



## Color Ink PP PAMC

### Description

COLOR INK PP PAMC are special polyamidic inks, with a high concentration of pigments, designed for the printing of PP tapes.  
If added with the 50% of our ADDITIVE ST2 they can be used for the printing of water based acrylic adhesives PP tapes, or printable hot-melt PP tapes or printable solvent based PP tapes (including low-noise). This special formulation produces a bright and well covering printing, with an extraordinary ageing resistance and non blocking effect.  
They can be used also for the three stations printing process of any kind of PP adhesive tapes and for the two stations printing process of PP acrylic tapes with corona treatment, ink and release coating.

### Application

#### A) Single-pass printing: PP tapes with water-based acrylic adhesive

1. Perform corona treatment;
2. Apply PP PAMC ink with the addition of ADDITIVO ST 2 (50 pp of COLOR INK + 50 pp of ADDITIVO), temp. >25°C.  
Printing machines: SIAT L 33 C.

#### B) Single-pass printing: pre-treated "printable" PP tapes with hot melt or solvent adhesive

1. Heat the cylinder to 45°C externally (internal thermostat at approximately 150°C);
2. Apply PP PAMC ink with the addition of ADDITIVO ST 2 (50 pp of Ink + 50 pp of Additive), temp. >25°C.  
Printing machines: SIAT L 36 C or L 33/200.

#### C) Three-pass printing: on all types of PP tapes

1. Apply PRIMER EPX-2;
2. Apply PAMC inks without additive (dilute with 50% DILUENT C PAM: Heptane-IPA 1:1);
3. Apply RELEASE PP 25 DIL.

NB: for this type of printing, we recommend using the Color Ink PP NITRO series of inks, which are

more specific and allow for higher printing speeds.  
Printing machines: SIAT L 36.

#### D) Two-pass printing: on acrylic PP tapes

1. Perform corona treatment;
2. Apply PAMC inks without additives (dilute with 50% DILUENTE C PAM: Heptane-IPA 1:1);
3. Apply RELEASE PP 25 DIL. Printing machines: SIAT L 36.

### Technical Specifications

Method of analysis	UoM	Standard
68. Adhesion		compliant
69. Tonality		compliant

### Handling

In printing systems A and B (mentioned above), these inks must be mixed with 50% ADDITIVO ST2. The products must be brought to temperatures above 25-30°C before being mixed. This additive contains aromatic solvents, so we recommend using solvent-resistant clichés, such as water-based photopolymers supplied by CARTOMAC FORNITURE SRL, SIAT, and IWA PLATE.  
In C and D printing systems, the inks should not be mixed with additives, but as they are very concentrated, they can be diluted up to 50% with our DILUENTE C PAM (heptane-isopropyl alcohol 1:1).

### Packaging

COLOR INKS PP PAMC are supplied in 10 kg or 20 Kg drums.

### Storing

Shelf life is over 6 months, when properly stored at temperatures between +5 and +40°C.  
After the addition of ADDITIVE ST2 the inks become sensitive to cold temperature: if storage



temperature is below +18°C, the additive could gel. In this case, warm products up to +35°C or more (with caution, as products are **easily flammable**) with a warm bath and stir them well. If working temperature is below +18°C, inks could gel in the printing machine basin. In this case add warmer product and stir it well.

Use within 6 months from production date (unopened and in the original packaging).

## Notes

It is important that the mixing ratio between ink and additive is always correct. Avoid mixing leftover additive-treated product with fresh, additive-free product.

Use the product at temperatures above 25°C.

If the product is used without the addition of additive, temperature has no influence, even during storage.