# TECHNICAL DATA SHEET

UV FLEXO INK

**FLEXO SCRATCH-OFF RANGE**
Revision 18–26th August 2026

# FLEXO SCRATCH-OFF RANGE

## Introduction

This information sheet provides recommendations and details for press set-up of UV Flexo coatings to allow the production of scratch-off metallic panels.

| Product Range |
|---|
| UvDry Flexo New Scratch-Off Lacquer L501* |
| UvDry Flexo Scratch-Off Metallic Varnish MV1410 * |
| UvDry Flexo New Silver Paste 1957 |
| UvDry Flexo New Dense Scratch-Off Black B2070 |
| UvDry Flexo Scratch-Off Overlacquer L574 * |

## Application

All constructions rely on smooth and even coverage of the Scratch-Off Lacquer L501, in the 1st station to provide the base coat. In all applications, the lacquer is applied and fully cured prior to printing the metallic coatings.

Silver has been chosen as the first colour down as it should offer the best opacity and release properties of subsequent coatings. A typical print sequence for a high security application is as follows.

Note: For promotional, low and non-security type applications, results may be achieved using less stations, alternative colour mixes and lower volume deliveries.

| Print Station | Coating | Anilox Volume Details (cm3/m2) |
|---|---|---|
| 1 | Scratch – Off Lacquer (L501) | 6.0 - 12.0 |
| 2 | Scratch – Off Silver (MV1410 blended 70% to 30% 1957 Paste) | 10.0 - 15.0 |
| 3 | Scratch – Off Black (B2070) | 8.0 - 12.0 |
| 4 | Scratch – Off Black (B2070) | 8.0 - 12.0 |
| 5 | Scratch – Off Silver (MV1410 blended 70% to 30% 1957 Paste) | 10.0 - 15.0 |
| 6 | Scratch – Off Silver (MV1410 blended 70% to 30% 1957 Paste) | 10.0 - 15.0 |
| 7 | Scratch – Off Black (B2070) for text | 6.0 - 8.0 |
| 8 | Scratch – Off Lacquer (L574) | 8.0 - 14.0 |

Note: The lacquer L574 can be used in the final station of the construction to aid high security anti-tape removal. This will also improve the rub and scuff properties of the silver, if required.

### Recommended quality tests to be carried out at set-up & during print run:

It is strongly recommended that quality tests be conducted on press during set-up and running of the print run. It is also recommended that samples of each print run be retained for reference and ageing tests.

1. Ensure the lamps operate efficiently in each unit.
2. During set-up ensure an even film weight of base coat L501 is carried across the web.
3. For the first colour down, ensure good cure. Test cure with side of hand. No smudging or marking off should be evident.
4. Check that scratch-off across the web meets your standard.
5. Repeat this process for each subsequent unit in turn.
6. Finally test the hiding power / opacity and scratch-off properties versus your internal standard.

### Other Information

Products must be mixed/stirred thoroughly to ensure consistency prior to printing, failure to do so may alter the performance or finish of the inks and lacquers.

When printing on digitally printed labels we would recommend corona treatment of the Digital image prior to applying the lacquer for the best results. Thorough testing is recommended initially to ensure a satisfactory result is achieved.

Please note that the film weight of the base release coating is important in achieving a good result. If too low a film weight is applied, then the metallic inks on top may tighten up over time resulting in poor scratch-off properties.

ALDUS INKS strongly recommends that ageing tests be carried out when printing scratch-off labels for the first time as it is necessary to monitor the scratch-off properties to ensure that a satisfactory result has been achieved and is consistent over time.

*Please note these products contain Benzophenone, benzophenone free versions are available upon request.

### Storage and Shelf Life

All products detailed in this information sheet have a guaranteed shelf life of 12 months, except 1957 which is 6 months, but storage conditions are imperative. The container should be closed immediately after use and stored in a dry area at 5-18$^{o}$C away from direct sunlight. This guarantee only applies to sealed, unopened containers.

NB The metallic is shipped as a 2-pack system. When the 1957 Silver Paste is mixed with the MV1410 Metallic Varnish, the resultant blend will gel solid within 12 hours. It is important therefore that press units must be cleaned down before being left overnight or for any length of time.

The information contained in this General Information sheet is based on the experience of ALDUS INKS and our internal laboratory test procedures. It is not to be interpreted as a warranty or guarantee in any form as conditions and variables beyond our control can affect the end result.

We recommend press trials when using new substrates and other print related variables for suitability purposes.

We reserve the right to alter any product data as a result of technical or manufacturing processes.

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