

**Description:** AQUAPAK™ PLUS is a high strength; water based flexographic ink system designed for application on treated polyethylene coated paperboard. AQUAPAK™ PLUS is a premium product designed specifically for Tetra-Pak offering improved gloss, printability and block resistance versus AQUAPAK™ HP while providing maximum chemical and product resistance required for use on milk, juice, and ice cream cartons.

**Process:** Flexo-Water

**Application:** Folding carton; Food containers; Liquid packaging

**Substrate:** Polyethylene Coated Board

- Key Features:**
- Excellent printability
  - Excellent press stability
  - High strength
  - Chemical resistant to:
    - Ammonia
    - Lactic and citric acid
    - Chain Lubricants
  - Product resistant
    - Milk and fruit juices

- Limitations:**
- Chain lubricants vary substantially, and some chain lubricants may attack AQUAPAK™ PLUS inks. AQUAPAK™ PLUS has been tested successfully with SaniGlide, Lubriklenz S and Ecolab FBC lubricants.
  - Some juices are extremely aggressive due to composition or high pulp content. Qualifying tests should be performed on new juices.
  - AQUAPAK™ PLUS inks may be used for the packaging of solids and/or powders. Testing is recommended since some materials may result in excessive abrasion.

**Blending Instructions:** Available as mono-pigmented finished inks, matched finished inks or for blending on site

Aquapak™ PLUS Blend Vehicle – RFCW0651	50 -60%
Recommended Dispersions	40 - 50%

RFCW0652 - AQUAPAK™ PLUS EXTENDER should be used to further adjust color strength as required.

### **PRODUCT TECHNICAL DATA SHEET**

All information is based on results from experience and tests and is believed to be accurate, but given without acceptance of liability for loss or damage, attributable to reliance thereon as conditions of use lie outside our control

**Color Range:**

Base Color Availability	
GS Yellow	Cyan Blue
Orange	Cyan Green
YS Naphthol	Carbazole Violet
BS Naphthol	White
Quinacridone	Black

**Mono-Pigmented Finished Inks**

Mono-Pigmented Inks Available	
APP-100	White
APP-200	AAOT Yellow
APP-300	Orange
APP-400	Y/S Naphthol Red
APP-401	M/S Naphthol Red
APP-402	B/S Naphthol
APP-403	Quinacridone
APP-500	G/S Cyan Blue
APP-600	Cyan Green
APP-700	Carbazole Violet
APP-900	Black

**Ink Handling Procedures:**

**Reducers:**

Aquapak™ PLUS Inks are provided press-ready. Further reduction in viscosity can be achieved with the addition of water.

**Optimum pH Range:**

9.2 – 9.6  
If pH adjustment becomes necessary, Aquapak™ PLUS can be adjusted press-side with PF-2443 H/S pH adjuster solution.

**Foaming:**

Aquapak™ PLUS has been formulated to ensure the least amount of foam generation. Should a foaming issue occur, Aquapak™ PLUS can be adjusted with CCA-32776 press-side defoamer.

**Drying:**

A web temperature of at least 120°F with good air flow through the dryers should be maintained to ensure optimum resistance properties development.

**Recommended Anilox and Plate Materials:**

Aquapak™ PLUS inks may be used with either two-roll or bladed unit configurations.  
Aquapak™ PLUS inks are formulated to accommodate a myriad of screen and volume combinations for both chrome and ceramic aniloxes.

**Press Speeds:**

Aquapak™ PLUS will run at speeds of up to 900 feet / minute.

**Clean-Up Recommendations:**

Warm Water  
Water and Amine Combinations  
Commercial Cleaners (Lysol, Formula 409, etc.)

**Ink Storage:**

Aquapak™ PLUS inks are freeze / thaw stable. However, it is recommended that all precautions be taken to keep from freezing. Recommended storage temperatures are 50° - 100° F.

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