimum distance between lines that are not to be printed against each other = 0.25 mm (0.71 pt)

- for durability of printing inks see below

TECHNICAL REFERENCES TO TAMPO PRINTING

- max. printing area 100 x 100 mm
 (for recessed areas the distance from the edge must be at least 5 mm, max. depth = 2 mm)
- colour definition according to sample, range of dyes, RAL , Pantone or NCS;
 colour deviation Delta E = 2.5 possible
- generation of a smooth-sided film with a 1:1 scale
 - * positive, mirror-inverted (coated side below)
 - * film exposure in 20 l/cm screen (in grey-scale mode, images)
 - * 3.5 log. Density
 - * film size 150 x 150 mm (printed image centred)
 - * min. line weight = 0.25 mm (0.71 pt)
 - * minimum distance between lines that are not to be printed against each other = 0.25 mm (0.71 pt), since otherwise the correct printing of cases with structured finishes is not possible; the font size must be at least 2.5 mm
- for durability of printing inks see below

GENERAL TOLLERANCES WITHIN THE PRINT FORMAT

According to ISO 2768m T1.

Linear measure

Nominal dim.	0,5 – 6 mm	6 – 30 mm	30 – 120 mm	120 – 400 mm	400 – 1000 mm
Tolerance	± 0.1 mm	± 0.2 mm	± 0.3 mm	± 0.5 mm	± 0.8 mm

Angular measure

Nominal dim.	bis 10 mm	10 – 50 mm	50 – 120 mm	120 – 400 mm	> 400 mm
Tolerance	± 1°	± 0.5°	± 0.33°	± 0.16°	± 0.08°

Radii

Nominal dim.	0,5 – 3 mm	3 – 6 mm	6 – 30 mm	30 – 120 mm	120 – 400 mm
Tolerance	± 0.2 mm	± 0.5 mm	± 1 mm	± 2 mm	± 4 mm

RESISTANCE OF PRINTING INKS

	Printing inks*	
	1-component for enclosures	2-components for front panels and Duroplasts
Acetone	-	-
Petrol (cleaning petrol)	-	-
Petrol "Super"		
Diesel oil		
Grease		
Hand cream	+	+
Sea water		



Hydrochloric acid 10%		
Weak alkalis		
Strong alkalis		
Lactic acid		
Glass cleaner	+ ("Siddin")	+ ("Siddin")
Ethanol	-	-
Resistance to weathering	+	+

+ = resistant, o = conditionally resistant, - = not resistant, unmarked = not tested

Material resistance may change through the simultaneous action of different media!

* The resistance of printing inks depends on various factors:

Substrate (consistency and type) – dry layer thickness – test regulations

The analysis of the tests is based on the following given facts:

- Substrate: white PVC (Serilux 2000)
- Print: 120T fabric
- 2-component processing with ZH/N-00 hardening agent (8:1)
- Thinning 10%
- Tests with acetone, petrol, glass cleaner and ethanol were carried out using a soaked swab of cotton wool with wiping movements, applying slight pressure.

FIXED COSTS

According quotation.

FORM OF DELIVERY

Same as standard (in PE-bags, in layers in the cartons).
Special agreements possible.

Quantity differencies + 10 % possible.

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