

## Preparation and Use Guidelines – Opacode® WB

Opacode® WB monogramming ink is a water-based, edible printing ink developed for brand identification of pharmaceutical and dietary supplement solid oral dosage forms.

### Equipment

Opacode WB is designed for use with offset-gravure printers and can be customized for single or multi-track printers. Opacode WB is also suitable for use with pad printers.

### Preparation

- Opacode inks are liquid dispersions containing insoluble particles which must be re-suspended immediately prior to use
- For optimal suspension, the Opacode bottle should be agitated in a mechanical shaker or shaken vigorously by hand for two minutes
- A sealed bottle of Opacode ink is recommended for each print run; this should be replaced at the end of a work shift (about 8 hours) due to inherent evaporation and adjustment of the original ink

### In-Process Adjustments

Opacode WB may require initial dilution to ensure complete filling of the gravure, especially with high-speed single-track printers and/or where the print image is very narrow. In-process adjustments are required during the printing process due to inherent evaporation of solvent and water, which can change ink viscosity, wetting properties and drying times. When making solvent adjustments, a general recommendation is to use a blend of solvents at an equivalent ratio to those contained in the Opacode WB formulation. Small amounts (5-10 ml) of deionized water, isopropyl alcohol (IPA), and propylene glycol can be added, alone or in combination, to adjust ink properties and optimize printing performance.

Foaming may be observed due to agitation from the etch cylinder. When this occurs, a small amount (5-10 ml) of IPA can be added to minimize the foam.

### Opacode WB Clean Up Guidelines

As a water-based product, Opacode WB is easy to clean and eliminates the need for harsh solvents or caustic soaps.

1. Wipe the offset roller and gravure with a clean cloth wetted with water
2. Inks containing iron oxides or titanium dioxide pigments may require additional brushing of the cylinder etches using IPA and a brass brush
3. Ink fountains or pans can be washed with water and a mild detergent

## Key Advantages

- Applicable for a range of substrates including immediate release film coated tablets, hard and soft gelatin capsules\*
- Sharp, clear monogram
- Water-miscible
- Rapid drying
- Good adhesion properties
- Easy to clean with water and mild detergent

\*Not suitable for printing on modified release coatings

## COLORCON TECHNICAL SUPPORT

Colorcon provides technical assistance for printing applications with Opacode WB monogramming ink. Technical Service Managers are available around the world to provide on-site support at your location and to help optimize your process. Taking advantage of these services early in product development will help expedite your product launch and ensure efficient manufacturing with consistent quality print.

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For more information, contact your Colorcon representative or call:

North America  
**+1-215-699-7733**

Europe/Middle East/Africa  
**+44-(0)-1322-293000**

Asia Pacific  
**+65-6438-0318**

Latin America  
**+54-11-5556-7700**

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