Waterbased Coating – Blister/Heat-Seal Coating Change-Over Considerations

Scope	- Diligence in change-over between INXCAC blister/heat-seal coating and other coating products is necessary to prevent any issues related to cross-contamination within the coating-system and coating container/s – this outlined change-over procedure is intended to mitigate potential incidents of cross-contamination. - INXCAC PUD blister/heat-seal coatings (polyurethane formulations) are not compatible with other waterbased coatings (acrylic formulations) and can be problematic when sharing a common press coating-system (feed/return stems, hoses/lines/connections, filters, pumps, chamber, recovery-pan, etc.). - Cross-contamination during a change-over can result in congealed coating residing within the coating-system that could potentially impede/restrict coating flow and lead to down-time for cleaning. * **Conventional acrylic coating, when exposed to blister/heat seal coating, may create severe contamination of the coating-system requiring additional cleaning. Residual blister/heat-seal coating remaining in the coating-system can impair the functionality of acrylic coatings when contamination occurs – this can cause the remaining acrylic coating in the container to become unusable.**
Coating Preparation	**Recommended Drum Preparation Steps** 1) Acquire the blister/heat-seal coating from inventory based on oldest date-of-manufacture (DOM) listed on the container product label – do not use the lid label for reference, these can be interchanged on used containers. 2) If using a used/partial container, inspect the surface of the coating for any dried material/skin or particles/ debris floating on the surface – skim and remove any dried material/skin or debris prior to mixing. 3) Mix the coating thoroughly using a drill w/ mixing-blade attachment or drum-mixer – mix for ~5-minutes. 4) Measure the coating temperature using a handheld pyrometer and document the result. 5) Measure the coating viscosity using a Zahn #3 cup and document the result. 6) Check the temperature/viscosity results against the INXCAC 'Temperature/Viscosity Index Chart' for compliance. The intended manufactured viscosity can be found on the specific product Technical Data Sheet (TDS) or on the specific batch COA. If the coating is too thick (high viscosity), dilute with only water in 1% increments and re-measure to verify compliance. Consult INXCAC 'Waterbased Coating Viscosity Measurement Procedure' technical document for specifics in coating dilution procedure. 7) Keep lid closed and secured on the container until ready for use to prevent surface drying/skinning.
Mixing	- Use of a lid-mounted mixer is recommended for pre-mixing and constant agitation during use.
Filtration	- An in-line screen basket strainer/filter installed between the infeed stem/coating container and feed coating pump is recommended – this should be installed to allow for easy access for regular cleaning. - OEM coating pumps are generally equipped with in-line filter systems, however, if the system lacks in-line filtration, an after-market pumping system is installed without filtration or additional in-line filtration is desired, the below link is a good resource for in-line screen basket strainer/filter products: • Hayward SB Series Simplex Basket Strainers: www.haywardflowcontrol.com - The intent of the filtration is to capture larger particles to prevent circulation to the coating chamber where the particles may result in flow obstruction – it is recommended to use a relatively course strainer mesh to not restrict the infeed coating flow.
Coating Cleaner	- INXCAC 501 Cleaner is a general-use coating cleaner that is suitable for use for cleaning INXCAC blister/heat-seal coating products as well as non-blister/acrylic coating products. - 501 Cleaner can be used for cleaning blister/heat-seal coating from the coating-system and from parts/surfaces of the coating-unit. - 501 Cleaner is recommended for use as a cleaning 'buffer' when changing in/out of blister/heat-seal coating applications to prevent cross-contamination with acrylic coating products.

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Change-Over Procedure	**Recommended Change-Over Procedure Steps** 1) Drain/recover coating back to respective container. 2) Clean infeed filter/strainer with hot water – remove all debris. 3) Pump clean water (preferably hot) through coating-system to clean residual coating – avoid recirculating contaminated/wastewater through the coating-system. A continuous incoming fresh water source and outlet to a waste container/system is ideal. Recycling contaminated water through the coating system is not recommended and should be avoided if possible. 4) Drain all water from the coating-system – wipe excess water from chamber/recovery-pan if necessary. 5) Circulate 501 Cleaner for ~5-minutes – this is feed/return to the same cleaner container. 6) Drain/recover all 501 Cleaner from the coating-system. 7) Remove the used chamber from the press. 8) Wipe chamber recovery-pan and anilox surfaces with 501 Cleaner – if using a common anilox for blister/heat-seal and non-blister/heat-seal applications, it is recommended to clean the anilox cells using 501 Cleaner and an anilox brush to remove any residual coating. 9) Clean and install replacement chamber in new/rebuilt condition (new blades and end-seals) – chamber cavity, infeed/drain ports and outside surfaces should be cleaned with 501 Cleaner prior to rebuild and installation. 10) Clean infeed filter/strainer with 501 Cleaner. 11) Clean infeed/return stems with 501 Cleaner – remove any dried residue. 12) Clean mixer impellers/shaft with 501 Cleaner – remove any dried residue. 13) Install feed stem and drum-mixer into the next coating container. 14) Purge any residual 501 Cleaner from the coating-system into a waste container. 15) Install return stem into coating container and circulate coating to press – constant agitation during use is recommended. 16) For blister/heat-seal coating, keep container always covered to avoid surface drying/skinning. 17) Clean coating-blanket/plate surface with 501 Cleaner removing any residue from prior application – use a new/unused coating blanket/plate if possible.
Drum Consolidation	- When combining partial blister/heat-seal coating containers together, ensure that no surface dried material/skin or debris is present – skim any surface debris off before combining. - When decanting a partial container into another, make sure that no sediment/particles that may be on the bottom of the container are transferred – transferring coating through a strainer may be necessary to filter out any debris.