

SOP Processing Conditions for Leather Match Topcoat TUC1164R/TUC1395 Dull Leather Match

Ingredients:

- TUC1164R Dull Leather Match or TUC1395 Dull Leather Match
- Dilution Solvent (100% IPA)

I. MIXING PROCEDURE - INK ROOM

	Percent	Lbs.
Rework Topcoat Formula:		300
New Topcoat	80%	240
Rework Topcoat	20%	60
TOTAL		300

Mixing Procedure:

1. Mix the above Topcoat Formula and Dilution Solvent for 30 minutes and check viscosity
2. Add dilution solvent to reduce viscosity to 13-15 seconds #3 Zahn
3. Mix for 15 minutes

II. PRINT MACHINE - OPERATING CONDITIONS

Print Machine Conditions:

1. #1 Roll 95Q
2. #2 Roll 120Q
3. Flush all lines with IPA prior to introducing topcoat
4. Flush topcoat through all lines to flush out any residual IPA
5. **Must recirculate topcoat throughout the production run!**
6. **Must mix topcoat throughout the production run!**
7. Viscosity range: 13-15 seconds #3 Zahn
8. Speed: Standard Speed
9. Oven: Standard Oven Conditions



SOP Processing Conditions for Leather Match Topcoat TUC1164R/TUC1395 Dull Leather Match (contd)

III. PRINT MACHINE - END OF RUN

PRINT MACHINE CONDITIONS:

1. **#1 Roll 95Q**
2. **#2 Roll 120Q**
3. Flush all lines with IPA prior to introducing topcoat
4. Flush topcoat through all lines to flush out any residual IPA
5. **Must recirculate topcoat throughout the production run!**
6. **Must mix topcoat throughout the production run!**
7. Viscosity range: 13-15 seconds #3 Zahn
8. Speed: Standard Speed
9. Oven: Standard Oven Conditions

HANDLING AND STORAGE OF REMAINING TOPCOAT:

1. At the end of the run, drain the pan of topcoat into the drum
2. Reduce viscosity to 15 seconds #3 Zahn with 100% IPA
3. Seal drum for next run

CLEAN-UP:

Clean rolls, pans, and lines with 100% and discard the dirty solvent.

DO NOT PUT DIRTY SOLVENT INTO TOPCOAT.

