

SOP Processing Conditions Ultra-Clear High-Abrasion Topcoat for Double Polished Clear TUC1354M2 with TUC1338R XLinker

Ingredients:

TUC1354M2 Ultra-Clear High-Abrasion Topcoat
TUC1338R Cross Linker
Topcoat Dilution Solvent (80% MEK // 20% IPA)

I. MIXING PROCEDURE - INK ROOM

| | Percent | Lbs. |
|---|---------|------------|
| Primer Formula: | | 300 |
| TUC1354M2 Ultra-Clear High-Abrasion Topcoat | 84% | 252 |
| TUC1338R Cross Linker | 16% | 48 |
| Topcoat Dilution Solvent | 0% | 0 |
| TOTAL | | 300 |

Mixing Procedure:

1. Mix the topcoat and crosslinker per the above Topcoat Formula for 30 minutes and check viscosity
2. Add Topcoat Dilution Solvent to bring the viscosity down to 15 seconds #3 Zahn
3. ****Take sample to lab for pre-check of topcoat.**
4. Must be approved prior to taking drum to Print Machine
5. When approved, take drums(s) to Print Machine



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II. PRINT MACHINE - OPERATING CONDITIONS

PRINT MACHINE CONDITIONS:

1. Print Roll 120 Line - Reverse coat or standard coat with 120 Quad (4.0-4.4 g/m²)
2. Viscosity must be 13-15 sec #3 Zahn - adjust viscosity with Topcoat Dilution Solvent (80% MEK, 20% IPA)
3. Flush all lines with MEK prior to introducing topcoat
4. Flush topcoat through all lines to flush out any residual MEK
5. Recirculate and mix topcoat throughout the production run - Recheck viscosity and maintain at 13-15 sec #3 Zahn. Supervisor will indicate frequency of recheck.
6. 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.
7. Maintain web temperature of less than 70 °C (158 °F) at print machine.
8. Material will be crosslinked when put in oven/press for double polished clear.

III. PRINT MACHINE - END OF RUN

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.

