

GTR Series is a highly versatile solvent based screen printable ink system for graphic transfer decorating of motorcycles, automotives, bicycles, helmets and various other applications. This ink was specifically designed for use as a substrate free waterslide decal and is ideal for curved and irregular surfaces. The finished decal is suitable for overprinting or overspraying to obtain a high-luster, abrasion and solvent resistant finished part. The system is offered in our CMS Pantone® Approved Color Matching System as well as a variety of highly reflective metallics.

### Printing

Stir well before printing. Thinning colors 10% - 20% is allowed. Thinners are available with Normal, and Slow dry times. Thinner is not recommended for the removable Transfer Premask Clearcoat. Print speed of the Transfer Premask Clearcoat should be very slow with minimized off contact. A high thickness of Transfer Premask Clearcoat is important for elasticity and protection of printed decals. If Transfer Premask Clearcoat is too thin; decals may be difficult to manage during application. The Transfer Premask Clearcoat may also be difficult to peel-off the cured decal if deposit is not maximized. It is normal to witness some bubbling in wet coating, however, once dry, the surface should become smooth.

### Coverage

1,200 to 1,700 square feet per gallon with 260 mesh/inch. Coverage is dependant on color and printing conditions.

### Light Fastness

Colors are lightfast up to three (3) years with a 260/inch or coarser mesh.

### Stencil

Solvent resistant, dual cure emulsion is best.

### Mesh

- 200 mesh/inch for base coat white or clear
- 158 to 305 mesh/inch for image colors
- 158 to 305 mesh/inch for metallic's
- 200 mesh/inch for Transparent Base
- 60 mesh/inch with extra emulsion build on substrate side to maximize deposit of Transfer Premask Clearcoat

### Squeegee

A 70 to 80 durometer, sharp-finished square edge profile is best for first and last down clear, base white, metallic's and colors.

A 65 durometer, rounded profile is best for Transfer Premask Clearcoat.

### Drying

Ink dries rapidly by solvent evaporation. Dry time can be reduced with hot air drying at 40 - 50°C.

- First Down Clear: 30 minutes - room temperature
- Colors: 15 minutes - room temperature
- You must wait at least 1 -3 hours before printing the Transfer Premask Clearcoat

### Substrates suitable for Decal application

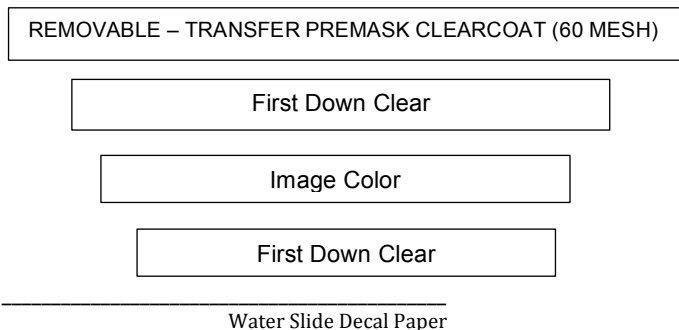
- ABS
- Glass / Ceramics
- Polycarbonate
- PVC
- Various Metals

### Application instructions

Immerse in water for 45 seconds, slide decal from waterslide paper directly onto surface to be decorated. Use a flexible rubber squeegee to remove any air bubbles from underneath decal. Force Dry at 50c for 30 minutes or air dry for 24 hours. Over baking temperature or time may cause bubbling in coatings. After drying, remove Transfer Premask Clearcoat.

### Recommended Transfer Decorating System

#### Print Schedule:



### Decal Top Coating

Graphics can be top-coated, after application and thorough dry time with the following:

- Thermoset Spraying Clears (Automotive)

## **Metallic's**

Use the Metallic Mixing Clear to prepare metallic inks. Recommended mixing ratios are:

- 20 – 25% gold pigment
- 10 – 15% silver pigment

## **Storage**

Care should be taken to store ink in tightly closed containers located in a cool (60-80°F/15-27°C) dark place. After long production runs excess ink from the screen should be properly disposed. With suitable conditions, unopened ink is expected to have a shelf life of approximately twelve (12) months from date of manufacturer.

## **Precautions**

Read the material safety data sheet prior to processing. It contains instructions for precautions to be taken when handling inks. If ink comes in contact with skin wipe off with a clean, dry cloth (do not use solvent). Wash and rinse the affected areas with soap and water.

We strongly recommend a preliminary test of printing, drying and transferring on the supports intended to use, in order to ascertain exactly the procedure, the working times and the obtained effect. **MIX WELL BEFORE USE.** Follow the directions on the package, ask for the safety data sheets and always follow the directions contained therein.

**Important** – Only the correct use of the product will allow satisfactory results. For this reason, closely related to the product supplied, Polymeric must decline all direct and indirect responsibility for the proper or improper use of the product. Make certain that product is right for the desired use, work according to the instructions given in our technical data sheets. Before use contact our Technical Service in case of doubt.

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