



Kustom Kure Energy-Curable Flexo Ink Materials

Kustom Group has developed its Kustom Kure UV flexo ink materials with the understanding that it is necessary to achieve the highest possible strength with the lowest possible viscosity and thixotropy. For this reason, we have listed UV grinding vehicles, extenders, and photoinitiators that have been developed to compliment each other.

UV Vehicles

<u>Code</u>	<u>Description</u>	<u>Application</u>
KS-322	UV Flexo Grinding Vehicle	Our best pigment wetting, grinding vehicle for flexo ink. Proprietary chemistry with unique wetting properties and adhesion to most nonporous substrates. Reduces thixotropy.
KS-307	Fatty Acid Modified Polyester Oligomer	For use as a grinding vehicle or a letback vehicle in UV flexo ink for paper and plastic applications.
KS-326	UV Flexo Epoxy Extender	General purpose letback to increase cure and cross linking.

Additives

<u>Code</u>	<u>Description</u>	<u>Application</u>
KS-384	Flow Additive	Use as a wetting agent in pigment dispersions to reduce thixotropy, increase flow & transfer.
KS-381	UV Stabilizer	Effective in-can stabilizer in a liquid form.

Photoinitiators

<u>Code</u>	<u>Description</u>	<u>Application</u>
KS-210	Flexo Photoinitiator for White Inks	Excellent for through-cure of flexo and litho white inks.
KS-308	High Potency Photoinitiator	100% active photoinitiator blend. Our best for darker colors. Ideal for UV flexo ink.
KS-373	Photoinitiator Compound	100% active P.I. blend for use in UV flexo ink.

FOR YOUR PROTECTION:

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Kustom Kure – Energy-Curable Flexographic Formulary Guide for Paper and Plastic



Flexo Pigmented Dispersion

<u>Materials</u>	<u>Yellow Ink</u>	<u>Red Ink</u>	<u>Blue Ink</u>	<u>Black Ink</u>
KS-322 UV Flexo Dispersion Vehicle	40 – 45%	30 – 35%	30 – 35%	25 – 35%
KS-307 UV Low Viscosity Polyester	10 – 20%	10 – 20%	10 – 20%	---
KS-326 UV Flexo Vehicle*	---	---	---	20 – 30%
KS-384 Flow Additive	1 – 3%	2 – 4%	2 – 4%	3-5
KS-381 Stabilizer	1%	1%	1%	1%
Yellow Pigment	30 – 35%	---	---	---
Red Pigment	---	35 – 40%	---	---
Blue Pigment	---	---	35 – 40%	---
Black Pigment	---	---	---	37 – 40%
Total	100%	100%	100%	100%

Flexo Paper Ink System (paper, paperboard and some plastics)

<u>Materials</u>	<u>Yellow Ink</u>	<u>Red Ink</u>	<u>Blue Ink</u>	<u>Black Ink</u>
KS-322/KS-307 Based Yellow Dispersion	43 – 48%	---	---	---
KS-322/KS-307 Based Red Dispersion	---	43 – 48%	---	2 – 4%
KS-322/KS-307 Based Blue Dispersion	---	---	43 – 48%	2 – 4%
KS-322/KS-326 Based Black Dispersion	---	---	---	40 – 45%
KS-326 UV Flexo Extender	40 – 50%	40 - 50%	40 – 50%	40 – 48%
KS-308 Kustom High Potency P.I.	2 – 4%	3 – 5%	3 – 5%	5 – 7%
KS-373 Top Cure P.I. Compound	1 – 3%	1 – 3%	1 – 3%	2 – 4%
Total	100%	100%	100%	100%

Notes:

- Adjust to proper viscosity with KS-266 TMPTA and/or 5-10% of KS-247 HDDA.
- KS-384 dispersant will increase flow, reduce thixotropy, and improve pigment wetting. It will also increase cost and slow cure. Adjust accordingly.

*Replace a portion of the KS-322 or KS-307 with KS-326 to increase cure response.

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Technical Data Sheet

KS-322

UV High Pigment Load Dispersant Vehicle



Product Description

KS-322 is recommended as a higher concentrated, lower viscosity version of KS-204. KS-322 is an excellent choice for dry grinding carbon black, and other hard to wet pigments. Use in UV flexographic inks, UV inkjet inks, and offset inks. KS-322 has exhibited excellent pigment wetting capabilities, good adhesion properties, and overall lower viscosities of the finished ink. Applications include paper or non-porous substrates. For additional information regarding formulary assistance and applications, please contact your KUSTOM SERVICES, INC. representative.

Performance Characteristics

- High pigment loading capability
- Can be used as a dispersant modifying vehicle at 10-20%
- Excellent adhesion to most plastics
- Excellent printability

Physical Properties

- Viscosity 45 – 60 Poise (Rheometer)
- Specific Gravity 1.14
- Solids > 99%

Suggested Starting Ink Formulary

Please refer to the SUGGESTED INK FORMULARY bulletin for starting ink formulations. These are intended as starting formulae only. Substrate, press and other variables must be addressed by the formulator for each application

Storage and Handling Information

Care should be taken not to expose radiation curable products to temperatures exceeding 100°F for prolonged periods of time or to direct sunlight. Storage must be in a cool, shaded, well-ventilated and dry area. To do otherwise might cause uncontrollable polymerization of the product with generation of heat. Do not store this material under an oxygen-free atmosphere. This material should not be stored for more than six (6) months.

Certain precautions should be taken when handling this product. Please refer to the Material Data Safety Sheet for further details. This product contains materials that may cause moderate skin injury (reddening and swelling) and/or sensitization. Since irritation may not occur immediately, contact can go unnoticed. Consult the MSDS for appropriate equipment prior to using this or any other materials referred to this in this Technical Data Sheet.

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DATE REVISED: 01/17/2016

Technical Data Sheet

KS-307

Kustom Kure Low Viscosity Polyester Dispersion Vehicle



Product Description

KS-307 is Fatty Acid Modified Hexa-functional Polyester. KS-307 is recommended as an additive for flow or use to enhance flexibility and pigment wetting in place of epoxy acrylate. KS-307 has good pigment wetting, litho properties, and cure speed.

For additional information regarding formulary assistance and applications, please contact your KUSTOM SERVICES, INC. representative.

Performance Characteristics

- Excellent pigment wetting
- Good Litho Properties
- Good reactivity and low viscosity

Physical Properties

- Viscosity 65 – 85 Poise
- Specific Gravity 1.10
- Solids > 99%

Suggested Starting Ink Formulary

Please refer to the SUGGESTED INK FORMULARY bulletin for starting ink formulations. These are intended as starting formulae only. Substrate, press and other variables must be addressed by the formulator for each application.

Storage and Handling Information

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Technical Data Sheet

KS-326

Kustom Kure UV Flexo
Extending Vehicle



Product Description

KS-326 is a UV letback vehicle based on epoxy acrylate for paper. Typical applications include commercial and folding carton, most paper substrates including paperboard. For additional information regarding formulary assistance and applications, please contact your KUSTOM SERVICES, INC. representative.

Performance Characteristics

- Excellent cure response
- Excellent gloss
- Low Viscosity
- Excellent flow

Physical Properties

- Viscosity 30 – 35 sec. #3 Zahn
- Specific Gravity 1.13
- Solids > 99%

Suggested Starting Ink Formulary

Please refer to the SUGGESTED INK FORMULARY bulletin for starting ink formulations. These are intended as starting formulae only. Substrate, press and other variables must be addressed by the formulator for each application.

Storage and Handling Information

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Technical Data Sheet

KS-384

Flow Additive



Product Description

KS-384 is a dispersant specifically developed for use in UV chemistry. KS-384 is recommended as an additive to reduce thixotropy and increase flow in UV-curable flexographic, dry offset, and lithographic inks. A ladder study is recommended to determine proper dosage level. Typical dosage level is 1-3%. *(Higher percentages may interfere with proper litho performance.) Typical applications include on paper, paperboard and select plastic stocks. For additional information regarding formulary assistance and applications, please contact your KUSTOM SERVICES, INC. representative.

Performance Characteristics

- Reduces thixotropy
- Increases flow and transfer
- Can be used as a wetting agent in pigment dispersion.

Physical Properties

- Specific Gravity 1.03
- Solids > 99%

Suggested Starting Ink Formulary

Please refer to the SUGGESTED INK FORMULARY bulletin for starting ink formulations. These are intended as starting formulae only. Substrate, press and other variables must be addressed by the formulator for each application.

Storage and Handling Information

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Technical Data Sheet

KS-381

Polymerization Inhibitor



Product Description

KS-381 is a hindered amine based inhibitor and is recommended as an in-container stabilizer. KS-381 is especially effective in pigmented systems. It acts as an effective free radical scavenger, and helps prevent polymerization in UV-curable materials. For additional information regarding formulary assistance and applications, please contact your KUSTOM SERVICES, INC. representative.

Performance Characteristics

- Effective in-container polymerization inhibitor in a liquid form.
- Effective free radical scavenger.
- Excellent choice for pigmented systems
- Recommended usage is 1.0 – 2.0% by weight.

Physical Properties

- Viscosity 16 – 18 sec. #3 Zahn cup
- Specific Gravity 1.12
- Solids >99%

Suggested Starting Ink Formulary

Please refer to the SUGGESTED INK FORMULARY bulletin for starting ink formulations. These are intended as starting formulae only. Substrate, press and other variables must be addressed by the formulator for each application.

Storage and Handling Information

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Technical Data Sheet

KS-210

Kustom Kure Flexo Photoinitiator for White Inks



Product Description

KS-210 is a balanced photoinitiator recommended specifically for use in TiO₂ pigmented systems. KS-210 can be used for most UV-curable inks including flexographic, screen, and litho. For additional information regarding formulary assistance and applications, please contact your KUSTOM SERVICES, INC. representative.

Performance Characteristics

- Excellent cure response
- Non-yellowing
- For use with white pigments
- Recommended dosage is 7-10%
- Low viscosity liquid – easy to blend into ink system
- Blend of selected photoinitiators with broad cure response

Physical Properties

- Viscosity 18 – 25 sec. #2 Zahn
- Specific Gravity 1.11
- Solids > 99%

Suggested Starting Ink Formulary

KS-210 may be used in combination with other photoinitiators. Please refer to the SUGGESTED INK FORMULARY bulletin for starting ink formulations. These are intended as starting formulae only. Substrate, press and other variables must be addressed by the formulator for each application.

Storage and Handling Information

Care should be taken not to expose radiation curable products to temperatures exceeding 100°F for prolonged periods of time or to direct sunlight. Storage must be in a cool, shaded, well-ventilated and dry area. To do otherwise might cause uncontrollable polymerization of the product with generation of heat. Do not store this material under an oxygen-free atmosphere. This material should not be stored for more than six (6) months.

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Technical Data Sheet

KS-308

Photoinitiator Blend



Product Description

KS-308 is a liquid photoinitiator blend, effective for flexo, litho, screen, especially recommended for darker colors and thicker films(except white)*. For better economics in lighter colors, use in combination with KS-203. For additional information regarding formulary assistance and applications, please contact your KUSTOM SERVICES, INC. representative.

Performance Characteristics

- Excellent cure response especially with darker colors
- For use with all standard organic and select carbon black pigments (except white)*
- Low viscosity liquid – easy to blend into ink system
- Blend of selected photoinitiators with broad cure response

Physical Properties

- Viscosity 220 – 280 Poise (TA Rheometer)
- Specific Gravity 1.10
- Solids > 99%
- Appearance Liquid (CAUTION: Upon aging, KS-308 may start to crystallize. A simple warming of KS-308, not to exceed 130°F, will reconstitute the material safely.)

Suggested Starting Ink Formulary

KS-308 can be used at a concentration of 1-8% by weight of the total formula. KS-308 may also be used in combination with other photoinitiators. Please refer to the SUGGESTED INK FORMULARY bulletin for starting ink formulations. These are intended as starting formulae only. Substrate, press and other variables must be addressed by the formulator for each application.

Storage and Handling Information

Care should be taken not to expose radiation curable products to temperatures exceeding 100°F for prolonged periods of time or to direct sunlight. Storage must be in a cool, shaded, well-ventilated and dry area. To do otherwise might cause uncontrollable polymerization of the product with generation of heat. Do not store this material under an oxygen-free atmosphere. This material should not be stored for more than six (6) months.

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*Use KS-210 for white inks

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DATE REVISED: 01/17/2016

Technical Data Sheet

KS-373

Kustom Kure Photoinitiator Compound



Product Description

KS-373 is a balanced photoinitiator recommended for use in UV-curable lithographic and flexographic inks (except tints)* where high performance and fast cure response are desired. For additional information regarding formulary assistance and applications, please contact your KUSTOM SERVICES, INC. representative.

Performance Characteristics

- Excellent cure response
- For use with all standard organic and select carbon black pigments (except tints)*
- Low viscosity liquid – easy to blend into ink system
- Blend of selected photoinitiators with broad cure response

Physical Properties

- Viscosity 16 - 18 sec. #2 Zahn
- Specific Gravity 1.10
- Solids > 99%
- Appearance Liquid

Suggested Starting Ink Formulary

KS-373 can be used at a concentration of 5-10% by weight of the total formula. KS-373 may also be used in combination with other photoinitiators. Please refer to the SUGGESTED INK FORMULARY bulletin for starting ink formulations. These are intended as starting formulae only. Substrate, press and other variables must be addressed by the formulator for each application.

Storage and Handling Information

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*Test beforehand. KS-210 can be used for tints.

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Technical Data Sheet

KS-247

Kustom Kure HDODA



Product Description

KS-247 is recommended as a tack reducer for UV-curable lithographic and flexographic inks where high performance and fast cure are desired. Typical applications include inks for use on plastic, metal, paper, paperboard and other substrates. For additional information regarding formulary assistance and applications, please contact your KUSTOM SERVICES, INC. representative.

Performance Characteristics

- Good cure speed without brittleness
- Good solvency
- 100% reactive in UV ink systems

Physical Properties

- Viscosity 10 – 14 sec #2 Zahn
- Specific Gravity 1.01
- Solids > 99%

Suggested Starting Ink Formulary

Please refer to the SUGGESTED INK FORMULARY bulletin for starting ink formulations. These are intended as starting formulae only. Substrate, press and other variables must be addressed by the formulator for each application.

Storage and Handling Information

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Technical Data Sheet

KS-266

Kustom Kure TMPTA



Product Description

KS-266 is recommended as a tack reducer for UV-curable lithographic and flexographic inks where high performance and fast cure are desired. Typical applications include inks for use on plastic, metal, paper, paperboard and other substrates. For additional information regarding formulary assistance and applications, please contact your KUSTOM SERVICES, INC. representative.

Performance Characteristics

- Good cure speed without brittleness
- Good solvency
- 100% reactive in UV ink systems

Physical Properties

- Viscosity 100 – 110 cps
- Specific Gravity 1.10
- Solids 100%

Suggested Starting Ink Formulary

Please refer to the SUGGESTED INK FORMULARY bulletin for starting ink formulations. These are intended as starting formulae only. Substrate, press and other variables must be addressed by the formulator for each application.

Storage and Handling Information

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