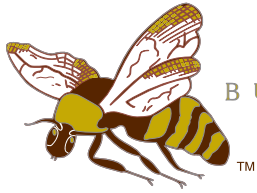


# Buzz Sales Company, Inc.

## GETTING THE MOST FROM PLASTI-TONE™ INKS

1. There are no “rules” that apply to the handling of water-based inks for die-stamping 100% of the time. However, excellent results may be obtained in most instances by following these simple guidelines.
2. Make ready as usual. Since Plasti-Tone™ Inks usually run most work thinner than other brands of ink, we recommend using a stockinette. A hard overlay is generally best in most instances.
3. Always *stir the ink before using it*, whether using a new can or not. Even though Plasti-Tone™ Inks are shelf-stable over long periods and will not deteriorate, some separation may occur. By just “turning the ink over”, uniformity will be assured to the bottom of the can.
4. Fill the fountain *no more than half-full* with ink because Plasti-Tone™ Inks generally require more thinning than other brands. This will also leave room in the fountain for adjusting the ink with more water or ink later or the addition of any additives.
5. Thin the ink with ordinary tap water, until the impression is acceptably sharp or it appears to become “washed out” or faded. If it appears faded, add fresh ink sparingly from the can until it looks right again. Generally, depending on the coverage required, the thinner Plasti-Tone™ Inks **can** be run, the sharper they will stamp.
6. Be sure that the inking roller is receiving adequate ink from the fountain, but not an excessive amount. Because the film of ink on the fountain roller becomes thinner when the ink is thinned, the flow of ink to the inking roller may need to be adjusted if the impression begins to break.
7. Relieve all wiping pressure. Then add pressure slowly until the die or plate is wiped clean. Plasti-Tone™ Inks generally require much less wiping pressure than other brands.



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8. For best die-wipe economy, when the ink is adequately thinned and ready to run, begin to close the wipe until a smear appears on the impression. Then open the wipe gradually until the smear is gone. At this point, the wipe should be very close or even overlapped up to one-third the width of the die or plate.
9. Stamp with just enough pressure to pull *all* the ink out of the die or plate. In some instances, a “patch” under the overlay may be necessary to create enough pressure in certain areas of some dies or plates.
10. Maintain the viscosity of the ink in the fountain by adding water as necessary. Water-based inks tend to thicken from evaporation due to the action of the fountain, especially at higher press speeds. On longer runs, it is important to maintain the correct balance of ink and water added to the fountain over time. If water is continually added without regard to its effect, the ink will lose its integrity, leaving a “sludge” in the bottom of the fountain, due to the binder (“varnish”) in the ink having been stripped or over-diluted. We recommend that the fountain be run down periodically on long runs so that most all the ink/water mixture is refreshed from time to time.
11. To avoid drying or packing in, the die or plate should be thoroughly cleaned with a brush and water and then wiped clean with a cloth so that all dried ink is removed, any time the press is stopped.
12. Store left-over ink in separate containers, with the lids snapped on. Do not contaminate fresh ink with used, thinned or modified ink. Our plastic ink cans are easily re-usable for this purpose. We recommend always starting up with fresh ink, then adding leftover ink to it a little at a time until it is used up. (Incidentally, to remove the label from our plastic ink cans, *do not wet it*. Simply lift a corner and pull it off dry.)
13. All Plasti-Tone™ Inks may be left in the fountain overnight, if desired. Remove the inking roller and cover the fountain with a wet cloth and a plastic wrap to retain moisture and to keep out dirt and dust.
14. While it is possible that other brands of water-based ink may be compatible, we do not recommend mixing Plasti-Tone™ Inks with any other brand of ink. To do so is entirely at the user’s risk. All Plasti-Tone™ Inks may be mixed in any combination or proportion.