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| **STANDARD OPERATING PROCEDURE**  **Ink development against provided sample** |

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## Purpose

To develop formulation of ink against provided sample

## Scope

This procedure is applicable to all the staff of PCC R&D Staff

## Responsible

## Assistant Manager-LAB (R&D)

## Procedure

* Sample should be provided as per following criteria

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| **Preference** | **Sample** |
| 1 | Wet ink |
| 2 | Printed sample |
| 3 | Pantone reference |

* Determine the product line, substrate and desired properties from customer inquiry form.
* Follow below procedure as per provided sample/reference

**Wet Ink**

* Check viscosity by using flow cup as per WI and reduce ink to printing viscosity by appropriate diluents mentioned in customer inquiry form.
* Make a drawdown of provided sample on appropriate substrate by using appropriate coating medium (Hand coater for flexo and printing proofer for gravure)
* Look for similar shades in already matched grades for guideline.
* If shade is not present in color combination database then use Pantone color guide to have an idea about recipe.
* Make a trial mix by using the available pastes of the possible component colors.
* Compare the trial mix with provided sample ink as per SOP of QC of wet ink. Also confirm strength by making 10% tint in compatible white ink.
* If the trial ink is Ok against the provided sample, note the formulation in customer development sheet and attach prints with it. Also fill in the observations in COA.
* If trial ink is not Ok, rework on the formulation until it is Ok and note each rework in product development sheet.

**Printed Sample**

## In case of printed sample, use it as shade reference. However, in this case, comparison of mileage and flow is not possible.

## Associated Documents and Records

* Customer development form
* Customer development sheet
* COA

**AMENDMENT HISTORY**

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| --- | --- | --- | --- |
| **REV. #** | **DCR#** | **SECTION** | **AMENDED TEXT** |
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\* All changes made in the document are notified in the Amendment History Table.