

SOP Processing Conditions for TUC1388R/TUC1389R with TUC1387 XLinker

SRT Denim Topcoat - 2nd Station

[Must be used in conjunction with Dull PU Primer TUC1386]

Ingredients:

- TUC1388R Dull SRT - Denim Stain Resistant Topcoat
- TUC1389R Gloss SRT - Denim Stain Resistant Topcoat
- TUC1387 Cross Linker
- Topcoat Dilution Solvent (80% MEK // 20% IPA)

I. MIXING PROCEDURE - INK ROOM

	Percent	Lbs.
Primer Formula:		300
TUC1388R Dull/TU-C1389R Gloss Denim Resist SRT	93%	279
TUC1387 Cross Linker	7%	21
Dilution Solvent	0%	0
TOTAL		300

Mixing Procedure:

1. Mix the topcoat and crosslinker per the above Topcoat Formula for 45 minutes and check viscosity
2. Add Topcoat Dilution Solvent to bring the viscosity down to 15 seconds #3 Zahn
3. Mix for an additional 15 minutes
4. Repeat Steps 2 and 3 if necessary until viscosity holds at 15 seconds #3 Zahn
5. When viscosity holds, cap the drum
6. ****Take sample to lab for pre-check of stain test.**
7. Must be approved prior to taking drum to Print Machine
8. When approved, take drums(s) to Print Machine



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II. PRINT MACHINE - OPERATING CONDITIONS

PRINT MACHINE CONDITIONS:

- **When you run a color check sample, put a piece in a lab oven at 300°F for 60 seconds and check stain test. If test does not pass, DO NOT RUN. Alert supervisor/technical.**
- Use TUC1386 Dull PU Primer on Print Roll 120Q (1st Station) - adjust viscosity of primer with 100% IPA to 13-15 sec #3 Zahn
- Print Roll 95 Line (2nd Station) - Use TUC1388 Dull/TUC1389 Gloss SRT Topcoat Crosslinked - Viscosity must be 13-15 sec #3 Zahn - adjust viscosity with Topcoat Dilution Solvent (80% MEK, 20% IPA)
- Flush all lines with IPA prior to introducing PU Primer
- Flush PU Primer through all lines to flush out any residual IPA
- Recirculate and mix PU Primer throughout the production run - Recheck viscosity and maintain at 13-15 sec #3 Zahn. Supervisor will indicate frequency of recheck.
- On a long run, maintain at least ½ drum at all times - add fresh material. At the end of a long run or for a short run, make only the amount required for the run.
- Speed: 25-30 YPM
- At the end of the run, reduce viscosity to 15 seconds #3 Zahn with 100% IPA and seal drum.

III. PRINT MACHINE - END OF RUN

HANDLING AND STORAGE OF REMAINING TOPCOAT:

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

QC TEST:

Check IPA Cleaning at end of print machine. Must clean permanent marker with 100% IPA. If it does not clean, slow down speed to increase temperature and dwell time.