

# PRODUCT DATA SHEET

## ROTO/FLEXO ASTRALAM

**83255** is a range of flexo and gravure inks that has been specifically formulated for reverse printing co-extruded polypropylene and certain other films that are to be subsequently adhesive laminated. For optimum print performance separate flexo and gravure range are recommended, but single range could be utilized.

Laminates printed with **83255** are used for packaging a wide range of products. The low odour and solvent retention characteristics make it particularly suited to the packaging of food products such as coffee, biscuits, snack foods, cooked foods, confectionery, etc.

Care is, however, necessary in packaging certain products having a high essential oil concentration.

### PROPERTIES

The properties of **83255** been designed to meet the stringent requirements of the film/film lamination market and include:

- ? Good adhesion and laminate bond strengths.
- ? Low solvent retention and odour.
- ? Low re-absorption of solvents from the laminating adhesives.
- ? Improved printability and tonal reproduction, particularly at higher print speeds.
- ? Higher colour strength at printing viscosity.
- ? Extrusion coatable/laminable (with a primer).

### SUBSTRATES

**83255** is used for reverse printing a number of films that are to be subsequently laminated.

- ? Treated oriented polypropylenes.
- ? One side coated cellulose films.
- ? In-line Corona treated polyester
- ? Certain co-polymer coated films have also been successfully converted.

A key temperature of 65 – 70°C (web) is normally sufficient to achieve adhesion to heat sensitive polyolefin films. However, the actual temperature can vary with substrate, process and press conditions.

### ADHESIVES

**83255** printed films may be laminated with a number of single, two-component solvent-based, 100% solids adhesives.

The actual bond strength in the printed area is a function of the substrate, ink colour, adhesive and the adhesive weight. It is normally necessary to exceed a minimum adhesive weight to achieve acceptable bonds and this should be tested before bulk production of new combinations.

Specific combinations should be evaluated before use, please contact our technical service personnel for evaluation before use.

### EXTRUSION LAMINATION

**83255** printed OPP can be extrusion laminated when primed with a suitable extrusion primer.

### PRESS SPEED

**83255** inks may be printed at speeds of 50 to 250m/min using the appropriate reducers. They are particularly suited to high speed running.

### INK HANDLING

The ink should be reduced to obtain the required press viscosity.

The colour has to be homogenous to guarantee the required result and therefore it should be stirred before use.

### REDUCTION

#### Normal 83060-0820

Dependent upon press speed, flexo plate composition and press drying capabilities.

Slow : 83060-0805

It is essential to ensure solvent removal, especially with slow drying solvents, to avoid blocking and to maintain the low odour properties of **83255**, as even small quantities of 'clean' solvent may cause odour and taint problems. High-retained alcohol levels are known to interfere with the performance of the laminating adhesive.

No guarantees for our ink can be given if the above solvent reduction is not followed. The use of other solvents and solvent blends are known to cause problems such as blocking, odour and reduced bond strength. In extremely severe cases the wrong solvent can cause "Ink Chunk Out".

### **ROLLERS AND STEREOS**

Being alcohol rich, **83255** inks may be used with most normal rubber roller and stereo materials. The use and type of photopolymer plates should be notified, however, to ensure complete suitability.

### **COLOUR RANGE**

**83255** inks are available in a wide colour range, only occasionally limited by selecting pigments suited to the requirements of the lamination.

### **WASTE DISPOSAL**

Care should be exercised in the disposal of printing ink waste. This should be carried out in accordance with good industrial practice, observing all the appropriate regulations.

### **WASH UP**

**83060-0805**

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*This information has been carefully compiled from experience gained in the laboratory and under commercial conditions. However, the product's performance and its suitability for the customer's purpose depend on the particular conditions of use and the material being printed. We recommend that the customers satisfy themselves that each product meets their requirements in all respects before commencing a print run. Since we cannot anticipate or control the conditions under which our products are used it is not possible to guarantee their performance. All sales are subject to our standard terms and conditions of sale. We would point out the information contained in this leaflet is only a recommendation and may need to be altered to suit the conditions and efficiency of the equipment employed. **ink** products are not designed for use in conjunction with those of any other ink maker or similar supplier unless agreed to in writing.*