



TWN TECHNICAL BULLETIN

08/2011

Subject: PART NUMBERS - FILM, INKS AND ACTIVATORS

Summary

This Technical Bulletin has been issued due to customer inquiries asking for a legend to the TWN part number. Additionally, processors are asking for a recommendation as to which activator to use with each different ink. This part number legend and film guide with recommended activators has been produced to meet the need.

Shop Procedure

Check your film's TWN part number to determine what type of ink your film was printed with and to determine the recommended activator. Always pack film back into the original sleeve to retain the correct part and lot numbers.

Label Example - Located on clear plastic sleeve that film is packed into

DESCRIPTION		QUANTITY
WTP 338-50CFNB40AC		125M
LOT NUMBER	PRODUCTION DATE	
101105A301	10-11-05	
Storage temperature conditions: 68°F - 77°F		
*Store film below 60% humidity		
T.W.N. Industries, Inc.		(305) 258-9622

The WTP part number can be broken down into seven (7) key segments.

Take WTP338-50CFNB40AC as an example.

① WTP 338 ② 50, 51, 60, 80, 100 ③ SP, CF ④ NB, WB, SB, GB ⑤ 30, 40 ⑥ A, B ⑦ A, B, C

① Pattern number: Includes WTP plus a three digit identification code such as 338 in this example

② Film Width: This is measured in centimeters

③ Film Format: SP - static printing film designed to float on water for approximately 1 minute before spraying activator, or CF - continuous flow film designed for automated equipment where activator is applied prior to film going on the water. *Continuous flow film can be used as static printing film, just allow 2 minutes on water before spraying activator.

④ Backing: This is a backing color sometimes used to enhance or add backing highlights to the pattern. Stated as NB - No Backing, WB - White Backing, SB - Silver Backing, GB - Gold Backing

⑤ Film Thickness: Stated in microns, 30 for static printing film or 40 for continuous flow film

⑥ PVA Type: Stated as A for our original formula or B for a new formulation where additional surface tension and elasticity is required

⑦ Ink Type:

A inks: The original formulation and still widely used. A inks contain a favorable level of UV stability. The recommended activator for A inks is 3-3502.

B inks: Recommended for outdoor products, automotive interior trim parts, ATVs and UTVs etc. B inks are highly UV and fade resistant. Specially formulated to meet manufacturers Xenon Arc ASTM G155A test standards. 3-3502 is the primary activator for B ink, but we can report that the NJM2010SPC works well too and in some cases is providing better results.

C inks: Provide more surface tension and offer a greater level of elasticity when processing parts with deep draws. Bright vivid colors tend to hold their saturation levels better when expanding. For best results, NJM2010SPC activator is recommended for C inks.
