

## GUIDELINES FOR USING DIRECT FOOD CONTACT WATER-BASED INKS BY FLEXOGRAPHY

NS27  
09/14***Ink Preparation:***

- If cold, allow ink to come to room temperature.
- If ink is in kits or drums, thoroughly mix before using.
- If ink is in one-gallon containers, shake well to homogenize.

***Press Preparation:***

- Thoroughly clean ink pans, doctor blades (chambers) and anilox rolls with the appropriate cleaners for the conventional inks previously run.
- Use only new, clean, lint-free rags. Avoid using rags which are chemically treated or scented. Do not use rags previously soiled by conventional inks.
- Clean as if you are switching a deck from a dark colored ink to a pastel or white.
- Thoroughly clean all pumps, hoses, and any other surface that may contact the ink. If possible, use new hosing and save after the run for future use with direct food contact inks. Disposable kit liners are also often used.
- Allow all surfaces to dry prior to inking.

***Inking the Press:***

- Pour ink into the pan, or place ink into the pumping system, whichever is appropriate for your process.
- Mix ink by either rotating anilox or pumping through system for 3-5 minutes.
- Check ink pH and adjust if necessary,
- Adjust to the optimum viscosity for the run, which will be dependent upon color, graphic, and drying requirements.
- Use the diluent guidelines from the appropriate Colorcon Technical Data Sheet to adjust viscosity and drying rates.
- After dilution, recheck and adjust pH as necessary.
- If at anytime it is determined that a color adjustment is necessary, use only appropriate direct food contact inks or toners from Colorcon.

***During the Run:***

- Check pH and viscosity approximately every thirty minutes (more frequently if pressroom conditions warrant) in order to maintain print quality. ALWAYS ADJUST pH BEFORE ADJUSTING VISCOSITY.
- For plate wash-up, use the same materials that you are using to control the inks. Again, use only clean rags, or rags that have been only used with direct food contact inks.

***After the Run:***

- If pumping from kits or drums, remove the pump and seal the containers in order to prevent contamination.
- Store under ambient conditions. Avoid freezing conditions.
- Label the container as “press-return” ink.



For more information, contact your Colorcon representative or call 1-800-724-0624  
You can also visit our website at <http://www.colorcon.com/notox>

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