

SOP Processing Conditions for TUC1386 with TUC1387 XLinker

PU Primer - 1st Station

[Must be used in conjunction with X-Treme SRT-Denim Stain Resistant Topcoat TUC1388 Dull/TUC1389 Gloss]

Ingredients:

- TUC1386 Dull PU Primer
- TUC1393 Gloss PU Primer
- TUC1387 Cross Linker
- Dilution Solvent (100% IPA)

[Must be used in conjunction with X-treme SRT-Denim Stain Resistant Topcoat TUC1388 Dull/TUC1389 Gloss]

I. MIXING PROCEDURE - INK ROOM

	Percent	Lbs.
Primer Formula:		300
TUC1386 Dull/TUC1393 Gloss PU Primer	98.5%	295.5
TUC1387 Cross Linker	1.5%	4.5
Dilution Solvent	0%	0
TOTAL		300

Mixing Procedure:

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

SOP Processing Conditions for TUC1386 with TUC1387 XLinker (contd.)

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% MEK and discard the dirty solvent.

DO NOT PUT DIRTY SOLVENT INTO TOPCOAT.

