



Product/Process Change Notification

PCN Number:	100022-A	Product Category:	7824 Ink	Issue Date:	23-May-2017			
Contact:	Inside Sales	E-Mail: insidesales@xandex.com						
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Description of Change to Customer:								
Viscosity of Ink specification changed from 650 to 720 cPs to 690 to 830 cPs. This change was implemented by deviation on 27-Feb-2017. (see attached)								
Reason For Change:								
To maintain dot size consistency with currently available raw materials, an increase in viscosity is required.								
Customer Impact of Change and Recommended Action:								
Verify performance meets current ink dot inspection requirements.								
Forecasted Key Milestones: Subject to change based on business conditions					Date:			
Complete Internal Qualification Testing					Complete			
Samples Available To Order					Now			
First Shipment of Changed Product (as early as)					Immediately			
Last Shipment of Unchanged Product (subject to material availability)					No longer available			
Method of Identifying Changed Product:								
Batch number and ship date.								
Assessment:								
Function: We expect a slight increase (~1 mil) in dot size diameter.								
Products and Xandex Part Numbers Affected								
201-1546	302-1151	302-2151	302-2251	302-2351	302-2451	302-2651	302-2658	302-2851
302-3371	302-3451	302-3651	302-4351	302-4451	303-1551	303-1651	303-1851	304-1551
304-1651	304-1851							
Revision History								
Date of Revision:	Revision Letter:	Reason:						
18-May-17	A	Initial release						

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 100022-A Appendix: Qualification Testing

Test	Result
Color Strength Test	Pass
Fineness of Grind Test	Pass
Viscosity (to revised specification)	Pass
Dot Structure Evaluation	Pass
Dot Consistency Test (to revised specification)	Pass
Ink Dry Time Test	Pass
Ink Adhesion Test	Pass
Ionic Contamination Test	Pass
Viscosity Stability Test	Pass
Dot Size Stability Test	Pass



February 27, 2017

To: DieMark 7824 Ink Customers

Subject: Notice of Deviation

Scope: DieMark 7824 Ink Cartridge Shipments beginning Wednesday March 1, 2017

Xandex 7824 ink goes through rigorous qualification for dot performance (size, drying time, adhesion) prior release to production. The current raw materials produce 7824 ink in which the viscosity are outside our specified range, which was determined using historical data. However, the dot performance meets our expectation for this ink formula and we expect this ink to perform satisfactorily for the requirements of your application.

Please contact your customer service representative if you have any questions regarding this deviation.

Bill Eastin

A handwritten signature in black ink that reads "Bill Eastin". The signature is written in a cursive, slightly slanted style.

Chemist
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