

### HBI Mixing Ratio

<b>SB ink</b>	Weigh desired amount
<b>1000H Hardener</b>	10%
+	
<b>SBM Thinner</b>	20%
<b>S3 Retarder</b>	10%

### Cheat Sheet: Grams

<b>SB ink</b>	50	100	150
<b>1000H Hardener</b>	5	10	15
+			
<b>SBM Thinner</b>	10	20	30
<b>S3 Retarder</b>	5	10	15



## Mixing Rules

Always use a scale!

When new ink can is opened, ink must be mixed well

### STEPS

1. Weigh **INK**, add weighed **HARDENER**
2. **Mix well!**
3. Only then add weighed **THINNER** and **RETARDER**
4. **Mix** again

### MATERIALS

**For Mixing Containers:**

Non-waxed paper

Teflon

Polypropylene

**For Mixing Sticks:**

Wood

Steel