

**AQUALINE HIGH GLOSS INK for
DIRECT FOOD CONTACT PACKAGING**

- ◆ Resistance to grease, oil and water on the reverse side of carton board.
- ◆ A high gloss carton emulsion.
- ◆ Water white and aesthetically pleasing.
- ◆ Good drying and excellent rub resistance provides maximum press speed potential with minimum transfer times between print and finishing.
- ◆ Formulated with substances that are cleared for use in direct contact with food as listed in **FDA CFR21 176.170 and 176.180.**

TECHNICAL CHARACTERISTICS:

Viscosity (DIN 4 @ 20°C)	40-45 Seconds
PH	7.8-8.2
Solids	38-42%
Gloss (Sheen @ 60° on Gloss Art)	70-85
Drying Speed	Medium
Rub Resistance	Good
Slip Values	Medium
Heat Resistance	110°C.

WB 777-45 is suitable for use in the carton, commercial and magazine sectors. WB 777-45 is suitable for direct food contact as described below. It is also suitable for use on toy packaging. For further technical details, please consult the 'Health and Safety' data sheets.

APPLICATION CHARACTERISTICS

Single/Double Sided	Single, or double with testing for suitable cartons
Recommended Minimum back up time	Test
Minimum Substrate Grammage	115 gsm
Glueable	Yes
Foil Blockable	Yes
UV Varnishable	Yes
Recommended film weight	4-6gsm wet

WB 777-45 is suitable for application via the majority of in-line coaters on Heidelbergs, Komori's, Mitsubishi, Roland, KBA, Ryobi, etc... Application can be via conventional three roller methods or new technology enclosed chamber anilox systems.

GENERAL TECHNICAL DETAILS:

Due to the high gloss characteristics of WB 777-45, only single sided application is recommended without very careful testing. Applying coating to the reverse may result in blocking caused by the re-wetting of the initial coated film if the reverse is not a suitable carton material.

WB 777-45 does not contain any detrimental surface tension modifiers, and is therefore suitable for subsequent finishing operations such as foil blocking, gluing, lamination and UV varnishing. Certain recommendations will need to be followed if UV varnishing - please contact the laboratory for further information.

WB 777-45 is not suitable for application to substrates below 115gsm. Lower grammage stocks may exhibit distortion or curl.

Optimum drying conditions would include the use of hot air knives, and IR lamps. IR lamps should be kept to a minimum, with direct stack temperatures not falling below 27°C or rise above 34°C. Light application of a middle grade spray powder is recommended.

The formulation is designed to comply with the heavy metals limits of the European Toys standard EN71-3-1994 and the American CONEG regulations.

The FDA CFR21 listings are for 176.170 'Components of paper and paperboard in contact with aqueous and fatty foods' and 176.180 'Components of paper and paperboard in contact with dry foods'. This coating may be used on the food contact surface of cartons according to the specific details listed in these sections of CFR 21.

STORAGE AND HANDLING:

Waterbased emulsions should not be exposed to temperatures below 5°C or above 35°C. During cold months, it is recommended that containers are kept off of cold floors and stored on pallets. 'AquaLine' emulsions have a 12 month shelf life - if unopened and stored in the correct conditions. Manufacture date is available on the label.

Waterbased emulsions are non hazardous and require no special storage or labelling.

DISCLAIMER:

The information contained in this product data sheet is correct to the best of our knowledge at the date of issue. It is intended as a guide for the optimum use of the named product and is not intended as a warranty or as a specification. The information relates only to the product specified and may not be suitable for combinations with other materials or in processes other than those specifically described herein.



**WB 777-45 Aqualine High Gloss for Direct Food Contact Packaging
DTM 25/02/2008 Version 1**