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THE BEST PRACTICE GUIDE TO:

PIPE MARKING

Brought to You by Your Label & Sign Professionals!



Your #1 Source for Industrial Identification & Communication Solutions!

GUIDE DESCRIPTION

This guide is intended to provide the best pipe marking¹ practices so as to meet all codes and maximize the effectiveness of the communication of information using pipe markers.

If you should need further assistance after reviewing this best practice guide, please contact one of our knowledgeable customer service representatives at 1-800-788-5572.

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¹The words “pipe marker/marking” and “label” will be used interchangeably.

1. TOOLS

The recommended tools and equipment involved with this labeling project include:

- Schematic of facility's pipe system
- Computer with Windows Operating System (*Win 2000 and above*)
 - Word processing software (*MS Word, Open Office Document, etc*)
 - Optional
- Laptop (for portability)
- DuraLabel PRO Printer² (<http://www.duralabel.com>)
 - DuraLabel PRO library of symbols, templates, and examples
 - Optional
- DuraLabel PRO battery (*for portability*)
- DuraLabel PRO supplies (<http://www.duralabel.com>)
 - Tape (*size of tape dependent on size of pipe*)
- Various sizes (*size dependent on size of pipe*)
- Yellow, Green, Blue, Red, Brown, Orange
- Thermal transfer ribbon
- Black, White
- Optional
- DuraLabel PRO OSHA & Pipe Marking Package
- Pipe Grabber™ sleeves
- Cold storage vinyl
- Reflective tape
- MBX Vinyl Zapper
- Supplies and equipment to clean and prepare pipe for labeling.



2. EVALUATION OF FACILITY

As defined by the ASME/ANSI A13.1 – 2007 standard, a 'pipe' is a conduit used to convey, distribute, mix, separate, discharge, meter, control, or snub fluid flows. A pipe system includes piping of any kind including fittings, valves, and pipe coverings.

The addendum (**pg. 9**) to this guide provides an inspection form you can use to record the results of your inspection.

When evaluating your facility, look for and/or pay attention to:

- Existing pipe markers.
- Are they still legible? (*Damaged, deteriorated, etc...*)
- Are they accurate? (*Name, flow, label color*)
- Pipes with missing pipe markers.
- New equipment.
- Are there new pipes that redirect contents to/from new equipment?
- Areas where maintenance is performed.
- Traffic areas.

² Although other industrial quality printers may be used, the DuraLabel PRO is a popular thermal transfer printer proven to make effective pipe markers. The DuraLabel PRO is a high productivity printer that creates long-lasting DuraLabel PRO pipe markers. The descriptions given in this guide use the DuraLabel PRO.

Although the ASME/ANSI standard suggests labeling all pipes, it is required for pipes to be labeled in the following situations:

- The contents of pipes could affect procedures during emergency situations.
- The contents of pipes are hazardous.
- The flow direction is unknown.
- The destination of the contents is unknown.
- The flow needs to be redirected for maintenance.
- One or more valves need to be shut off for maintenance.

In conducting your inspection, use a pipe schematic and piping drawings to plan your inspection. Be sure to consult your facility’s pipe schematics to ensure accurate labeling of contents and direction of flow.

The content of a pipe determines the color scheme of the pipe marker. See **Table 1** to ensure existing pipe markers are standard compliant. If not, they should be replaced.

Table 1 (Colors)

Fluid Service	Background Color	Letter Color
Fire Quenching Fluids	Red	White
Toxic & Corrosive Fluids	Orange	Black
Flammable Fluids	Yellow	Black
Combustible Fluids	Brown	White
Potable, Cooling, Boiler Feed, and other water	Green	White
Compressed Air	Blue	White

The size of the pipe marker is also an important factor. Properly sized labels will allow personnel to read the labels at a reasonable distance. See **Table 2** to ensure existing pipe markers are standard compliant. If not, they should be replaced.

Table 2 (Sizes)

Outside Pipe Diameter Including Covering		Minimum Length of Label Field Color		Minimum Height of Letters	
0.75" - 1.25"	19 - 32 mm	8"	203 mm	0.5"	13 mm
1.5" - 2"	38 - 51 mm	8"	203 mm	0.75"	19 mm
2.5" - 6"	64 - 152 mm	12"	305 mm	1.25"	32 mm
8" - 10"	203 - 254 mm	24"	610 mm	2.5"	64 mm
Over 10"	Over 254 mm	32"	813 mm	3.5"	89 mm

NOTE: Pipes too small for labels should be marked with a hanging tag.

Use the Addendum (pg. 9) at the end of this guide to help in determining the color, size, and quantity of labels needed.

The following table provides a list of standard abbreviations that may be used on pipe markers. Abbreviations should only be used to make the message easier to read and when it is not practical to write out the entire word or phrase.

Standard Abbreviations:

ABED	Aux. Building Equip. Drains
ABEDT	Aux. Building Equip. Drain Tank
ABFD	Aux. Building Floor Drain
ABFDT	Aux. Building Floor Drain Train
ACB	Air Circuit Breaker
ACK	Acknowledge
ACT	Actuate
ADJ	Adjust
AFW	Auxiliary Feedwater
ALM	Alarm
AMB	Ambient
ANAL	Analyzer
AO(V)	Air Operated (Valve)
AVG	Average
BA	Boric Acid
BAR	Bar Graph
BAT	Boric Acid Tank / Battery
BATT	Battery
BIST	Bistable
BIT	Boron Injection Tank
BKR	Breaker
BLOC	Block
BOP	Balance of Plant
BTM	Bottom
BTU	British Thermal Unit
BUP	Backup
C	Centigrade (aka. Celsius)
C/CB	Condensate / Cond. Booster
C1M	Cumulative One Minute
CAB	Cabinet
CAL	Calibration / Calorie
CAUS	Cause
CCW	Component Cooling Water / Closed Cooling Water
CD	Condensate
CDB	Condensate Booster
CDT	Chemical Drain Tank
CHAM	Chamber
CHAN	Channel
CHNG	Change
CHRG	Charging
CJB	Cold Junction Box
CKT	Circuit
CL	Cold Leg
CLNG	Cooling
CMPT	Computed
CNMT	Containment

COM	Common
COMP	Component
CONC	Concentration
COND	Condenser / Condensate
CONDTY	Conductivity
CONT	Controller
CONT ROD	Control Rod
CONTR	Control
COR	Correction
CORR	Correlation
COUNT	Count
CPM	Counts Per Minute
CPU	Central Processing Unit
CPUS	Central Processing Units
CR	Control Room
CROM	Control Rod Drive Mechanism
CS	Containment Spray
CSR	Cable Spreading Room
CST	Condensate Storage Tank
CUMLT	Cumulative
CW	Circulating Water
CW PP	Circulating Water Pump
CYL	Cylinder
D/G	Diesel Generator
DEG	Degrees
DEMIN	Demineralizer
DET	Detector
DEV	Deviation
DIV	Division
DO	Diesel Fuel Oil
DOT	Dirty Oil Tank
DSCH	Discharge
DT	Delta Temperature
ECCS	Emergency Core Cooling Sys.
EDT	Equipment Drain Tank
EFCT	Effect
EFLNT	Effluent
EHC	Electro Hydraulic Control
ELEC	Electrical
EQ	Equipment
EQUIP	Equipment
ES	Extraction Steam
ESF	Engineered Safety Feature
ESS	Essential Service
EXH	Exhaust / Exhauster
EXPANS	Expansion
EXTR	Extracted Extractor / Extraction

F	Fahrenheit
FCV	Flow Control Valve
FD	Forced Draft
FH	Fuel Handling
FLW	Flow
FO	Fuel Oil
FREQ	Frequency
FRNT	Front
FW	Feed Water
GOV	Governor
GPM	Gallons Per Minute
GRP	Group
GSC	Gland Steam Condenser
GV	Governor Valve
HG(A)	Mercury (absolute)
HGHT	Height
HIDP	High Differential Pressure
HL	Hot Leg
HOV	Hydraulic Operated Valve
HP	High Pressure
HR(S)	Hour
HRSS	High Radiation Sampling System
HT RT	Heat Rate
HTNG	Heating
HU/CD	Heatup/Cooldown
HUT	Hold up Tank
HYD	Hydraulic
I/P	Current to Pressure
I/V	Current to Voltage
IA	Instrument Air
ID	Identification / Inside Diameter
INBO	Inboard
INC	Increase
INF	Influent
INIT	Initial
INL	Inlet
INSERTIN	Insertion
INST	Instrument / Instantaneous
INT	Internal
INTERM	Intermediate
IOD	Iodine
ISOL	Isolation
JUNCT	Junction
K	Kilo

LNG	Long / Liquefied Natural Gas
LO FLW	Low Flow
M/G	Motor Generator Sets
MAINT	Maintenance
MAX	Maximum
MCR	Main Control Room
MFP	Main Feed Pump
MIN	Minutes / Minimum
MOIST	Moisture
MPH	Miles Per Hour
MPS	Miles Per Second
MS	Main Steam / Moisture Separator
MSIV	Main Steam Isolation Valve
MSR	Moisture Separator Reheater
MTR	Motor
MU	Makeup
MVBL	Moveable
NAOH	Sodium Hydroxide
NAR	Narrow
NAR RNG	Narrow Range
NBL	Noble
NEG	Negative
NEUT	Neutron
NIS	Nuclear Instrumentation System
NR	Narrow Range
NUC	Nuclear
OG	Off-Gas
OOS	Out of Service
OP	Over Pressure
OPER	Operator / Operating
OT	Over Temperature
OT-OP	Over Temp-Over Pressure
OUT	Output
OUTBD	Outboard
OUTLT	Outlet
OVERLD	Overload
OVERTEMP	Over Temperature
OVRPWR	Overpower
PART	Partial
PARTIC	Particulate
PCT	Percent
PCV	Pressure Control Valve
PENET	Penetration
PMG	Permanent Magnet Generator
PNEU	Pneumatic
PORV	Power Operated Relief Valve

POS	Positive
POST	Position
POT	Potentiometer
PPB	Parts per Billion
PPM	Parts per Million
PR58	Process Radiation Monitor 58
PREAMP	Preamplifiers
PRG	Purge
PRI	Primary
PROC	Process
PRT	Pressurizer Relief Tank
PS	Power Supply
PSI	Lbs Per Square Inch
PSIA	Lbs Per Square Inch Absolute
PSIG	Lbs Per Inch Gauge
PSIO	Lbs Per Square Inch Differential
PT	Point
PTL	Pull-To-Lock
PUL	Pulverizer
PW	Primary Water
PWR RNG	Power Range
PZR	Pressurizer Relief Tank
RC	Reactor Coolant
RCDT	Reactor Coolant Drain Tank
RCFC	Reactor Containment Fan Cooler
RCL	Reactor Coolant Loop
RCS	Reactor Coolant System
RDT	Reheater Drain Tank
RECOMB	Recombiner
REGEN	Regenerative
REL	Relative
RESID	Residual
RH	Residual Heat
RHR	Residual Heat Removal
RHT	Reheat
RLY	Relay
RNG	Range / Running
ROC	Rate of Change
RTD	Resistance Temp. Detector
RTN	Return
RVLIS	Reactor Vessel Level Indication System
RW	Radwaste
RWST	Refueling Water Storage Tank
S/G	Steam Generator
SA	Service Air
SB	Service Building

SEC	Second
SEL	Select
SEP	Separator
SERV	Service
SFP	Service Fuel Pump
SGTR	Steam Generator Tube Rupture
SI	Safety Injection
SPEC	Specification
STDY	Steady
STNBY	Standby
STOR	Storage
SUPPR	Suppressed
SUPRESS	Suppression
SW	Service Water / Switch
SWST	Secondary Water Storage Tank
T/C	Thermocouples
TAMB	Temperature Ambient
TAVG	Average Temperature
TB	Turbine Building / Terminal Box/Block
TC	Cold Leg Temperature
TCV	Temperature Control Valve
TD	Turbine Drain
THER	Thermal
THRT	Throttle
THST	Thrust
TOT	Total
TREP	Reference Temperature
TRNA	Train A (B, C, etc.)
TRNSNT	Transient
TRP	Trip
TTD	Terminal Temp. Difference
TURBS	Turbines
UNCONT	Uncontrolled
VAC	Vacuum
VALS	Values
VAP	Vapor
VAR	Variance
VCT	Volume Control Tank
VIB	Vibration
VNT	Vent
VOL	Volume
WR	Wide Range
XFR	Transfer
XMTR	Transmitter

3. LABEL CREATION

Needed Equipment and Supplies

There is more than one option for obtaining the needed pipe markers. If only a small number of pipe markers are needed, and there is no rush to have them applied, pipe markers can be ordered online or from local sign and label stores. However, if more than just a few labels are needed, it is more economical to get a label printer, such as the DuraLabel PRO, and make customized labels as needed.

To make getting started easy, DuraLabel PRO offers an OSHA & Pipe Marking Package that provides all of the commonly used pipe labeling materials.

The DuraLabel PRO OSHA & Pipe Marking Package includes:

- DuraLabel PRO Printer (*software and templates included*)
- 2" Blue 3.0 mil vinyl
- 2" Orange 3.0 mil vinyl
- 2" Green 3.0 mil vinyl
- 2" Red 3.0 mil vinyl
- 2" Yellow 3.0 mil vinyl
- 2" White 3.0 mil vinyl
- 4" Blue 3.0 mil vinyl
- 4" Orange 3.0 mil vinyl
- 4" Green 3.0 mil vinyl
- 4" Red 3.0 mil vinyl
- 4" Yellow 3.0 mil vinyl
- 4" White 3.0 mil vinyl
- 4.3" White Resin Ribbon
- 4.3" Black Resin Ribbon



This is the standard package. However **this package can be customized** based on the type of pipes that need to be labeled.

Some of the special supplies that are available include:

- Cold storage supply vinyl – Adhesive will stick on cold surfaces.
- 2.0 mil vinyl – A more flexible label than the 3.0 mil vinyl.
- Sign blanks – For hot pipe labeling where vinyl adhesive won't function.
- Reflective tape – For low light settings.

Label Creation Steps (with the DuraLabel PRO)

Design the required pipe labels with a familiar word processor, such as Microsoft Word or Open Office Document. The included Software CD comes with pre-made MSWord templates and examples. The DuraLabel PRO printer can print on supplies up to 4" wide.

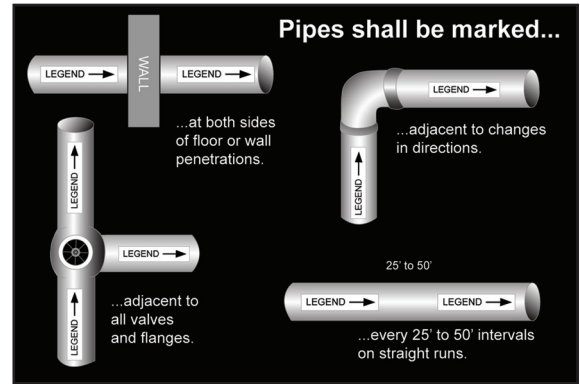
1. See **Table 2** to determine the size of label and letters and adjust page format accordingly.
2. Type out text in a sans-serif font in capital letters.
3. From the DuraLabel PRO symbols library, insert arrow to indicate direction flow of pipe contents.
4. See **Table 1** to determine the appropriate colored labeling tape and ribbon. Load the DuraLabel PRO printer accordingly.
5. Print the label.

4. LABEL PLACEMENT

Labels should always be applied to clean, dry surfaces.

Pipe markers should be placed:

- To indicate direction of flow by labeling with arrows at one or both ends.
- So as to be visible from the point of normal approach.
- At any line entry or re-entry point.
- Near valves, flanges and changes in pipe direction.
- At both sides of ceiling, wall or floor penetrations.
- At least once every 50 feet on straight pipe runs.



Special Conditions:

- If pipeline is located **above** the normal line of vision, the label shall be placed below the horizontal center line of the pipe to maximize visibility.
- If pipeline is located **below** the normal line of vision, the label shall be placed above the horizontal center line of the pipe to maximize visibility.
- Use Pipe Grabber™ Sleeves when:
 - Pipe is too dirty and cannot be cleaned.
 - Pipes are too hot.
 - Labels won't adhere due to the pipe being covered with rust, scale, un-lagged insulation, etc.

Removing Old Labels



Most labels are meant to be permanent and are extremely tough to remove. When applying new pipe markers, it may be necessary to remove older labels. The MBX Vinyl Zapper easily removes vinyl, decals, reflective tape, and adhesives in a single operation using an Eraser Wheel. The Eraser Wheel is designed with notched rubber fingers that grab edges of vinyl to peel away from surfaces without damaging underlying OEM paint, or other substrate material.

By changing wheels, the MBX Vinyl Zapper can be used for other applications, such as cleaning and preparing surfaces for new labels.

MBX Vinyl Zapper applications:

- Remove vinyl, decals, reflective tape, and adhesive with no paint damage.
- Remove crud, concrete, debris, and waste from industrial, manufacturing or construction operations.
- Remove corrosion, oxidation, rust, and scale without damaging material beneath.
- Remove paint, protective coatings, and sealers.
- Remove soft and gummy materials without clogging.
- Remove slag and weld burn.
- Decontaminate metal surfaces.
- Create textured surfaces from sharp, angular profiles to smooth finishes.
- Feather new coatings into existing coating.
- Roughen fiberglass, plastic, or rubber surfaces for repair or bonding.
- Clean contours, nooks, and crannies, bolt threads, sharp edges, and uneven surfaces.

5. LABEL MAINTENANCE

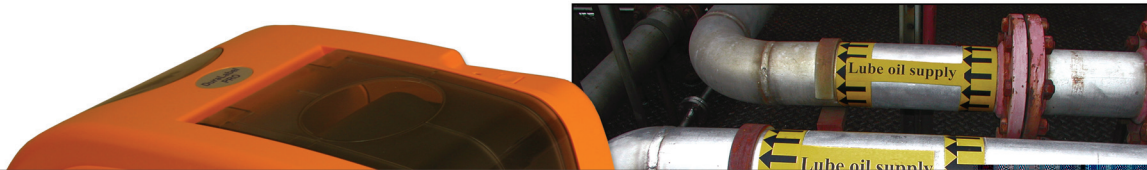
Labels should be properly maintained to ensure legibility and readability. Under normal conditions labels will last 5-7 years. Environmental conditions can result in a shorter or longer life.

Labels should be inspected on a periodic basis and replace any that are missing or have deteriorated beyond legibility. Accumulation of debris, grease, oil, or other materials should be cleaned off.

Pipe Markers are only useful if they are visible. **DuraLabel PRO supplies are chemical resistant** and solvents and cleaning agents may be used when necessary to clean off dirt, grime, oil, etc...

If cleaning is not possible and label is not readable, replace the existing label with a new one. DuraLabel PRO pipe markers are designed to be permanent. Should the need to remove a pipe marker ever arise, a Vinyl Zapper can be used to remove the label.

Set up a schedule to reevaluate your facility. Refer to the “Evaluation of Facility” section of this guide for help.



The DuraLabel PRO is a high speed thermal transfer printer that quickly, efficiently, and economically prints

the pipe marker labels you need. Call 1-800-788-5572

for more information or visit www.DuraLabel.com

DISCLAIMER: This guide is for general purposes only. It is not a substitute for review of applicable standards.

7. PIPE MARKING GUIDE

The following Pipe Marking Guide, offered by Graphic Products to aid in properly customizing pipe markers, complies with the **ASME A13.1 - 2007 Standard for the Identification of Pipes**.

COLOR CODE

Material Properties	Letter color on Field color	Example
FLAMMABLE Fluids which are a vapor or produce vapors that can ignite and continue to burn in air.	Black on Yellow	→ HYDROGEN →
COMBUSTIBLE Fluids that may burn but are not flammable.	White on Brown	→ ACETIC ACID →
TOXIC & CORROSIVE Fluids which are corrosive or toxic or will produce corrosive or toxic substances.	Black on Orange	→ NITRIC ACID →
FIRE QUENCHING Water and other substances used in sprinkler fire fighting piping systems.	White on Red	→ HALON →
OTHER WATER Any other water except for water used in sprinkler & fire fighting piping systems.	White on Green	→ BOILER WATER →
COMPRESSED AIR Any vapor or gas under pressure that does not fit a category above.	White on Blue	→ COMPRESSED AIR →
DEFINED BY USER	White on Black	→ DEFINED BY USER →
DEFINED BY USER	Black on White	→ DEFINED BY USER →
DEFINED BY USER	White on Purple	→ DEFINED BY USER →
DEFINED BY USER	White on Gray	→ DEFINED BY USER →

PIPE MARKER SIZE CHART

Letter & Label Dimensions in accordance to pipe diameter

NOTE:

It is recommended that pipes less than .75" in diameter, be labeled with a permanent tag.

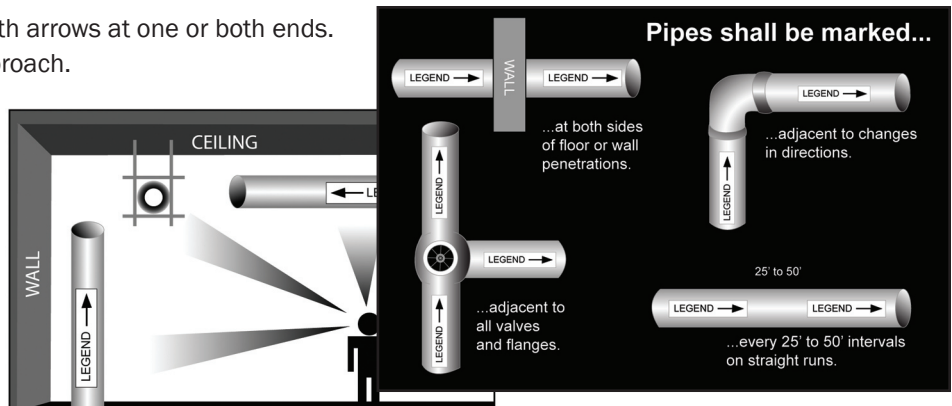
Outside Pipe Diameter Including Covering		Minimum Length of Label Field Color		Minimum Height of Letters	
.75" - 1.25"	19 - 32 mm	8"	203 mm	.5"	13 mm
1.5" - 2"	38 - 51 mm	8"	203 mm	.75"	19 mm
2.5" - 6"	64 - 152 mm	12"	305 mm	1.25"	32 mm
8" - 10"	203 - 254 mm	24"	610 mm	2.5"	64 mm
Over 10"	Over 254 mm	32"	813 mm	3.5"	89 mm

PLACE MARKERS:

- ◆ To indicate direction of flow by labeling with arrows at one or both ends.
- ◆ To be visible from the point of normal approach.
- ◆ Near valves, flange and changes in pipe direction.
- ◆ Both sides of ceiling, wall or floor penetrations.
- ◆ At any line entry or re-entry point.
- ◆ On straight pipe runs.
- ◆ Every 50 feet is typical.

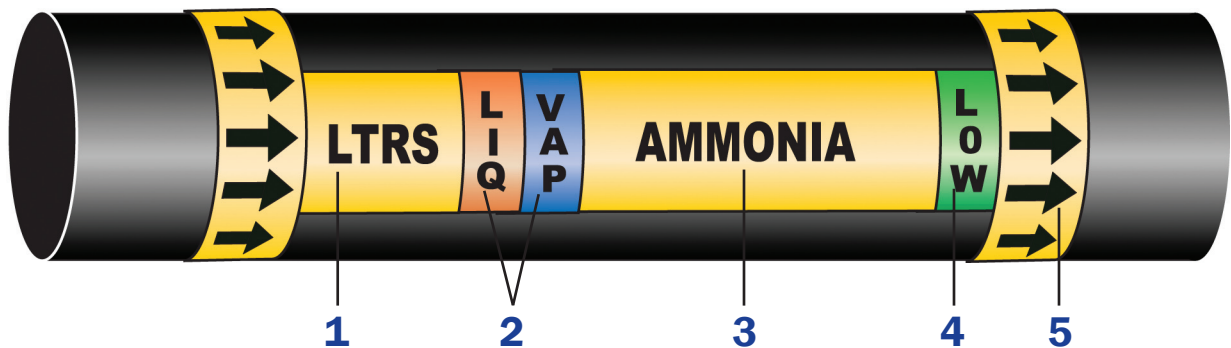
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8. AMMONIA REFRIGERATION SYSTEM PIPE MARKING GUIDE

The following Pipe Marking Guide, offered by Graphic Products to aid in properly customizing pipe markers, complies with the **IIAR (International Institute of Ammonia Refrigeration) Standards**.



1. ABBREVIATIONS

Abbreviations for Ammonia System Components

ABBREVIATION	SYSTEM
BD	Booster Discharge
CD	Condenser
DC	Defrost Condensate
ES	Economizer Suction
HGD	Hot Gas Defrost
HPL	High Pressure Liquid
HSD	High Stage Discharge
HSS	High Stage Suction
HTRL	High Temperature Recirculated Liquid
HTRS	High Temperature Recirculated Suction
LIC	Liquid Injection Cooling
LSS	Low Stage Suction
LTRL	Low Temperature Recirculated Liquid
LTRS	Low Temperature Recirculated Suction
RV	Relief Vent
TSR	Thermosyphon Return
TSS	Thermosyphon Supply

2. PHYSICAL STATE

LIQ - Liquid - Black or white printed on orange
VAP - Vapor - Black or white printed on blue
LIQ/VAP - Use both if both states exist

PHYSICAL STATE	PRESSURE LEVEL
VAP	LOW
LIQ	HIGH
LIQ	HIGH
VAP	LOW
VAP	HIGH
LIQ	HIGH
VAP	LOW
LIQ	LOW
LIQ/VAP	LOW
LIQ	HIGH
VAP	LOW
LIQ	LOW
LIQ/VAP	LOW
VAP	HIGH
LIQ/VAP	HIGH
LIQ	HIGH

4. PRESSURE LEVEL

HIGH Pressure - Black or white printed on red
LOW Pressure - Black or white printed on green

3. MARKER BODY

"AMMONIA" printed in black on yellow

5. FLOW DIRECTION

Direction of flow of the system contents is indicated by the arrows. Place arrows at one or both ends.

PIPE MARKER SIZE CHART

Outside Pipe Diameter Including Covering	Minimum Length of Label Field Color	Minimum Height of Letters
.75" - 1.25" (19 - 32 mm)	8" (203 mm)	.5" (13 mm)
1.5" - 2" (38 - 51 mm)	8" (203 mm)	.75" (19 mm)
2.5" - 6" (64 - 152 mm)	12" (305 mm)	1.25" (32 mm)
8" - 10" (203 - 254 mm)	24" (610 mm)	2.5" (64 mm)
Over 10" (Over 254 mm)	32" (813 mm)	3.5" (89 mm)

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VALVE TAG & PIPE MARKING TOOLS

DuraLabel PRO, The Smart Choice

It is important that signs and labels are legible, strategically placed to be seen clearly and easy to understand. It is critical to follow OSHA's standards of compliance for the health and safety of everyone at your facility.



Whether you need valve tags, pipe markers or general OSHA safety signs, the DuraLabel PRO does it all! And at huge savings compared to other labeling systems. The included templates make printing pipe markers and valve tags a snap. You can also print directly from popular software packages such as EasyPower, SKM and others.



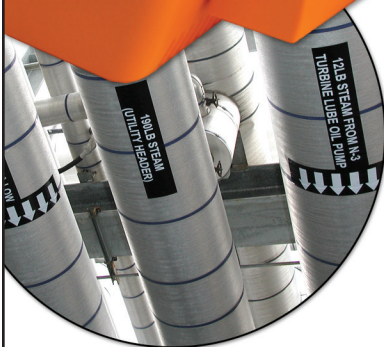
Pipe Grabber™ Sleeves



Pipe Grabber™ Sleeves provide a clean surface for labeling dirty, oily, or rusty pipes. Just print a label, apply it to the sleeve, then place the sleeve around the pipe. (Shown above)

Pipe Markers

The DuraLabel PRO is great for making pipe markers for any type of facility, from restaurants to refineries.



Valve Tags

Inexpensive custom valve tags are fast and easy to create. Our valve tags are extremely durable and long-lasting for a uniform and professional appearance throughout your entire facility.

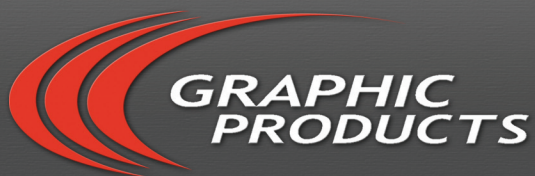


DuraTag™ Stock

This heavy-duty UV-stabilized material is resistant to tears, moisture, chemicals, and extreme cold, making it ideal for indoor and outdoor use. Print in color with the DuraLabel PRO ribbon.



For more information please visit www.DuraLabel.com or call 1-800-788-5572



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