ACMI #2000 STENCIL INK

Product information + step-by-step illustrated application guide

MILITARY / FEDERAL SPECIFICATION — MANUFACTURER-REPORTED

CID A-A-208B, Types I and IV (formerly **TT-I-1795A**). The supplied source guide reports that ACMI states #2000 meets these specifications. This is not independent qualification evidence or a lot-specific Certificate of Conformance. Confirm documentation required for your application.

What is ACMI #2000 Stencil Ink?

According to ACMI, #2000 is a solvent-based, pigmented marking ink formulated for both porous and nonporous substrates. ACMI reports resistance to petroleum solvents and trichloroethylene and identifies some oily automotive parts as a possible application. Test suitability on actual parts.

READ FIRST — APPLICATION DISCLAIMER

This distributor-style guide is **not** a manufacturer-issued TDS or validated operating procedure. ACMI identifies the application categories, but the detailed steps below are **suggested trial procedures**, not manufacturer-certified instructions. No adhesion, dry time, durability, chemical resistance or suitability is guaranteed. Test and qualify before production.

Before using the ink

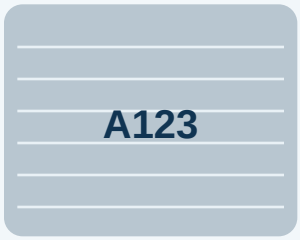
1. Read the current SDS and your site safety procedures. The source guide reports a **46°F (7.8°C) flash point**; control ignition sources and provide suitable ventilation.
2. Select a representative part and check for dirt, oil, release agents, coatings and moisture.
3. Prepare compatible equipment. Check ink uniformity; do not assume a thinner ratio or cleaning solvent.

SURFACES ACMI #2000 CAN MARK

Visual examples of materials identified in the supplied product information

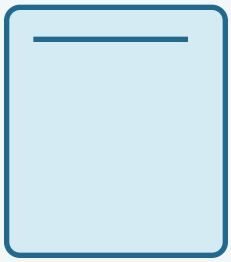
Porous and nonporous surface examples

Illustrations are representative; actual adhesion and marking performance must be tested.



METAL

Metal components



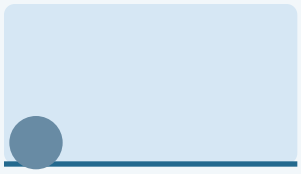
GLASS

Glass surfaces



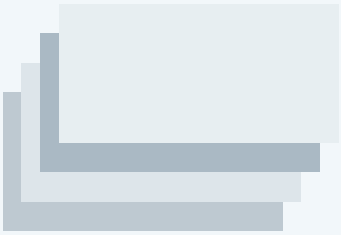
PLASTICS

Plastic parts



FILM

Thin film materials



FOIL

Foil substrates



POROUS SURFACES

Representative porous material

SOME OILY AUTOMOTIVE PARTS

The product information identifies some oily automotive parts as a potential use.
This does not mean the ink works on every oil or every contaminated surface.
Trial-mark representative parts and check legibility, drying and adhesion.

Manufacturer-stated materials:
glass, plastics, metals, film, foil, porous surfaces and some oily parts.

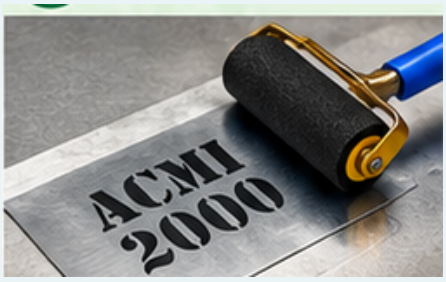
Do not assume suitability without testing.



Illustrations are generic examples, not validated application or performance claims.

METHOD 1 | STENCIL ROLLER OR BRUSH

ACMI lists a stencil roller with pad or brush as an application method. The sequence below is a suggested setup for trials.



01 Secure the stencil

Prepare: representative part, stencil and solvent-compatible roller or brush. Position the stencil flat on the marking area and hold it securely so it cannot shift.

Suggested sequence

1. On a scrap part, trial a small amount of ink with the roller or brush; avoid flooding the stencil.
2. Apply a light, even film across the stencil openings while keeping the stencil stationary.
3. Lift the stencil carefully to avoid smearing. Inspect whether ink has crept beneath the edges.
4. Allow the printed test mark to dry, then check readability, coverage and adhesion. Adjust the trial technique rather than assuming a universal film thickness.

METHOD 2 | WOODEN HAND STAMP + FOAM PAD

The supplied guide identifies **rubber stamping with a foam stamp pad**. The pictured stamp has a traditional wooden mount; the foam pad is a separate item. **Verify that both the pad and rubber die are compatible with the solvent ink.**



02 Wooden-mounted rubber stamp

Use a traditional wooden handle and rubber stamping die. Inspect the rubber for damage and make sure the intended text or symbol fits the part.



03 Separate foam stamp pad

Choose a **solvent-compatible foam pad**. For a trial, add a small amount of #2000 ink to the pad and distribute it evenly; avoid over-saturating. Do not assume an ordinary office stamp pad is compatible.

METHOD 2 | WOODEN HAND STAMP (CONTINUED)

Suggested test sequence for a wooden-mounted rubber stamp and separate foam ink pad.

1. Ink the pad: Apply a small amount of #2000 to the compatible foam pad, spreading it evenly over the contact area. Keep the ink container closed when not dispensing.
2. Load the rubber stamp: Press the rubber face straight onto the pad, then lift it. Check that the raised design is evenly inked without heavy pools.
3. Make the impression: Align the stamp over the part. Press down evenly, without rocking, sliding or dragging; lift straight up.
4. Inspect: Check sharpness, missing characters, bleeding and transfer. Re-ink as necessary, adjusting pressure and loading through testing.
5. Allow to dry: ACMI reports a **typical 75–105 seconds**, affected by temperature, humidity and film thickness. Verify actual dry-to-handle time before stacking or handling parts.

METHOD 3 | AIRBRUSH



04 Solvent-compatible airbrush

Use a suitable airbrush or spray system with ventilation and ignition-source controls. Confirm equipment compatibility before introducing #2000 ink.

1. Consult ACMI and the airbrush manufacturer for compatible components and appropriate preparation.
2. Trial the spray pattern on scrap material. Adjust the equipment using the manufacturer's instructions to obtain controlled coverage.
3. Apply an even trial coat and inspect for overspray, runs, gaps and edge definition.
4. Let the mark dry and verify legibility and adhesion. **No specific nozzle diameter, air pressure, thinning ratio or number of coats is established by the supplied documents.**

IMPORTANT — DO NOT GUESS AT THINNING OR EQUIPMENT SETTINGS

ACMI #2000 Reconditioner is identified in the source guide. It does not provide a universal dilution ratio, a verified equipment-cleaning solvent or exact airbrush settings. Request those details from ACMI and the equipment supplier.

Technical reference + quality checks

Values below are manufacturer-reported in the supplied ACMI #2000 guide; they are not lot-specific acceptance limits.

Federal specification	CID A-A-208B Types I and IV (formerly TT-I-1795A)
Ink system	Solvent-based / pigmented
Viscosity	38 cps (standard #2000)
Specific gravity	1.20
Weight per gallon	10.0 lb/gal
Flash point	46°F (approximately 7.8°C)
Typical dry time	75–105 seconds
Shelf life	Use within 1 year recommended
Reconditioner	ACMI #2000 Reconditioner
Packaging	Pints, quarts and gallons

Colors and availability

The previously supplied SDS identifies multiple color names, including black, blue, brown, gold, gray, green, magenta, maroon, orange, pink, red, silver, tan, violet, white and yellow, as well as variants. **This does not confirm current inventory or availability.** Check the exact formulation and shade with the supplier.

Cleanup, storage and safety

Close containers after use and store away from heat, flames and ignition sources. The supplied guide references SDS storage of **40–90°F (4–32°C)**; confirm the current SDS. Use appropriate eye/skin protection and ventilation. Confirm cleaning agents and waste-disposal requirements for your equipment and facility.

Pre-production acceptance checklist

■ Sharp, readable impression ■ Dry-to-handle time checked
■ Adhesion and rub resistance tested ■ Substrate/coating compatibility verified
■ Required chemical/abrasion exposure tested ■ Required certification reviewed

CUSTOMER RESPONSIBILITY — TEST AND QUALIFY

Use this guide together with the manufacturer’s current TDS and SDS. All operating sequences shown are suggested practices; only the application-method categories and reported product properties are attributed to the supplied ACMI material. Customers must independently verify performance and any military, aerospace or customer specification requirements.