

## Description

ORALITE® 5018 Screen printing ink is a solvent based, quick-curing one-component system with a glossy, highly weatherproof surface after curing. The following transparent colors and opaque black are available:

- ORALITE® - screen printing ink 5018-020 yellow
- ORALITE® - screen printing ink 5018-030 red
- ORALITE® - screen printing ink 5018-035 orange
- ORALITE® - screen printing ink 5018-050 blue
- ORALITE® - screen printing ink 5018-060 green
- ORALITE® - screen printing ink 5018-080 brown
- ORALITE® - screen printing ink 5018-070 black (opaque).

## Area of use

ORALITE® 5018 Screen Printing Ink was especially developed for printing on ORALITE® reflective films with an alkyd resin, acrylic, PVC face film or top coated polyester for printing. Printing on all ORALITE® reflective films, color 010 (white), are perfect for the manufacture of traffic signs.

## Product Handling and Processing

Storage and Transportation	The ink containers have to be stored in a dry indoor area at temperatures between 60°F and 104°F. During transportation, the temperature should not drop below 40° F for more than 24h. Shelf life of closed containers is 2 years. Always keep containers tightly closed after use and finish within 3 months.
Color conditioning	Regarding print viscosity, all seven colors are ready for use. Before printing, ink should be thoroughly stirred using an agitator or substantially shaken by hand. Following thorough mixing and a rest period of about 10 minutes, to allow air bubbles to escape, the screen printing ink is ready for printing. Opened original ink cans should be carefully closed after usage. When reusing such a can, it may be necessary to dilute the ink.
Serigraph stencils	Only wire mesh cloth made of polyester quality of mesh number 61-64 (mesh 1:1) should be used for manufacturing stencils for screen printing.
Processing instructions	Using the recommended stencils guarantees a compliance of the color prints on ORALITE® reflective films of the color 010 (white) with the international specifications for colors at daylight. In addition, the color prints on ORALITE® reflective films Series 6910, 6900, 5930, 5910, 5900, 5810, 5800, 5840, 5710, 5700 and 5500 of the color 010 (white) meet the international specifications for reflective materials of this class, as far as their minimum reflective data is concerned.
Preparation for printing	The stencil for screen printing and the squeegees (flood coater and blade) have to be cleaned with a suitable purifier. Every sheet of film shall be cleaned with an anti-dust cloth.
Drying	As soon as the solvent evaporates, the ink coat starts curing. The drying period depends on the room temperature, the air humidity and the drying conditions. Using a drying rack a good air circulation is required within the first 30 min. Prints are stackable in small stacks (4 inches max). Before stacking the prints must be completely dry. The minimum processing and curing temperature must be 60° F, a humidity of 20% to 50% is recommended. Drying time is 48 hours, after approximately 8 days, the product is thoroughly cured. After curing properly, the ink coat is highly weatherproof and resistant to chemicals and mechanical stress. A transparent coating is not necessary.



## Product Handling and Processing (cont.)

Multicolor printing	Multicolor prints shall be made in an overlapping execution.
Labeling and safety	For ORALITE® screen printing ink current safety data sheets are available containing information about all safety-related data and labeling procedures in accordance with the current specifications for hazardous materials and the EU specifications. Please refer to the product page at <a href="http://www.orafol.com">www.orafol.com</a> for detailed information.

### Note:

All ORALITE® products are manufactured within an ISO 9001:2008 controlled manufacturing environment and batch traceability is possible on the basis of the roll number.

### IMPORTANT NOTICE

When using ORALITE® sheeting, please comply with relevant national specifications. ORAFOL recommends obtaining the current requirements from your local authority and ensure product conformance with such requirements. Please contact ORAFOL for further information.

All ORALITE® products are subject to careful quality control throughout the manufacturing process and are warranted to be of merchantable quality and free from manufacturing defects. Published information concerning ORALITE® products is based upon research which the Company believes to be reliable, although, such information does not constitute a warranty. Because of the variety of uses of ORALITE® products and the continuing development of new applications, the purchaser should carefully consider the suitability and performance of the product for each intended use, and the purchaser shall assume all risks regarding such use. All specifications are subject to change without prior notice.

Surfaces to which the material will be applied must be thoroughly cleaned from dust, grease or any contamination which could affect the adhesion of the material. Freshly lacquered or painted surfaces should be allowed to dry for at least three weeks and to completely cure respectively. The compatibility of selected lacquers and paints should be tested by the user, prior to application of the material. The self-adhesive reflective material can only be used for dry application. The low tensile strength of the material can make the removability of the reflective film more difficult. Please review applicable application information published by ORAFOL.

No warranty is given for purposes other than those listed in the Technical Datasheet or which are not processed according to ORAFOL's processing and handling instructions. The durability of the signs will depend on a variety of factors, including but not limited to substrate selection and preparation, compliance with recommended application guidelines, geographic area, exposure conditions and maintenance of the product and finished sign. Sign failures caused by the substrate or improper surface preparations are not the responsibility of ORAFOL. Please refer to the full warranty document available at [www.orafolamericas.com](http://www.orafolamericas.com) for detailed information.

WARNING: This product contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm.

ORALITE® is a trademark of ORAFOL Europe GmbH.



ORAFOL Americas – GA  
1100 Oracal Parkway  
Black Creek, GA 31308  
Phone: 888.672.2251

ORAFOL Americas – CT  
120 Darling Drive  
Avon, CT 06001  
Phone: 800.654.7570  
techsupport-americas@orafol.com - [www.orafolamericas.com](http://www.orafolamericas.com)

ORAFOL Canada  
2831 Bristol Circle  
Oakville, Ontario L6H 6X5  
Phone: 888.727.3374