



TECHNICAL SERVICE BULLETIN

High Adhesion Water-Based Marking Ink TA-Series

Re: TA Ink Applicator Instructions for Applying Ink to Bead Rings

1. PREPARATION:

- a. Shake the ink well for approximately 10 seconds.
- b. Place black cap with needle attachment on applicator bottle and screw cap on finger tight.
- c. Select needle to be used with applicator to apply ink.
- d. Screw needle on applicator bottle fitting finger tight (needle screws into white tip on black cap).

2. APPLICATION:

- a. Use a minimum amount of ink to create a line. Less ink applied is better.
- b. Be sure tip is clear. Hold bottle upright and lightly squeeze bottle to determine that tip is clear. If tip is not clear, follow Tip Maintenance instructions below.
- c. Shake bottle well before applying ink. (Approximately 10 seconds.)
- d. Turn bottle upside down and hold at an angle with needle touching surface to be marked.
- e. Very lightly squeeze bottle while moving bottle in a linear fashion in order to create a line.
- f. Squeezing the bottle harder will cause more material to flow, squeeze lighter for less flow.
- g. In addition to bottle squeeze tension, needle size can be changed to allow more or less flow depending on the inside diameter of the needle.
- h. When done applying ink, stand bottle upright allowing ink to drain back into bottle. Then squeeze bottle to clear needle with the air in the bottle. This will clear tip when not in use.

3. MAINTENANCE:

- a. Be sure to store the bottle up right at all times when not in use.
- b. Before applying ink check tip for any dried material that may cause tip to clog.
- c. Clear the tip of any dry material.
- d. If tip is clogged, remove the needle. Use a small thin wire smaller than the inside diameter of the needle to clear. (The insides of plastic needles are tapered, easily allowing material to be reversed).
- e. If needle remains clogged then replace needle with a new needle.
- f. The tip of a plastic needle may be cut off if clogged but beware this will allow much more material to flow because of the larger opening created and care should be used not to over apply material.
- g. Do not attempt to thin or clean applicator bottle with ordinary tap water as this may congeal the ink. If a cleaning solution is required we recommend using L-400 cleaning solution.

Needle Selection for Trial Period

Different size and type needles need to be experimented with to determine best size and application rate. Plastic needles seem to perform better than metal needles; this may come down to personal preference. Remember that the **TA ink needs to be 100% dry before further process** can continue. Do not begin to build on the ring until ink is dry. Applying less material will reduce dry time required for ink. However, a large enough needle must be selected for ink to flow. Depending on the speed and squeeze pressure on the bottle, different application amounts and results will occur with different operators.