

# PRODUCT DATA

# PRODUCT #: TA-SERIES

## DESCRIPTION:

**WATER BASED BEAD MARKING INK**

## PRODUCT INFORMATION:

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 as well as marking uncured rubber parts like 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	BROWN
TA-3120	ORANGE
TA-4120	YELLOW
TA-5120	GREEN
TA-6120	BLUE
TA-6104	BLUE

## FEATURES:

*Excellent Adhesion*

*Helps to Reduce Defects and Waste*

*Fast Drying on Hot Surfaces*

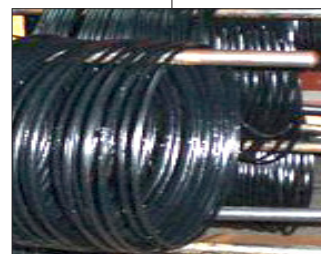
*Easy Application*

*Non-Hazardous, Non-Flammable*

*Industry Proven*

*Contains no VOC's*

*Wide Variety of Colors*



# TECHNICAL DATA SHEET

**PRODUCT CODE(S):**

TA-1120

**PRODUCT DESCRIPTION:**

BEAD MARKING INK

**PHYSICAL PROPERTIES:**

COLOR:	WHITE
TYPE:	WATER BASED
VISCOSITY:	850+/-250 CPS #3 SPINDLE @30 RPM
WEIGHT PER GALLON:	8.63 lbs/gal ± lbs. 1.03 g/ml ± 0.00 g/ml
SPECIFIC GRAVITY (ASTM D 1475-90):	1.033 ± .035
GLOSS @ 60°:	
pH:	10.3 +/-0.5
FLASH POINT:	* °F -17.8 °C
SOLIDS:	49.64 % by weight 35.35 % by volume
THEORETICAL COVERAGE:	567.01 ft <sup>2</sup> / gal @ 1.0 mil dry 13.91 m <sup>2</sup> /l @ 25.4 μ
VOC (WET):	0.00 lb(s)/gal ( 0.0 g/l)
VOC (DRY):	0.00 lb(s)/gal ( 0.0 g/l)

**APPLICATION:**

METHOD:	SYRINGE/APV BEAD MARKER BOTTLE
CURE METHOD:	
REDUCTION:	NONE REQUIRED, USE AS SUPPLIED
CLEAN UP:	L-400 OR ISOPROPYL ALCOHOL
RECOMMENDED EQUIPMENT:	HAND APPLIED

**SUBSTRATE:**

TYPE:	UNCURED BEAD RINGS AND RUBBER COMPOUND
PREPARATION:	CLEAN DRY SURFACE, FREE OF OIL AND LUBRICANTS

**HANDLING & STORAGE:**

SHELF LIFE:	9 MONTHS UNOPENED
FREEZE CAUTION:	Protect from freezing
RECOMMENDED STORAGE:	CRY STORAGE BETWEEN 70-85 °F

**ADDITIONAL GUIDELINES:**

Mix well before using. Close container after use. Contains no hazardous air pollutants. Minimum adhesion: 20 lbs force pull tear.

## A focused partner in advanced coating, chemical & manufacturing solutions...

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# TECHNICAL DATA SHEET

**PRODUCT CODE(S):**

TA-2120

**PRODUCT DESCRIPTION:**

BEAD MARKING INK

**PHYSICAL PROPERTIES:**

COLOR:	RED
TYPE:	WATER BASED
VISCOSITY:	850+/-250 CPS #3 SPINDLE @ 30 RPM
WEIGHT PER GALLON:	8.14 lbs/gal ± lbs. 0.98 g/ml ± 0.00 g/ml
SPECIFIC GRAVITY (ASTM D 1475-90):	0.980 ± 0.35
GLOSS @ 60°:	
pH:	10.3+/-0.5
FLASH POINT:	* 210 °F 98.9 °C
SOLIDS:	44.39 % by weight 34.02 % by volume
THEORETICAL COVERAGE:	545.68 ft <sup>2</sup> /gal @ 1.0 mil dry 13.39 m <sup>2</sup> /l @ 25.4 μ
VOC (WET):	0.09 lb(s)/gal ( 10.8 g/l)
VOC (DRY):	0.20 lb(s)/gal ( 24.0 g/l)

**APPLICATION:**

METHOD:	SYRINGE/APV BEAD MARKER BOTTLE
CURE METHOD:	
REDUCTION:	NONE REQUIRED, USE AS SUPPLIED
CLEAN UP:	L-400 OR ISOPROYL ALCOHOL
RECOMMENDED EQUIPMENT:	HAND APPLIED

**SUBSTRATE:**

TYPE:	UNCURED BEAD RINGS AND RUBBER COMPOUND
PREPARATION:	CLEAN, DRY SURFACE, FREE OF OIL AND LUBRICANTS

**HANDLING & STORAGE:**

SHELF LIFE:	9 MONTHS UNOPENED
FREEZE CAUTION:	Protect from freezing
RECOMMENDED STORAGE:	DRY STORAGE BETWEEN 70-85 °F

**ADDITIONAL GUIDELINES:**

Mix well before using. Close container after use. Contains no hazardous air pollutants. Minimum adhesion 20 lbs force pull tear.

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**PRODUCT CODE(S):**

TA-2140

**PRODUCT DESCRIPTION:**

BEAD MARKING INK

**PHYSICAL PROPERTIES:**

COLOR:	BROWN
TYPE:	WATER BASED
VISCOSITY:	#3 SPINDLE @30 RPM 850+/-250 CPS
WEIGHT PER GALLON:	8.16 lbs/gal ± 0.30 lbs. 0.98 g/ml ± 0.04 g/ml
SPECIFIC GRAVITY (ASTM D 1475-90):	0.979 ± 0.035
GLOSS @ 60°:	
pH:	10.3+/-0.5
FLASH POINT:	* 200 °F 93.3 °C
SOLIDS:	46.55 % by weight 33.69 % by volume
THEORETICAL COVERAGE:	540.39 ft <sup>2</sup> / gal @ 1.0 mil dry 13.26 m <sup>2</sup> / l @ 25.4 μ
VOC (WET):	0.00 lb(s)/gal ( 0.0 g/l)
VOC (DRY):	0.00 lb(s)/gal ( 0.0 g/l)

**APPLICATION:**

METHOD:	SYRINGE/APV BEAD MARKERS BOTTLE
CURE METHOD:	
REDUCTION:	NONE REQUIRED, USE AS SUPPLIED
CLEAN UP:	L-400 ISOPROPYL ALCOHOL
RECOMMENDED EQUIPMENT:	HAND-APPLIED

**SUBSTRATE:**

TYPE:	UNCURED BEAD RINGS AND RUBBER COMPOUND
PREPARATION:	CLEAN, DRY SURFACE, FREE OF OIL AND LUBRICANTS

**HANDLING & STORAGE:**

SHELF LIFE:	9 MONTHS UNOPENED
FREEZE CAUTION:	Protect from freezing
RECOMMENDED STORAGE:	DRY STORAGE BETWEEN 70-80 °F

**ADDITIONAL GUIDELINES:**

Mix well before using. Close container after use. Contains no hazardous air pollutants. Minimum adhesion 20 lbs force pull tear. Dry to touch in 1-10 minutes dependent on air flow. High Adhesion.

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**PRODUCT CODE(S):**

TA-3120

**PRODUCT DESCRIPTION:**

BEAD MARKING INK

**PHYSICAL PROPERTIES:**

COLOR:	ORANGE
TYPE:	WATER BASED
VISCOSITY:	850+/-100 #3 SPINDLE @ 30 RPM
WEIGHT PER GALLON:	8.34 lbs/gal ± 0.30 lbs.
	1.00 g/ml ± 0.04 g/ml
SPECIFIC GRAVITY (ASTM D 1475-90):	0.999 ± 0.035
GLOSS @ 60°:	
pH:	10.3+/-0.5
FLASH POINT:	* °F -17.8 °C
SOLIDS:	47.28 % by weight
	34.11 % by volume
THEORETICAL COVERAGE:	547.12 ft <sup>2</sup> / gal @ 1.0 mil dry
	13.43 m <sup>2</sup> /l @ 25.4 μ
VOC (WET):	0.05 lb(s)/gal ( 6.0 g/l)
VOC (DRY):	0.11 lb(s)/gal ( 13.2 g/l)

**APPLICATION:**

METHOD:	SYRINGE/ APV BEAR MARKER BOTTLE
CURE METHOD:	
REDUCTION:	NONE REQUIRED, USE AS SUPPLIED
CLEAN UP:	L-400 OR ISOPROPYL ALCOHOL
RECOMMENDED EQUIPMENT:	HAND APPLIED

**SUBSTRATE:**

TYPE:	UNCURED BEAD RINGS AND RUBBER COMPOUND
PREPARATION:	CLEAN DRY SURFACE, FREE OF OIL AND LUBRICANTS

**HANDLING & STORAGE:**

SHELF LIFE:	9 MONTHS UNOPENED
FREEZE CAUTION:	Protect from freezing
RECOMMENDED STORAGE:	DRY STORAGE BETWEEN 70-85 °F

**ADDITIONAL GUIDELINES:**

Mix well before using. Close container after use. Contains no hazardous air pollutants. Minimum adhesion: 20 lbs force pull tear.

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**PRODUCT CODE(S):**

TA-5120

**PRODUCT DESCRIPTION:**

BEAD MARKING INK

**PHYSICAL PROPERTIES:**

COLOR:	GREEN
TYPE:	WATER BASED
VISCOSITY:	850+/-150 #3@30
WEIGHT PER GALLON:	8.31 lbs/gal ± 0.30 lbs.
	1.00 g/ml ± 0.04 g/ml
SPECIFIC GRAVITY (ASTM D 1475-90):	0.991 ± 0.04
GLOSS @ 60°:	
pH:	10.3+/-0.5
FLASH POINT:	* 212 °F 100.0 °C
SOLIDS:	47.91 % by weight
	34.41 % by volume
THEORETICAL COVERAGE:	551.94 ft <sup>2</sup> / gal @ 1.0 mil dry
	13.54 m <sup>2</sup> /l @ 25.4 μ
VOC (WET):	0.00 lb(s)/gal ( 0.0 g/l)
VOC (DRY):	0.00 lb(s)/gal ( 0.0 g/l)

**APPLICATION:**

METHOD:	SYRINGE/APV BEAD MARKER BOTTLE
CURE METHOD:	
REDUCTION:	NONE REQUIRED, USE AS SUPPLIED
CLEAN UP:	L-400 OR ISOPROPYL ALCOHOL
RECOMMENDED EQUIPMENT:	HAND APPLIED

**SUBSTRATE:**

TYPE:	UNCURED BEAD RINGS AND RUBBER COMPOUND
PREPARATION:	CLEAN DRY SURFACE, FREE OF OIL AND LUBRICANTS

**HANDLING & STORAGE:**

SHELF LIFE:	9 MONTHS UNOPENED
FREEZE CAUTION:	Protect from freezing
RECOMMENDED STORAGE:	DRY STORAGE BETWEEN 70-85 °F

**ADDITIONAL GUIDELINES:**

Mix well before using. Close container after use. Contains no hazardous air pollutants. Minimum adhesion: 20 lbs force pull tear.

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**PRODUCT CODE(S):**

TA-4120

**PRODUCT DESCRIPTION:**

BEAD MARKING INK

**PHYSICAL PROPERTIES:**

COLOR:	YELLOW	
TYPE:	WATER BASED	
VISCOSITY:	850+/-150 #3SPINDLE @30 RPM	
WEIGHT PER GALLON:	8.46	lbs/gal ± 0.30 lbs.
	1.01	g/ml ± 0.04 g/ml
SPECIFIC GRAVITY (ASTM D 1475-90):	1.015	± 0.035
GLOSS @ 60°:		
pH:	10.3+/-0.5	
FLASH POINT:	212 °F	100.0 °C
SOLIDS:	48.33	% by weight
	33.05	% by volume
THEORETICAL COVERAGE:	530.12	ft <sup>2</sup> / gal @ 1.0 mil dry
	13.01	m <sup>2</sup> /l @ 25.4 μ
VOC (WET):	0.00	lb(s)/gal ( 0.0 g/l)
VOC (DRY):	0.00	lb(s)/gal ( 0.0 g/l)

**APPLICATION:**

METHOD:	SYRINGE/APV BEAD MARKER BOTTLE
CURE METHOD:	
REDUCTION:	NONE REQUIRED, USE AS SUPPLIED
CLEAN UP:	L-400 OR ISOPROPYL ALCOHOL
RECOMMENDED EQUIPMENT:	HAND APPLIED

**SUBSTRATE:**

TYPE:	UNCURED BEAD RINGS AND RUBBER COMPOUND
PREPARATION:	CLEAN DRY SURFACE, FREE OF OIL AND LUBRICANTS

**HANDLING & STORAGE:**

SHELF LIFE:	9 MONTHS UNOPENED
FREEZE CAUTION:	Protect from freezing
RECOMMENDED STORAGE:	DRY STORAGE BETWEEN 70-85 °F

**ADDITIONAL GUIDELINES:**

MiX well before using. Close container after use. Contains no hazardous air pollutants. Minimum adhesion: 20 lbs force pull tear.

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# TECHNICAL DATA SHEET



## PRODUCT CODE(S):

TA-6120

## PRODUCT DESCRIPTION:

BEAD MARKING INK

## PHYSICAL PROPERTIES:

COLOR:	BLUE
TYPE:	WATER BASED
VISCOSITY:	#3 SPINDLE@30 RPM 850+/-250 RPM
WEIGHT PER GALLON:	8.46 lbs/gal ± 0.30 lbs.
	1.01 g/ml ± 0.04 g/ml
SPECIFIC GRAVITY (ASTM D 1475-90):	1.019 ± 0.035
GLOSS @ 60°:	
pH:	10.3+/-0.5
FLASH POINT:	> 200 °F 93.3 °C
SOLIDS:	48.42 % by weight
	35.25 % by volume
THEORETICAL COVERAGE:	565.41 ft <sup>2</sup> / gal @ 1.0 mil dry
	13.87 m <sup>2</sup> /l @ 25.4 μ
VOC (WET):	0.02 lb(s)/gal ( 2.4 g/l)
VOC (DRY):	0.04 lb(s)/gal ( 4.8 g/l)

## APPLICATION:

METHOD:	SYRINGE APPLICATOR
CURE METHOD:	
REDUCTION:	
CLEAN UP:	ISOPROPYL ALCOHOL, L-400
RECOMMENDED EQUIPMENT:	

## SUBSTRATE:

TYPE:	COMPOUNDED TREAD RUBBER
PREPARATION:	CLEAN SURFACE

## HANDLING & STORAGE:

SHELF LIFE:	9 MONTHS UNOPENED
FREEZE CAUTION:	Protect from freezing
RECOMMENDED STORAGE:	DRY STORAGE BETWEEN 70-85 °F

## ADDITIONAL GUIDELINES:

This ink was designed for marking uncured "green" rubber components or hose. It will co-cure with a wide variety of synthetic or natural compounds. Zero (0.0) V.O.C.'s.

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# TECHNICAL DATA SHEET

**PRODUCT CODE(S):**

TA-6104

**PRODUCT DESCRIPTION:**

BEAD MARKING INK

**PHYSICAL PROPERTIES:**

COLOR:	BLUE
TYPE:	WATER BASED
VISCOSITY:	850+/-150 #3 SPINDLE @30
WEIGHT PER GALLON:	8.46 lbs/gal ± 0.30 lbs.
	1.01 g/ml ± 0.04 g/ml
SPECIFIC GRAVITY (ASTM D 1475-90):	1.020 ± 0.035
GLOSS @ 60°:	
pH:	10.3+/-0.5
FLASH POINT:	* 99 °F 37.2 °C
SOLIDS:	48.61 % by weight
	35.4 % by volume
THEORETICAL COVERAGE:	567.82 ft <sup>2</sup> / gal @ 1.0 mil dry
	13.93 m <sup>2</sup> /l @ 25.4 μ
VOC (WET):	0.00 lb(s)/gal ( 0.0 g/l)
VOC (DRY):	0.01 lb(s)/gal ( 1.2 g/l)

**APPLICATION:**

METHOD:	SYRINGE/APV BEAD MARKER BOTTLE
CURE METHOD:	
REDUCTION:	NONE REQUIRED, USE AS SUPPLIED
CLEAN UP:	L-400 OR ISOPROPYL ALCOHOL
RECOMMENDED EQUIPMENT:	HAND APPLIED

**SUBSTRATE:**

TYPE:	UNCURED BEAD RINGS AND RUBBER COMPOUND
PREPARATION:	CLEAN DRY SURFACE, FREE OF OIL AND LUBRICANTS

**HANDLING & STORAGE:**

SHELF LIFE:	9 MONTHS UNOPENED
FREEZE CAUTION:	Protect from freezing
RECOMMENDED STORAGE:	DRY STORAGE BETWEEN 70-85 °F

**ADDITIONAL GUIDELINES:**

Mix well before using. Close container after use. Contains no hazardous air pollutants. Minimum adhesion: 20 lbs force pull tear.

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