



UVACURID® PrimeTube T81 Ink Series

Low-Migration Ink Series for UV Tube Printing

Characteristics

With the UVACURID® PrimeTube T81 Ink Series we present a low-migration series, especially for UV container decoration (also referred to as dry-offset or indirect letterpress). The ink series is suitable for overvarnishing and designed for plastic tubes, plastic capsules and other preformed containers which are overvarnished. It has excellent resistances against different fillings.

Technical Data

- **Drying/Curing:** UV-Hg (Mercury Vapour)
- **Substrate:** Film
- **Printing Process:** Indirect Letterpress
- **Formulation:** Low Migration - VOC-free
- **Further Processing:** Overvarnishing - Hotfoiling
- **Application:** Preformed Tubes
- **End Application:** Food - Cosmetics - Pharmaceuticals
- **Market:** Plastic Containers
- **Conformities:** Nestlé, Guidance Note on Packaging Inks - Switzerland, 817.023.21
- **Available Systems:** Z Base Colours - PANTONE® Base Colours
- **Mixing Lists Basis:** Z Base Colours

Substrates

Printable Containers

The series is suitable for injected, extruded and blow-molded preformed containers made from common substrates such as PE, PP, PS, ABS, PET, PVC.

Remark for Tube Printing:

For low-migration applications we recommend to use exclusively coextruded tubes because single-layer monotubes offer insufficient barrier properties

Packing Units

- 1 kg plastic can (black)

UVACURID T81 Farbserie

04/2017-UVACURID T81 Farbserie-16

The statements made in this publication are according to our current knowledge. They do not absolve the user from his own responsibility to ascertain that our products are suitable for his process. They are intended to inform and advise and are subject to influence from the technical process.

This edition 04/2017-UVACURID T81 Farbserie-16 dated April 12, 2017 replaces the previous edition dated November 16, 2016.

With the present edition expires the validity of all older editions.

ZG Division: Printing inks
Zeller+Gmelin GmbH & Co. KG
Schlossstr. 20, 73054 Eisingen/Fils, Germany
Tel. +49 7161 802-0 - Fax +49 7161 802-200
www.zeller-gmelin.de - druckfarben@zeller-gmelin.de

Page 1 of 9





Technical Service Center

Kindly note that we are ready at any time for competent technical application support on your site. Please contact our technical service centre for printing inks:

Ink-Service@Zeller-Gmelin.de
Tel: +49 7161 802-279

Additives

UVALUX® U0088 UV Printing Paste

Addition max.10%

Reduces the tack without reducing the viscosity significantly.

UVACURID® PrimeTube T81-X60001 Transparent White

Addition unlimited

Highly transparent, for reducing colour strength, tack and viscosity remain at a comparable level.

W963 UV Wash Up with Lemon Smell

Suitable for cleaning inking systems, sleeves, plates, blankets, etc.

Not approved for automatic washing units

UV Roller Cleaning Paste UV866

Only for rubbing into ink rollers, not suitable as ink additive

For cleaning of the ink rollers in offset and letterpress printing units from UV inks. Distribute paste with spatula on the oscillating rollers, let machine run without printing for several minutes, scrape off and wash again.

Remark:

The addition of any additive might change the overall characteristics of the printing ink.

Storage

Optimal storage conditions:

The optimal storage temperature is 20°C. Higher storage temperatures reduce the shelf-life.

Remarks:

- protect from frost
- store in a cool and dark place
- stir well before use

UVACURID T81 Farbserie

04/2017-UVACURID T81 Farbserie-16

The statements made in this publication are according to our current knowledge. They do not absolve the user from his own responsibility to ascertain that our products are suitable for his process. They are intended to inform and advise and are subject to influence from the technical process.

This edition 04/2017-UVACURID T81 Farbserie-16 dated April 12, 2017 replaces the previous edition dated November 16, 2016.

With the present edition expires the validity of all older editions.

ZG Division: Printing inks
Zeller+Gmelin GmbH & Co. KG
Schlossstr. 20, 73054 Eisingen/Fils, Germany
Tel. +49 7161 802-0 - Fax +49 7161 802-200
www.zeller-gmelin.de - druckfarben@zeller-gmelin.de

Page 2 of 9





- can should be closed immediately after usage

Warranty:

If the inks are stored correctly, we guarantee a shelf life of 6 months from date of delivery, as our raw material suppliers guarantee this period to us. However we know from practical experience our products can remain usable for 1-2 years or longer if they are properly handled and stored.

Service

Complete PANTONE® mixing recommendations. Ink formulation systems, mixing systems and dispensing systems are possible in different expansion levels.

Base ink basis for mixing recommendations:

- UVACURID® PrimeTube T81-Z... high intensity monopigmented base inks

Practice Remarks

Printing Materials

We recommend using ester and ketone resistant rollers (EPDM-material). The inking roller, rubber blanket and printing plate have to be resistant against UV-inks and UV-detergents (see manufacturers instructions).

Information about Light Resistance

All light resistances are indicated according to the blue wool scale (BWS) and are based on the product specifications of our pigment suppliers. Light resistance can change when mixing inks and when printing halftone. Depending on the mixing ratio and on the fineness of the screen the light resistance can be lower than the pure solid colour.

Preliminary Tests Recommended

Before beginning to print we recommend practice oriented pretests on your substrate, in order to test the desired characteristics of the finished product.

Marking

Marking according to EC legislation:

Our inks are classified and marked according to EC legislation and the German "Gefahrstoffverordnung" (German dangerous substances regulation).

The material safety data sheet (MSDS) is available on request.

UVACURID T81 Farbserie

04/2017-UVACURID T81 Farbserie-16

The statements made in this publication are according to our current knowledge. They do not absolve the user from his own responsibility to ascertain that our products are suitable for his process. They are intended to inform and advise and are subject to influence from the technical process.

This edition 04/2017-UVACURID T81 Farbserie-16 dated April 12, 2017 replaces the previous edition dated November 16, 2016.

With the present edition expires the validity of all older editions.

ZG Division: Printing inks

Zeller+Gmelin GmbH & Co. KG

Schlossstr. 20, 73054 Eisingen/Fils, Germany

Tel. +49 7161 802-0 - Fax +49 7161 802-200

www.zeller-gmelin.de - druckfarben@zeller-gmelin.de

Page 3 of 9





Product Designation

Zeller+Gmelin Base Inks:

T81-Z... high intensity monopigmented base inks

PANTONE®:

T81-P... PANTONE® base inks

Special Colours: T81-X...

Covering White: T81-X55001

Transparent White: T81-X60001

Monopigmented Base Inks

For ink mixing we recommend our mono-pigmented base inks. It is a print-ready system, with maximum colour strength. These base inks contain only one pigment respectively.

Advantages:

- Ink formulations are better reproducible
- Higher production security
- The higher colour-intensity makes printing with reduced ink lay-down possible
- Reduced dot gain
- More flexibility when adjusting colour strength for solids or fine texts
- Mixing recommendations are available for all PANTONE® mixed shades
- Ink dispensing, mixing and measuring systems with different expansion levels available

Product designation of the monopigmented base inks:

- UVACURID® PrimeTube T81-Z... high intensity monopigmented base inks

Miscellaneous

Intense Black Types for the Use as Spotink

UVACURID® PrimeTube T81-X40015

Very brilliant and deep intense black

UVACURID® PrimeTube T81-X40016

Higher reactivity but lower intensity than UVACURID® PrimeTube T81-X40015

UVACURID T81 Farbserie

04/2017-UVACURID T81 Farbserie-16

The statements made in this publication are according to our current knowledge. They do not absolve the user from his own responsibility to ascertain that our products are suitable for his process. They are intended to inform and advise and are subject to influence from the technical process.

This edition 04/2017-UVACURID T81 Farbserie-16 dated April 12, 2017 replaces the previous edition dated November 16, 2016.

With the present edition expires the validity of all older editions.

ZG Division: Printing inks

Zeller+Gmelin GmbH & Co. KG

Schlossstr. 20, 73054 Eisingen/Fils, Germany

Tel. +49 7161 802-0 - Fax +49 7161 802-200

www.zeller-gmelin.de - druckfarben@zeller-gmelin.de

Page 4 of 9





Resistance Properties

Colour Name	Article Number	Light Resistance	Spirit Resistance	Solvent Resistance	Alkali Resistance
PANTONE® Base Colours					
Orange 021	T81-P100	6 - 7 BWS	+	+	-
Yellow 012	T81-P101	6 - 7 BWS	+	+	-
Orange 021	T81-P150	5 BWS	+	+	+
Warm Red	T81-P200	5 - 6 BWS	+	+	+
Red 032	T81-P201	6 - 7 BWS	+	+	+
Rubine Red	T81-P202	6 - 7 BWS	+	+	+
Rhodamine Red	T81-P203	6 - 7 BWS	+	+	+
Purple	T81-P250	6 - 7 BWS	+	+	+
Violet	T81-P251	6 - 7 BWS	+	+	+
Reflex Blue	T81-P300	6 - 7 BWS	+	+	+
Process Blue	T81-P301	8 BWS	+	+	+
Blue 072	T81-P302	6 - 7 BWS	+	+	+
Green	T81-P350	8 BWS	+	+	+
Black	T81-P400	8 BWS	+	+	+
Z Base Colours					
Yellow	T81-Z2100	7 BWS	+	+	+
Yellow	T81-Z2101	4 BWS	+	+	+
Yellow	T81-Z2102	7 BWS	+	+	-
Yellow	T81-Z2103	5 BWS	+	+	+
Orange	T81-Z2150	5 BWS	+	+	+
Red	T81-Z2201	6 - 7 BWS	+	+	+
Red	T81-Z2202	6 - 7 BWS	+	+	+
Red	T81-Z2203	5 BWS	+	+	-
Red	T81-Z2205	6 - 7 BWS	+	+	+
Violet	T81-Z2251	6 - 7 BWS	+	+	+

UVACURID T81 Farbserie

04/2017-UVACURID T81 Farbserie-16

The statements made in this publication are according to our current knowledge. They do not absolve the user from his own responsibility to ascertain that our products are suitable for his process. They are intended to inform and advise and are subject to influence from the technical process.

This edition 04/2017-UVACURID T81 Farbserie-16 dated April 12, 2017 replaces the previous edition dated November 16, 2016.

Page 5 of 9

With the present edition expires the validity of all older editions.

ZG Division: Printing inks
Zeller+Gmelin GmbH & Co. KG
Schlossstr. 20, 73054 Eisingen/Fils, Germany
Tel. +49 7161 802-0 - Fax +49 7161 802-200
www.zeller-gmelin.de - druckfarben@zeller-gmelin.de





Blue	T81-Z2302	8 BWS	+	+	+
Green	T81-Z2350	8 BWS	+	+	+
Black	T81-Z2400	8 BWS	+	+	+

Remarks on Migration and Conformity

The following remarks are valid for the production of food packaging which conforms to the regulations in the European Union. We can not make any statements concerning food packaging legislation of countries outside the EU.

Regulation (EC) No. 1935/2004 requires that the one responsible for the “placing on the market” of a packaging article must have an appropriate documentation available to demonstrate the compliance with the rules related to food processing and distribution.

Not only the used materials have an influence on the food-legislation related properties of a packaging. The production process of the packaging has a significant impact as well.

Therefore we recommend that you send your finished products to a recognized analytical institute for examination and certification. That way you can prove that your products comply with the legal requirements.

The transfer of substances from the packing into the filling is called migration. The following production parameters have a significant influence on the grade of migration:

- correct processing, especially the complete through-cure of the ink film
- type of substrate and substrate thickness (sufficient barrier effect of the substrate)
- prevention of a direct contact of the printing ink with the food
- use of low-migration printing inks

The UVACURID® PrimeTube T81 Ink Series has a special low-migration formulation. Therefore we recommend these products for printing of materials for food-packaging. The EuPIA designation "FCM" stands for products which are generally suitable for the production of food-packaging. Please note that our FCM products are designed for use on the packaging outside (Non-DFC). A direct contact of the filling with the printed image has to be avoided.

Due to the low migration formulation it is reasonable to assume that with these products migration limit of the European Union should be well achievable (Regulation (EU) 10/2011 and Regulation (EU) 1183/2012). Therefore it should be possible with these products to fulfil the legal requirements of EC regulation 1935/2004.

We produce our low-migration products in accordance with the EU regulation 2023/2006 (Good Manufacturing Practice,

UVACURID T81 Farbserie

04/2017-UVACURID T81 Farbserie-16

The statements made in this publication are according to our current knowledge. They do not absolve the user from his own responsibility to ascertain that our products are suitable for his process. They are intended to inform and advise and are subject to influence from the technical process.

This edition 04/2017-UVACURID T81 Farbserie-16 dated April 12, 2017 replaces the previous edition dated November 16, 2016.

Page 6 of 9

With the present edition expires the validity of all older editions.

ZG Division: Printing inks
Zeller+Gmelin GmbH & Co. KG
Schlossstr. 20, 73054 Eisingen/Fils, Germany
Tel. +49 7161 802-0 - Fax +49 7161 802-200
www.zeller-gmelin.de - druckfarben@zeller-gmelin.de





GMP). The resulting demands on printing ink manufacturers are detailed in the EuPIA-GMP (see www.eupia.org).

Generally you should ensure with a migration analysis that no migration through the entire packaging system takes place. Due to the multitude of packaging materials and their completely different barrier properties we are unable to make any statements regarding through-migration.

However please note that migration can also occur by set-off when the printed surface is pressed against the food-contact surface of the packaging in the stack or reel.

We formulate our low-migration products in such a way that potential migration is as low as possible, both through the substrate and by set-off from the print-surface to the food contact surface in the stack or reel.

The UVACURID® PrimeTube T81 Ink Series is formulated in accordance with the Nestlé Guidance Note on Packaging Inks.

The UVACURID® PrimeTube T81 Ink Series is formulated in accordance with the Swiss ordinance 817.023.21 on materials and articles intended to get into contact with food.

Declaration of Composition and Product Declaration

As there are no specific regulations concerning printing inks and varnishes Zeller+Gmelin -like other ink suppliers- is obliged to follow regulations in the EU not directly related to printing inks.

Regulation (EU) 1935/2004

Article 3 of the Regulation 1935/2004 (impact on food) demands, that materials and articles do not transfer their constituents to food in quantities which could endanger human health or bring about an unacceptable change in the composition of the food or bring about a deterioration in the organoleptic characteristics thereof.

We urgently advise you to use for printing on food packaging only printing inks/lacquers which we specifically recommend for this application and which have a low-migration formulation.

A possible impact on the quality of food does not solely depend on the printing ink/lacquer itself but is depending on the complete production chain (ink laydown, UV-power, substrate, etc.). For this reason we can generally not confirm a compliance to Regulation 1935/2004 only based on the composition of the ink/lacquer.

Based on Article 17 (traceability) material and articles shall be ensured at all stages in order to facilitate control, the recall of defective products, consumer information and the attribution of responsibility.

All raw materials for ink/lacquer batches at Zeller+Gmelin are documented in writing on the Formula Component Report. Based on the batch number every raw material can be clearly traced back to the raw material batch.

Regulation (EU) 2023/2006

This so called GMP regulation (Good Manufacturing Practice) defines the requirements on the different participants in the manufacturing process of materials and articles intended to come into contact with food. It requests a system for quality assurance, control and documentation (§5-7). The EuPIA defined the requirements on printing ink manufacturers in the EuPIA-GMP.

UVACURID T81 Farbserie

04/2017-UVACURID T81 Farbserie-16

The statements made in this publication are according to our current knowledge. They do not absolve the user from his own responsibility to ascertain that our products are suitable for his process. They are intended to inform and advise and are subject to influence from the technical process.

This edition 04/2017-UVACURID T81 Farbserie-16 dated April 12, 2017 replaces the previous edition dated November 16, 2016.

With the present edition expires the validity of all older editions.

ZG Division: Printing inks
Zeller+Gmelin GmbH & Co. KG
Schlossstr. 20, 73054 Eisingen/Fils, Germany
Tel. +49 7161 802-0 - Fax +49 7161 802-200
www.zeller-gmelin.de - druckfarben@zeller-gmelin.de

Page 7 of 9





Regulation (EU) No 10/2011 and Regulation (EU) 1282/2011

Regulation EU 10/2011 and 1282/2011 establishes the specific rules for plastic materials and articles to be applied for their safe use and repeals Commission Directive 2002/72/EC of 6 August 2002 on plastic materials and articles intended to come into contact with foodstuffs (2).

In this regulation, the so called PIM (Plastic Implementation Measure) limits are set for substances, which are allowed to be in direct contact with food and are allowed to migrate into the food up to the level listed in Annex I.

Substances used in printing inks must not (with few exemptions) get in direct contact with food and are therefore not listed in Annex I.

Paragraph (30) states, that Coatings, printing inks and adhesives are not yet covered by a specific EU legislation and therefore not subject to the requirement of a declaration of compliance.

For the migration of non-authorized substances through a functional barrier into food a limit of 0,01 mg/kg (10 ppb) is set. Substances that are mutagenic, carcinogenic or toxic to reproduction should not be used without previous authorisation in food contact materials or articles and should therefore not be covered by the functional barrier concept.

CEPE / EuPIA – Exclusion Policy

CEPE is the European Council of producers and importers of paints, printing inks and artists colours whereas EuPIA is the European Printing Ink Group of CEPE. The printing ink industry voluntarily came up with the Exclusion Policy for specific substances many years ago.

Zeller+Gmelin is an active member in the EuPIA and subgroups. The raw materials used by Zeller+Gmelin for the formulation of our printing inks/lacquers meet the guidelines of the CEPE / EuPIA Exclusion Policy. This means that CMR 1A and 1B substances (cancerogenic, mutagenic and reprotoxic) plus T (toxic) and T+ (very toxic) are not used in our printing inks/lacquers.

Heavy Metals

CONEG stands for Coalition of North-Eastern Governors in the USA . One of their legislations, adopted by 18 states as of 1998, requires reductions in the amount of the four heavy metals mercury, lead, cadmium, and hexavalent chromium in packaging and packaging components sold or distributed in their member states. For Zeller+Gmelin printing inks/lacquers the limits for heavy metals as listed in the CONEG-Regulation (USA) are met. The Euro Norm 71.3 refers to the max level of heavy metals in childrens toys. For Zeller+Gmelin printing inks/lacquers the limits for heavy metals as listed in the DIN EN 71-3 are met.

Heavy metals are no part of our formulations.

Hazardous substances

Substances mentioned in the directive 2002/95/EC (RoHS) and directive 2011/65/EC are not intentionally used in our formulations printing inks/lacquers.

SVHC-substances (substances of very high concern): In our products no substances are used which are classified as CMR 1A & 1B, PBT (PBT pollutants are chemicals that are toxic, persist in the environment and bioaccumulate in food chains),

UVACURID T81 Farbserie

04/2017-UVACURID T81 Farbserie-16

The statements made in this publication are according to our current knowledge. They do not absolve the user from his own responsibility to ascertain that our products are suitable for his process. They are intended to inform and advise and are subject to influence from the technical process.

This edition 04/2017-UVACURID T81 Farbserie-16 dated April 12, 2017 replaces the previous edition dated November 16, 2016.

With the present edition expires the validity of all older editions.

ZG Division: Printing inks
Zeller+Gmelin GmbH & Co. KG
Schlossstr. 20, 73054 Eisingen/Fils, Germany
Tel. +49 7161 802-0 - Fax +49 7161 802-200
www.zeller-gmelin.de - druckfarben@zeller-gmelin.de

Page 8 of 9





vPvB (Substances that are potentially very persistent and very bioaccumulative) und endocrine disruptors (artificial hormones).

Furthermore we confirm that our printing inks/lacquers are in accordance with the EC regulation 1895/2005 (repeals the guide line 2002/16/EC).

ISO 9001

The production site of Zeller+Gmelin / Germany is certified according to DIN EN ISO 9001:2000 and DIN EN ISO 14001:2005 (corresponds to EN ISO 14001 edition Nov. 2004).

Swiss Ordinance 817.023.21

This ordinance regulates materials and articles intended to come into contact with food. On 01.04.2008 the ordinance was changed to include regulations concerning printing inks. Since 01.04.2010 only packaging which has been produced with conforming printing inks may be supplied to consumers. We urgently advise you to use for food packaging which is subject to this regulation only printing inks/lacquers which we specifically recommend for this application and which have a low-migration formulation.

Please note:

According to applicable law the manufacturer of the finished article and the filler have the full legal responsibility to ensure that their product is fit for its intended purpose and complies with the applicable rules (not the supplier).

Please also consider the relevant publications of the European Printing Inks Association EuPIA (<http://www.eupia.org>).

There are many types of final packaging and the printing ink/lacquer is only one constituent. Since the parameters in the printing, packing and storage processes are not under the control of the printing ink manufacturer, the printing ink suppliers are not able to issue certificates or declarations of compliance which cover the legal responsibility of the entire packaging chain (Text from EuPIA-PIFOOD May 2007).

The statements made in this declaration are according to our current knowledge. They do not absolve the user from its own responsibility to ascertain that our products are suitable for his application.

UVACURID T81 Farbserie

04/2017-UVACURID T81 Farbserie-16

The statements made in this publication are according to our current knowledge. They do not absolve the user from his own responsibility to ascertain that our products are suitable for his process. They are intended to inform and advise and are subject to influence from the technical process.

This edition 04/2017-UVACURID T81 Farbserie-16 dated April 12, 2017 replaces the previous edition dated November 16, 2016.

With the present edition expires the validity of all older editions.

ZG Division: Printing inks
Zeller+Gmelin GmbH & Co. KG
Schlossstr. 20, 73054 Eisingen/Fils, Germany
Tel. +49 7161 802-0 - Fax +49 7161 802-200
www.zeller-gmelin.de - druckfarben@zeller-gmelin.de

Page 9 of 9

