Water-Based Bead Marking Ink, also referred to as TA-series ink, is a co-curable product typically used in tire manufacturing to mark uncured bead rings for identification purposes. The product is safe for internal use and can also be used to mark other uncured rubber parts including plies and sheet rubber. After using the product in production, manufacturers have shown reductions in defects and waste.

The ink has exceptional adhesion and is non-hazardous. It is available in a wide variety of colors as well as low and high viscosity ranges. Bead Marking Ink is applied by hand and comes packaged in 8 oz. bottles with a cap and nozzle.

**Color Availability:**
- TA-1120 White
- TA-2120 Red
- TA-2140 Dark Brown
- TA-3120 Orange
- TA-4120 Yellow
- TA-5120 Green
- TA-6104 Blue
- TA-6420 Light Blue
# PRODUCT DATA SHEET

## Product Specifications

### WATER-BASED BEAD MARKING INKS

**PRODUCT NUMBER:** TA-Series

**COLOR:** Various

**TYPE:** Water-Based, High Adhesion

**VISCOSITY (ASTM D 2196-86):** 850 ± 250 CPS #3/30 RPM

**WEIGHT PER GALLON (ASTM D 1475-90):** 8.10 - 8.70 lbs/gal

**SPECIFIC GRAVITY (ASTM D 1475-90):** .972 - 1.044 g/ml

**pH:** 10.3 ± 0.5

**FLASH POINT:** (ASTM D 3828-93): > 200 °F

**SOLIDS:** 45 - 50% by weight 31-36% by volume

**THEORETICAL COVERAGE:** 500-580 ft² / gal @ 1.0 mil (12.3-14.2m² / L @ 25.4 µ)

**VOC:**

- WET: .00 lb/gal (.00 g/l)
- DRY: .00 lb/gal (.00 g/l)

**METHOD:** Syringe/APV Bead Marker Bottle

**REDUCTION:** None Required, Use as supplied

**DRY TO TOUCH:** 1-10 minutes dependant on air flow

**CLEAN UP SOLVENT:** L-400 or Isopropyl Alcohol

**RECOMMENDED EQUIPMENT:** Hand-applied

**TYPE:** Uncured Bead Rings and Rubber Compound

**PREPARATION:** Clean, Dry surface, free of oil and lubricants

**SHELF LIFE:** 9 Months unopened

**FREEZE CAUTION:** Keep from freezing

**RECOMMENDED STORAGE:** Dry Storage between 70°-85°F (21°-29°C)

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Mix well before using. Close container after use. Contains no hazardous air pollutants.

Minimum adhesion - 20 lbs force pull tear.

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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.