

3M

Roll Coat Inks

Series 4850/4950

Product Bulletin 4850/4950

April 2014

Replaces PB 4850/4950 dated May 2010

Description

3M™ Roll Coat Inks are used with 3M™ Reflective License Plate Sheetings to produce fully reflective vehicle registration plates for multi-year use. When processed according to the manufacturer's recommendations, 3M roll coat inks will last for the intended life of the registration plate. The inks are supplied in transparent colors as Series 4950 and opaque colors as Series 4850. They are intended for use on 3M™ License Plate Sheeting Series 4550/4770/4780, Series 4750, and Series 3570/3750.

Application

Transparent and opaque roll coat inks are applied to the embossed or debossed license plate by roller coating with a high quality roller coating machine. When roll coating license plates with the depressed style rim, hold down rollers are recommended to prevent the plate background from being painted. Roll coat inks may be thinned with 3M 4954 Thinner for ease of coating on the machine. DO NOT THIN MORE THAN 10%. 3M T11A Thinner has proven to be an adequate cleaning solvent. Other locally available solvents for clean up should be tested to avoid damage to the coating rolls.

Drying

Drying is best accomplished when baked for a minimum of 20 minutes at 225°F in a convection oven with good air circulation.

Contact your 3M Technical Representative for assistance in establishing time and temperature settings.

Infrared drying has been satisfactory in some license plate shops. Exact oven configurations,

time and settings are the responsibility of the license plate shop; however, all forms of drying must have sufficient exhaust to adequately remove all solvents during the drying process. Typical minimum drying conditions would be:

Minimum exposure time: 5 minutes

Maximum surface temperature: 300°F.

Colors

	Transparent Inks	Opaque Inks
Blue	4956	4856
Dark Blue	4959	4855
Red	4952	4853
Light Red	4951	—
Green	4957	4854
Dark Green	4955	—
Cranberry	4958	—
Purple	—	4857
Black	—	4852
White	—	4850

Health and Safety Information

Read all health hazard, precautionary, and first aid statements found in the Material Safety Data Sheet, and/or product label of chemicals prior to handling or use.

Storage

3M roll coat inks should be stored at general warehouse storage (16°C/60°F to 27°C/80°F). The inks have a shelf life of 12 months from customer receipt.

FOR INFORMATION OR ASSISTANCE

**CALL:
1-877-777-3571**

**IN CANADA CALL:
1-800-265-1840**

**Internet:
www.3M.com/mvss**

3M assumes no responsibility for any injury, loss or damage arising out of the use of a product that is not of our manufacture. Where reference is made in literature to a commercially available product, made by another manufacturer, it shall be the user's responsibility to ascertain the precautionary measures for its use outlined by the manufacturer.

Important Notice

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