ORALITE®
5018   SCREEN PRINTING INK

Description

The ORALITE® - Screen printing ink Series 5018 is a solventbased, quick-curing one-component system with a glossy, highly weatherproof surface after curing.

Area of use

The ORALITE® - Screen printing ink was especially developed for printing on ORALITE® reflective films the front material of which is made of alkyd resin, acrylic film, PVC or top coated polyester for printing. Printings on all ORALITE® reflective films of colour 010 (white) are suitable for the manufacture of traffic signs.

Supplying assortment

Range of colours:

The following glazing colours 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 is opaque.

Processing and handling instructions

Colour conditioning

Regarding print viscosity all seven colours are ready for use. Before printing, the ink should be thoroughly stirred up 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 colour prints on ORALITE® reflective films of the colour 010 (white) with the international specifications for colours at daylight. In addition to this, the colour prints on ORALITE® reflective films Series 5810, 5800, 5840, 5710, 5700 and 5500 of the colour 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 (10 cm max.). Before stacking the prints must be completely dry.
	The minimum processing and curing temperature must be 15°C, a humidity of 20% to 50% is recommended. Depending on the ambient conditions a drying time of 5 hours minimum is necessary.
	After curing properly, the ink coat is highly weatherproof and resistant to chemicals and mechanical stress. A transparent coating is not necessary.
Multicolour printing	Multicolour prints shall be made in an overlapping execution.
Marking	For the ORALITE® - screen printing inks series current safety data sheets are available containing information about all safety-related data, inclusive the marking procedures in accordance with the current specifications for hazardous materials and the EU specifications. The labels also contain the markings.