



TECHNICAL SERVICE BULLETIN

Water-Based Striping Inks TH-Series

Beugler® Wheel Application

1. INTRODUCTION:

The transition from solvent-based products to water-based products is not a direct offset process or direct replacement. This bulletin is to enhance the product change-over process. This also covers maintenance procedures that will add to an easy transition. A regular maintenance schedule must be established when implementing water-based inks.

Implementing these steps will eliminate aches and pains of a long learning curve. Utilizing this information in operator training programs will also help in the transition process. Most important is understanding that the change to water-based products is a work culture and product process change that needs to be harmonized early to avoid repeating errors and eliminating trial and error approaches for implementation of water-based products. A regular maintenance schedule must be established when implementing water-based inks.

2. TH-SERIES INK:

TH series inks have been developed and manufactured at an optimum viscosity. The ink is packaged and delivered at the most effective viscosity to flow through a Beugler® Wheel striper. The ink is packaged in quart bottles with a threaded cap for direct connection to the Beugler® Wheel. Other packaging sizes are available but do not have threads compatible to match Beugler® Wheels. This packaging must be decanted after being thoroughly mixed.

3. APPLICATION:

- a. Beugler® Wheel **see Diagram A

4. USE:

- a. Thoroughly mix the bottle for a minimum of two minutes, check for sediment on bottom of bottle, if sediment is still visible, continue to mix until all of the sediment from the bottom of the container is incorporated.
- b. Inspect Beugler® Wheel to be sure that it is clean and free of foreign material
- c. Remove lid from bottle and remove protective seal from container, be careful not to allow foreign material to enter the container when opening.
- d. Screw cap onto container and push-fit apply to the Beugler® Wheel.
- e. Place the Beugler® Wheel assembly into bottle-holder bracket inverted and place above material to be marked. Be sure assembly is oriented in proper direction, wheel only properly applies ink in one direction, see drawing for proper orientation.
- f. Be sure that the assembly is touching surface with only sufficient force to mark the surface without any skips. Too much pressure can cause scoring of soft surfaces. Too heavy of an application can cause slower drying.
- g. Bottle assembly should be thoroughly shaken at minimum once each shift for a minimum of one minute while in use or re-shaken at each color change.
- h. When the assembly is not in use, remove cap and wheel, clean both with water and brush. Store the bottle in an upright position. To combat ink build-up on wheels, the wheel should be removed from the bottle and the original lid replaced. The wheel should then be submerged in water. Keeping the head wet with a damp cloth while not in use. This will prevent clogging or ink drying on the wheel. The ink will not re-dissolve if it has dried.
- i. Regularly remove any dried ink from the Beugler® Wheel. This process will prolong the life of the wheel and reduce maintenance.

(Following these steps will allow for smoother service and cleaner lines with little trouble. Some procedures could be modified to meet line process needs.)



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5. CAUTIONS:

- a. Store unused ink in a cool area out of direct sunlight, storage temperature is not to exceed 100 F, failure to do so can result in shortened shelf life and extended mixing times.
- b. Do not mix the APV TH-Series inks with solvent-based inks or other brand inks.
- c. Do not add any liquid to ink; this product has been formulated, manufactured and delivered ready to use.
- d. Mix the bottle for a minimum of two minutes prior to opening, check the bottom of the bottle to ensure no sediment is left unmixed. Continue to mix the bottle until no sediment is left. Failure to mix well can result in slower dry time, weak color, and poor adhesion.
- e. Do not try to re-solvate water-based inks with solvent or water once the ink has dried. It cannot be removed or solvated.
- f. Begin use of water-based TH-series inks with new Beugler® Wheels, very small amounts of solvents or solvent-based inks can cause the water-based inks to become seedy or gel.
- g. TH-series inks should not be used with close tolerance striping wheels.
- h. It is recommended that the ink be applied as close to extruder as physically possible.

NOTE: The information and data given herein are based upon tests and reports considered reliable and are believed to be accurate. However, due to varied application and handling methods, no guarantee of duplicate performance, expressed or implied, is made.

