

**STANDARD OPERATING PROCEDURE****FOR USING FLEXICRAFT<sup>®</sup> RX and MED INKS***FT07A  
(12/09)*

- Purpose:** An effective method to assure peak printer performance and print quality.
- Scope:** In-line printer procedure provided for the transition from solvent ink to water based ink, when environmental or safety compliance is desired.
- Responsibilities:** This procedure should be reviewed and implemented when using RX and MED inks. Deviations from the recommended procedure are possible as your printing experience grows or as processing needs change.
- Equipment:** pH meter, either hand-held or bench-top model.  
Zahn Cup #2.  
A stopwatch or equivalent timer, accurate to 1.0 seconds.  
Bristle brush.
- Additives:** Flexicraft<sup>®</sup> viscosity modifier solution.  
Isopropyl alcohol.  
Water. (deionized recommended)  
Ammonium Hydroxide. (28%, 26 Baumé)
- Procedure:** Incoming batches of ink will meet the product pH specification. If long-term storage conditions exist, check the pH of the product.
- Using a pH meter, check the pH level of the ink prior to pouring into the printer ink pan/fountain.
- If necessary, adjust the ink pH with the viscosity modifier back to specification. The Zahn Cup #2 value for viscosity of the ink should be 18 to 25 seconds.
- Options:** Some RX ink users have found that premixing the ink with 10 to 40% viscosity modifier results in longer press stability. However, this can affect color density.
- Pour the product into the ink pan or ink circulatory system, if one is available.
- Pour the viscosity modifier into the control unit reservoir of the printer, if available. This unit will automatically dispense solution to maintain the pH and viscosity of the ink.
- If automatic control units are not available and you see the print quality change, slowly add the viscosity modifier in one ounce increments until print quality is satisfactory.

If an ink buildup is noted on the printing mats/plates during the run, wet a cloth with viscosity modifier and wipe until clean.

When printing on non-porous materials, such as foils or plastics, it is recommended to use hot-air dryers, mounted on the equipment, with the air blowing across the printed material but away from the printing mat/plate.

When the print run is finished and the machine is to be idle for an extended period of time (greater than two hours), the ink should be drained from the unit and placed in a closed container. Do not pour diluted ink into a container of fresh ink.

Using either viscosity modifier, warm water, or a blend of warm water and isopropyl alcohol, rinse and clean all printer parts. This cleaning is recommended as soon as possible after the print run. The longer the ink dries, the more difficult it will be to remove. A bristle brush should be used to clean the anilox ink roller to remove ink from the engraved cells, if so equipped.

When it is time to print again, first use the ink which has been returned to inventory after the previous run. Add fresh ink to achieve the required volume for the printer.

***References:***

Contact the our Technical Services Department if further information or assistance is required.