

**FLEXICRAFT® AT**

(NARROW WEB)

FT03  
(12/09)

- Product Type:** Water reducible modified acrylic polymers.
- General Description:** Flexicraft AT is a glossy, high solids, water reducible flexographic/gravure ink system. Metallized and paper foils, topcoated vinyls, plastic films and other nonporous substrates have been printed successfully. Thorough evaluation and testing should be done before production runs. Running properties are similar to conventional water-based inks, with little or no foaming and normal press speeds.
- Suggested Uses:** Suitable for use on paper and non-porous substrates. All non-porous substrates should be treated or topcoated for improved ink adhesion.
- Plates and Rollers:** All natural and synthetic rubber plates and rollers including Cyrel® and other photopolymer plates. Standard gravure cylinders used with conventional water-based inks will also be satisfactory. Should be used on presses with powered ink rollers when press is on idle.
- Additives and Diluents:** Normally supplied at higher than press ready viscosities to allow for diluent and drying rate adjustment flexibility at press-side.
- Recommended Solvents:** The following solvents and blends are intended only as a guide. Other diluents and/or ratios may be better suited for your specific application. For additional assistance contact our Technical Service Department.
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|---------|---|
| Normal: | 100% Water  |
| Fast:   | 80% Water<br>20% Ethyl or Isopropyl Alcohol                                     |
| Slow:   | 80% Water<br>20% Propylene Glycol.<br>Add additional propylene glycol as needed |
- Color Availability:** A full range of colors, including PANTONE®\* shades.
- Shelf Life:** Minimum one year in unopened containers.
- FDA Acceptability:** All components of Flexicraft AT series inks are sanctioned by the FDA as acceptable for minimal or indirect food contact.

\*PANTONE®, Inc.'s check standard trademark for color reproduction and color reproduction materials.

***Special Handling  
Procedure:***

1. pH: Due to volatility of amines used, pH may drop during extended runs resulting in an increase in viscosity and poor print quality. Therefore, check and adjust pH to 8.5-9.5 by adding 28% aqueous ammonia or household non-sudsy ammonia. A small amount of ammonia can cause substantial changes in pH. Add only a small amount at a time, mix and recheck pH. Do not add excess.
2. Viscosity: Increases in viscosity can occur during extended runs as a result of evaporation of amines or alcohol solvents in ink. First check pH and adjust as described above. Then check viscosity and adjust as necessary with recommended diluents.

**Note:** Use an ink reservoir cover, fountain cover and/or pump covers, if possible, to reduce evaporation of volatile amines and solvents.

**RECOMMENDATIONS FOR CLEANING AND REDUCING AGENTS**

Water based systems are more sensitive to diluent shock than solvent systems. Therefore, all diluents should be added slowly under agitation.

1. Water: Should be room temperature. Do not exceed 20% water by volume for best results.
2. Alcohol: Use only Ethyl, Isopropyl or n-Propyl Alcohol. Alcohols accelerate drying speed. Do not exceed 15% by volume.
3. Clear Extender: Used to reduce color strength without a significant change in viscosity, runability or gloss, especially when printing rotogravure.
4. Plate Retarder/Tack Reducer: Used to reduce plate build up, ink tack and paper curl. For central impression presses and presses without plate throw off, an addition of 3-5% will keep plates from sticking to paper when jogging or after stopping. Additions of 4-7% will eliminate paper curl.
5. Defoamer: Should be cut seven parts isopropyl alcohol to one part defoamer and used in a spray bottle. To be used only if foaming affects printing or pumping. Spray very sparingly across the ink surface to allow air bubbles to escape. Do not exceed 1% by volume. Excessive amounts of a defoamer can cause "fisheyes".
6. Press Washup: Remove ink to a separate container. Immediately rinse all components with warm water until clean. If ink is allowed to dry, a strong detergent-water-ammonia solution will be necessary. To prevent rust or corrosion on exposed metal surfaces, dry thoroughly after cleaning.