

Product 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 colours and opaque black are available in several container sizes from 800 to 4000 ml:

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 5018-073 grey
ORALITE® - screen printing ink 5018-070 black (opaque).

Area of use

The ORALITE® - Screen printing ink was especially developed to be used with ORALITE® reflective films made with alkyd resin, acrylic film or PVC top coats. Printings on all ORALITE® reflective films of color 010 (white) are suitable for the manufacture of traffic signs.

Processing and handling instructions

Storage and Transportation	The ink containers have to be stored in a dry indoor area at temperatures between 15 and 40°C [60 to 104°F]. During transportation, the temperature should not drop below 5°C [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.
Preprocessing of ink	All colours are made ready for use at the time of production. Before printing, the ink should be thoroughly stirred by hand or an electrical stirrer. After stirring and a rest period of about 10 minutes to degas, the screen printing ink is ready for use. When a previously used container is reopened, a dilution might be necessary.
Printing ink additives	In case of print defects, Thinner for ORALITE® 5018 (part no. 345900034), Retarder SV1 (part no. 345900011) and Printing Modifier ES (part no. 345900023) can be used. A maximum addition of 3% thinner <u>or</u> 1.5% of the retarder and 0.5% modifier to the ink is recommended. Please refer to the application instruction of the ORALITE® reflective film for further information.
Printing screens	Only mesh 61-64 (mesh 1:1) should be used for manufacturing of printing screens.
Preparation for printing	The printing screen and squeegees (flood coater and blade) have to be cleaned with a suitable agent. Every sheet of film shall be cleaned with an anti-dust cloth.
Processing	Use of the recommended screens and application instructions guarantees compliance of the color prints on white ORALITE® reflective films to the international specifications for colors at daylight. Prints on white products specified to be used for screen printing also meet the photometric specifications for the printed color. Please refer to the technical datasheet and application instruction of the reflective film.
Drying	Curing starts right after printing with the evaporation of the solvents. The time needed for complete curing strongly depends on ambient conditions such as temperature, humidity and air circulation. When using a drying rack, good air circulation is especially required within the first 30 min. Prints are stackable in small stacks (up to 10 cm [4 in]) when completely cured. The minimum processing and curing temperature must be 15° C [60° F], a humidity of 30% to 50% is recommended. Drying time is 48 hours, after approximately 8 days, the product is thoroughly cured. After complete cure, the print is highly weatherproof and resistant to chemicals and mechanical stress. A transparent varnish is not necessary.
Multicolor printing	Prints with multiple colours shall be printed with an overlap.

Labeling and safety information

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 www.orafol.com for detailed information.

All products are made in an ISO 9001 certified production environment and can be traced with their individual lot number.

IMPORTANT NOTICE

When using ORALITE® sheeting the relevant national specifications have to be complied with. ORAFOL recommends you obtain 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.

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.orafol.com for detailed information.

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