

PRODUCT DATA SHEET



Solvent-Based Dot Markers

Inspection Marking Ink

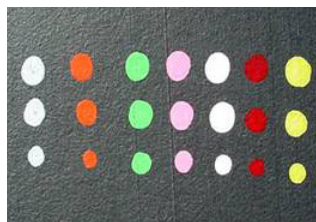
D-series

Solvent-Based Dot Markers are typically used in tire manufacturing to denote high point, conicity, and pass/fail on a tire after it has been cured during production. The marks help to assure synchronization of the tires during the rim assembly process and when mounting the tire.

Solvent-Based Dot Markers can be applied by hand or installed in a balancing/uniformity machine. The product is offered in three different sized diameters: 5-8mm. (small), 10-13mm.(standard), and 18-23mm. (extra large). The average number of dots produced by each marker (with normal use) is approximately 5000 dots ($\pm 10\%$).

Color and Size Availability:

- D-1009 **White** - standard/small/XL
- D-2522 **Pink** - standard/small
- D-2617 **Red** - standard/small/XL
- D-2861 **Ford Red** - standard/small/XL
- D-3564 **Orange** - standard/small/XL
- D-4744 **Yellow** - standard/small/XL
- D-4811 **Heavy Yellow** - standard
- D-5865 **Ford Green** - standard/small/XL
- D-6031 **Light Blue** - standard/small
- D-6699 **Blue** - standard/small/XL
- D-8505 **Gray** - standard
- D-9195 **Black** - standard



Features:

Quick-Drying

Wide Variety of Colors

Pocket-Sized

Easy to Use

Allows Effective Control of Dot Size

Aids Synchronization & Process Verification

Low VOCs

Industry Proven

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Product Specifications

PRODUCT DESCRIPTION:

SOLVENT-BASED DOT MARKERS

PRODUCT NUMBER: D-Series

PHYSICAL PROPERTIES:

COLOR: Various
TYPE: Solvent-Based
VISCOSITY(ASTM D 2196-86): 45-55 seconds #2 Zahn
WEIGHT PER GALLON (ASTM D 1475-90): 8.1 - 11.2 lbs/gal
SPECIFIC GRAVITY (ASTM D 1475-90): 0.98 - 2.30
pH: N/A
FLASH POINT (ASTM D 3828-93): > 81 °F
SOLIDS: 33- 58.4% by weight 26.9 - 38.9% by volume
THEORETICAL COVERAGE: 431 - 624 ft² / gal @ 1.0 mil (10.59 - 15.31 m² / L @ 25.4 μ)
VOC: WET: 4.68 - 5.49 lb/gal
COVERAGE: same as theoretical
RECOMMENDED FILM THICKNESS: WET: 2.5 mil DRY: 1.0 mil

APPLICATION:

METHOD: By Hand
REDUCTION: None Required, Use as supplied
DRY TO TOUCH: 1-10 minutes dependant on air flow
CLEAN UP SOLVENT: APV's L-265
RECOMMENDED EQUIPMENT: N/A

SUBSTRATE:

TYPE: Cured Rubber Compound
PREPARATION: Clean, Dry surface, free from silicone

HANDLING & STORAGE:

SHELF LIFE: 12 months, unopened
FREEZE CAUTION: Keep from freezing
RECOMMENDED STORAGE: Cool, dry location

COMMENTS:

Shake well before using. Close container with cap after use. To refresh tips, place them in a small amount of APV's L-1000.