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 |   |   |   | **PO Box 86  317 Vance St.** |
|   |   |   |   | **Forest City, NC 28043** |
|   |   |   |   | **Phone: 1-800-433-INKS** |
|   |   |   |   | **Fax: 828-247-0705** |
|   |   |   |   |   |   |
|   |   |   |   |   |   |
|   |  ***TECH-TALK*** |  |   |   |   |
|   |   |   |   |   |   |
| **PRODUCT NAME:** | Film SP Ink System |   |   |   |
|   |   |   |   |   |   |
| **DESCRIPTION:** | High Strength System with excellent adhesion to various Films that is |
|   | designed to be overprinted or laminated. |   |   |
|   |   |   |   |   |   |
|   |   |   |   |   |   |
| **SUBSTRATES:** | Film, Foils, and Paper |   |   |   |
|   |   |   |   |   |   |
| **PROPERTIES:** |   |   |   |   |   |
|   |   |   |   |   |   |
| ***VISCOSITY:*** | 16 - 32" #3 Zahn |   |   |   |   |
|  |   |   |   |   |   |
| ***pH:*** | 8.8 - 9.4 |   |   |   |
|  |   |   |   |   |   |
| ***RUN SPEED:*** | 100 - 300 FPM |   |   |   |
|  |   |   |   |   |   |
| ***HEAT RESISTANCE:*** | Not Recommended |   |   |   |
|  |   |   |   |   |   |
| ***LIGHT FASTNESS:*** | Available in Lightfast and Non-lightfast |   |   |
|  |   |   |   |   |   |
| ***WATER RESISTANCE:*** | Very Good to excellent |   |   |   |
|  |   |   |   |   |   |
| ***REDUCERS:*** | Blend 98/2, water/pH |   |   |   |
|  |   |   |   |   |   |
| ***ANILOX:*** | Solids 400-600 line, Process 800-1200 line |   |   |
|  |   |   |   |   |   |
| ***DOCTOR BLADE:*** | Recommended |   |   |   |
|  |   |   |   |   |   |
| ***METER BALL:*** |   |   |   |   |   |
|  | 50-75 durometer roller |   |   |   |
|  |   |   |   |   |   |
| ***DRYING CAPABILITIES:*** |   |   |   |   |   |
|  | Medium to Hot Forced Air volume |   |   |
|  |   |   |   |   |   |
| **PRESS SIDE PROCEDURES** |  |   |   |
|   |   |   |   |   |   |
|   |   |   |   |   |   |
|  |   |   |   |   |   |
| *Pour ink into pan straight. Start press and pull up color to determine strength. If color strength* |
| *needs adjusting, we recommend changing anilox before adjusting ink.* |   |   |
|  |   |   |   |   |   |
| *If color pulls up strong and you want to reduce, use blend of 98/2, water/pH adjuster.* |   |
|  |   |   |   |   |   |
| *Extend color using AWG-0252V Film SP Transparent White.* |   |   |
|  |   |   |   |   |   |
| *Propylene Glycol can be added up to 5% by weight for slower press speeds.* |   |
|  |   |   |   |   |   |
| *If higher press speeds are needed, use a blend of water/alcohol. Keep in mind that using this* |
| *blend will lower your pH. So, check you pH after each add and raise as needed.* |   |
|  |   |   |   |   |   |
|  |   |   |   |   |   |
|  |   |   |   |   |   |
| **END USE RESTRICTIONS** |  |   |   |
|  |   |   |   |   |   |
|  |   |   |   |   |   |
|  |   |   |   |   |   |
| ***NOT INTENDED FOR USE IN THE FOLLOWING APPLICATIONS:*** |  |  |
|  |  |  |  |  |  |
| ***WET APPLICATIONS WHICH INCLUDE -*** |  |  |  |
|  |  | *Steam* |  |  |  |
|  |  | *Autoclave* |  |  |  |
|  |  |  |  |  |  |
|  |  |  |  |  |  |
|  |  |  |  |  |  |
|  |  |  |  |  |  |
| ***LIGHTFASTNESS -*** |  | *N/A* |  |  |  |
|  |  |  |  |  |  |
|  |  |  |  |  |  |
|  |  |  |  |  |  |
| ***HEAT RESISTANT -*** |  | *Up to 300*º *Fahrenheit* |  |  |  |
|  |  |  |  |  |  |
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|  |  |  |  |  |  |
|  |  |  | *02/23/15* |  |  |
|  |  |   |  |  |  |
| *John M. Ruppe, Jr. - President* |   | *Date:* |  |  |
|  |  |  |  |  |  |