



AUTOMARK APL

Solvent Screen Ink For Panel Automotive Constructions

Features

- **Specifically Designed for Automotive Industry Constructions**
- **Consistent Ink Viscosity for All Blending Colors**
- **Excellent Opacity / Bright Clean Colors**
- **Superior Color Stability**
- **Safe, Low Temperature, Jet Drying**
- **Clean Transparent Shades for LED or Window Applications**

Thinning

Stir well before every use. Viscosity reduction can be accomplished using the APL-TH Thinner or the APL-RT Retarder. Suggested maximum level is 30% reduction by weight.

Note: The addition of retarder will significantly increase the dry time.

Mesh and Squeegee

Automark APL prints well through 196 to 305 (77 to 120/cm) monofilament polyester or stainless steel fabrics. The ideal squeegee durometers are from 60 to 80 and solvent resistant.

Stencils

Stencil materials must be solvent resistant. Solvent-adhered stencil films should not be used with Automark APL.

Drying

It is important that Automark APL be thoroughly dried for best performance. Automark APL should not be air dried.

Properly thinned, Automark APL must be jet dried at no less than 160°F (70°C) for 5 minutes.

When the APL-RT is used as a reducer, a dry time of 180°F (80°C) for 5 minutes is suggested. The retarder requires this temperature to properly dry.

Note: As multiple layers of ink are printed over each other, dry times will increase.

Coverage

Standard line colors should yield coverage of 1,800 to 2,400 square feet/gallon (45 to 57 m²/liter) depending on film thickness.

Wash Up

Wash up on press with Xtend™ press washes and after the production run with Xtend™ ink degradants.

Pre-Production Test

It is strongly recommended that all substrates be tested before use as supposedly similar substrates can vary between manufacturers and even between different batches from the same manufacturer. Certain plastics may be impregnated with lubricants that, like plasticizer migration, may impair adhesion and block resistance, even a considerable period after printing. Other plastics can become brittle or caused to curl after printing.

END-USER MUST DETERMINE SUITABILITY OF THIS PRODUCT FOR THE INTENDED USE PRIOR TO PRODUCTION.

Co-Use with Other Inks

It is not recommended that Automark APL be intermixed and/or inter-printed with any other UV or solvent-based ink system.

Color Availability

The Automark APL color range includes standard printing colors as well as matching system colors. This color range includes transparent as well as opaque pigments (where appropriate), which allows a variety of backlit and first-surface colors to be matched. All pigments have suitable lightfastness and heat stability to pass most automotive interior appliqué specifications.

Automark APL toners are single pigment inks that can be mixed in any proportion. All toners are glossy when blended. If gloss reduction/diffusion is desired, use the APL-DX Diffuser Clear as required.

Special Matches

Special colors can be supplied against prints, wet ink, PANTONE® numbers, or other standard colors.



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Standard Colors

APL-233	Trans. R S Blue
APL-260	Trans. Y S Red
APL-265	Trans. B S Red
APL-301	Opaque Black
APL-312	Opaque White
APL-DBC	Dye Base Clear
APL-DX	Diffuser Clear
APL-GB	Gloss Black
APL-HTX	Halftone Extender

Matching System

APL-010	G S Yellow
APL-014	R S Yellow
APL-020	Orange
APL-030	Y S Red
APL-031	B S Red
APL-035	Magenta
APL-039	Violet
APL37704	B S Green
APL-041	Y S Green
APL-050	G S Blue
APL-052	R S Blue
APL-MX	Mixing Clear
APL-SB	Shading Black
APL-TW	Tinting White

Thinners/Retarders

APL-TH	Thinner
APL-RT	Retarder

Reducers/Modifiers

APL-FC	Flow Control
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Metallics

Automark APL Mixing Clear is recommended for use with metallic powders. Suggested ratios of powder and Mixing Clear are 8% by weight of silver powder and 20% by weight of gold powder. It is recommended that fresh metallics be mixed daily to prevent color shift of the finished mix.

Dye Based Clear

The Automark APL-DBC (Dye Based Clear) is designed to be the foundation vehicle for customer-supplied colorant dyes used when printing LED's and/or panel windows. APL-DBC is Silicone/ Flow control free, so the printer can add preferred flow control additives. Dyes may be dissolved directly into the DBC, or may be dissolved in a solvent first, then added as a solution. Solvents used in the DBC are quite aggressive and will hold dyes in solution for a reasonable amount of time. However, no solvent/dye solution is indefinitely stable.

The APL Dye Based Clear should be used with the APL-FC (Flow Control), allowing customers to achieve desired appearance clarity and printability properties. APL-FC flow control should be added in increments of 1/2 percent by weight, and must be power mixed. APL-FC is a silicone, and will increase the internal haze of the clear, so it should be used sparingly.

Storage

Containers should be tightly closed immediately after use. At the end of long printing runs, surplus ink from the screen should be disposed of. Refer to Material Safety Data Sheet (MSDS) for materials and conditions to be avoided.

In the interest of maximum shelf life, storage temperatures should be between 50°F (10°C) and 77°F (25°C). When stored under these conditions the maximum shelf life is shown by the use by dates, which are clearly marked on all ink containers.

Safety and Handling

Refer to MSDS for safety, handling, and waste disposal information.