



Product/Process Change Notification

PCN Number:	100025-B	Product Category:	Ink	Issue Date:	1-Jun-2018
Contact:	Inside Sales		E-Mail: insidesales@xandex.com		
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Description of Change to Customer:					
All Markem-Imaje 699X types of ink are reformulated by replacing phenolic resin.					
Reason For Change:					
Bisphenol A greater than 0.1% was discovered in the ink material testing; the phenolic resin was determined to be the source and is being replaced with a different phenolic resin. In addition, the resin manufacturer has discontinued production of the current resin.					
Customer Impact of Change and Recommended Action:					
The existing "Soft Cure Guidelines" (100-150°C @ 5-15 minutes) resulted in a hard cure in our testing; a soft cure can be obtained by baking the wafer(s) at 70-100°C for 5-30 minutes. If you use soft curing, you may have to modify your parameters. We recommend that our customers verify the revised ink meets all current quality criteria for your use model.					
Forecasted Key Milestones: Subject to change based on business conditions					Date:
Complete Internal Qualification Testing					Complete
Samples Available To Order					11-Jun-18
First Shipment of Changed Product (as early as)					1-Jan-19
Last Shipment of Unchanged Product (subject to material availability)					31-Dec-18
Method of Identifying Changed Product:					
Batch number and ship date.					
Assessment:					
Function (due to change in soft cure parameters) and form.					
Products and Xandex Part Numbers Affected					
All ink cartridges with 6990 Black Ink, 6993 Black Ink, 6993 Red Ink, or 6997 Black Ink (See Appendix for specific part numbers)					
Revision History					
Date of Revision:	Revision Letter:	Reason:			
31-May-18	A	Initial publication			
22-Jun-18	B	Markem agreed to Xandex request to delay change, qualification testing completed. Changes = Bold			

Please contact your Xandex sales representative for any questions or support requirements. Please return any response as soon as possible, but not to exceed 30 days.

PCN 100025 Appendix: Qualification Testing

Test	Result
Color Strength Test	Pass
Fineness of Grind Test	Pass
Viscosity	Pass
Dot Size/Consistency Test	Pass
Ink Cure Time Test	Pass
Ink Adhesion Test	Pass
Backflow Test	Pass
Dot Count Test	Pass
Solvent Resistance Test (*change to soft cure parameters)	Pass*
Ionic Contamination Test (6990 Only)	Pass



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Appendix: Cartridges affected by PCN 100025

Cartridges that use 6990 Black Ink

Part Number	Description
302-1121	6990BLK 05ML DM1 FILAMENT
302-2121	6990BLK 05ML DM1 TUNGSTEN
302-2221	6990BLK 08ML DM1
302-2321	6990BLK 10ML DM1
302-2421	6990BLK 15ML DM1
302-2621	6990BLK 25ML DM1
302-2628	CSP 6990BLK 18/25ML DM1
302-2821	6990BLK 30ML DM1
302-3321	6990BLK 10ML DM1.25
302-3421	6990BLK 15ML DM1.25
302-3621	6990BLK 25ML DM1.25
302-4321	6990BLK 10ML DMS
302-4421	6990BLK 15ML DMS
303-1521	6990BLK A5 DM2
303-1621	6990BLK A6 DM2
303-1821	6990BLK A8 DM2
304-1521	6990BLK A5 DM2.3
304-1621	6990BLK A6 DM2.3
304-1821	6990BLK A8 DM2.3

Cartridges that use 6993 Red Ink

Part Number	Description
302-0102	CSP6993RED 5ML FIL120-125
302-1102	6993RED 05ML DM1 FILAMENT
302-2102	6993RED 05ML DM1 TUNGSTEN
302-2202	6993RED 08ML DM1
302-2302	6993RED 10ML DM1
302-2402	6993RED 15ML DM1
302-2602	6993RED 25ML DM1
302-2802	6993RED 30ML DM1
302-3302	6993RED 10ML DM1.25
302-3402	6993RED 15ML DM1.25
302-3602	6993RED 25ML DM1.25
302-4302	6993RED 10ML DMS
302-4402	6993RED 15ML DMS
303-1502	6993RED A5 DM2
303-1602	6993RED A6 DM2
303-1802	6993RED A8 DM2
304-1502	6993RED A5 DM2.3

Cartridges that use 6993 Black Ink

Part Number	Description
302-0101	CSP6993BLK 5ML FIL120-125 DM1
302-1101	6993BLK 05ML DM1 FILAMENT
302-1401	DISC CSP 6993BLK 15ML DM1 C.170/.175
302-2101	6993BLK 05ML DM1 TUNGSTEN
302-2201	6993BLK 08ML DM1
302-2301	6993BLK 10ML DM1
302-2401	6993BLK 15ML DM1
302-2601	6993BLK 25ML DM1
302-2608	CSP 6993BLK 18/25ML DM1
302-2801	6993BLK 30ML DM1
302-3301	6993BLK 10ML DM1.25
302-3401	6993BLK 15ML DM1.25
302-3601	6993BLK 25ML DM1.25
302-4301	6993BLK 10ML DMS
302-4401	6993BLK 15ML DMS
302-7101	CSP 93BLK 5ML FIL.091-.094 DM1
303-1501	6993BLK A5 DM2
303-1601	6993BLK A6 DM2
303-1801	6993BLK A8 DM2
304-1501	6993BLK A5 DM2.3
304-1601	6993BLK A6 DM2.3
304-1801	6993BLK A8 DM2.3

Cartridges that use 6997 Black Ink

Part Number	Description
302-1111	6997BLK 05ML DM1 FILAMENT
302-2111	6997BLK 05ML DM1 TUNGSTEN
302-2211	6997BLK 08ML DM1
302-2311	6997BLK 10ML DM1
302-2411	6997BLK 15ML DM1
302-2611	6997BLK 25ML DM1
302-2618	CSP 6997BLK 18/25ML DM1
302-2811	6997BLK 30ML DM1
302-3311	6997BLK 10ML DM1.25
302-3411	6997BLK 15ML DM1.25
302-3611	6997BLK 25ML DM1.25
302-4311	6997BLK 10ML DMS
302-4411	6997BLK 15ML DMS
303-1511	6997BLK A5 DM2
303-1611	6997BLK A6 DM2
303-1811	6997BLK A8 DM2
304-1511	6997BLK A5 DM2.3
304-1611	6997BLK A6 DM2.3
304-1811	6997BLK A8 DM2.3