

Sericol TMI II 1000 Overprint Clear Coat

Instructional Bulletin #3.24 (Revision 4)

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1.0 Scope

Avery Dennison Recommends:

- Sericol's TMI II 1000 is a single component overprint clear coat. When screen printing Avery Dennison™ Marking Films with Sericol's TMI II inks, the clear coat provides an overall excellent cosmetic appearance and extends the life of the printed part.
- It is very important that the clear coat be applied properly and in the correct amount to assure durability and performance of the printed part.
- After jet drying the final TMI II ink color, the print may be clear coated with TMI II 1000 without batch oven drying the inks.

2.0 TMI II 1000 Overprint Clear

2.1 System Components

Product #	Description
K-77747	1000 Overprint Clear
K-14003	Thinner
K-67020	Retarder* (Do not exceed 5% by weight)

2.2 Mixing Instruction

- Adjust viscosity to 20 seconds in a #5 Zahn cup using K-14003 Thinner (the use of any other thinner will affect flow). K67020 retarder may be used (do not exceed 5% by weight) if needed to improve screen stability. The TMI II 1000 overprint clear can be stored and reused once thinned; however, viscosity will need to be readjusted. *NOTE: Use of the retarder will increase normal clear coat drying time.

3.0 Application of TMI 1000 Overprint Clear Coat Over TMI II Ink Systems

3.1 Screen Printing

Mesh Count	Squeegee Durometer
157 - 200	70

NOTE: When tensioning screens, tension the fabric to 16-22 Newton (N/cm). Any suitable (lacquer proof) stencil system may be used (i.e., direct method, indirect method, direct/indirect method, or capillary films). Prior to production, it is recommended to test the compatibility of the stencil and the ink. When clear coating a metallic color, the coarser mesh is suggested to properly protect the metallic flakes. It may be necessary, when using a large flake, to apply two coats of clear for adequate protection.

3.2 Roller Coating

- TMI II 1000 overprint clear coat may be roller coated. While the same respective screen printing mixing instructions will apply, additional viscosity "adjustments" with the appropriate thinner may be necessary to assure coatability. The minimum dry film thickness of the overprint clear coat should be 0.4 mil (10mm).
- When roller coating, it is important to obtain a uniform dry film thickness to assure a smooth, even coat.

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4.0 Drying of the TMI II Overprint Clear Coat

- TMI II 1000 Overprint Clear can be batch oven dried or dried in a jet dryer.

4.1 Batch Oven Drying

- The prints should be racked and placed in a batch oven for 45 Minutes at 160° F (70° C)
- After batch oven drying, prints must cool on racks for a minimum of 30 minutes before unstacking. Stacking prints too soon after drying may leave an impression in the clear coat. Premasking prints too soon after drying may cause difficult premask removal.
- Properly vent batch ovens. To prevent hot and/or cool spots, adequate air circulation is required. To test, use maximum number of racks with temperature sensitive tapes at the top, middle, and bottom of each rack.

4.2 Jet Drying

- Jet drying of TMI II 1000 can be accomplished as follows 45 Seconds* at 160° F (70° C).
NOTE: Dwell time listed is a total belt time. At least 60% of the total belt time should be in the heat chamber. This total belt time is considered the minimum time required before stacking.
- For further information about the processing of Avery Dennison films with Sericol's TMI II 1000 Overprint Clear Coat system, contact Avery Dennison's Graphics Division Customer Technical Support Team.
- To order Sericol's TMI II 1000 Clear Coat, MSDS (Material Safety Data Sheet) information, or to obtain general ink information, contact Sericol Customer Service at (800) 255-4562.

NOTE: The preceding information is based upon tests believed to be reliable and is intended only as a source of information. The purchaser should independently determine, prior to use, the suitability of the ink system for his/her specific purposes. Performance of the ink system is not guaranteed by Avery Dennison.

Revisions have been italicized.

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