WOF1308 Water-Based Inline Offset Gloss Varnish
Technical Data Sheet

1. Product Overview

WOF1308 is an advanced high-gloss water-based varnish engineered for inline coating on sheetfed offset presses for tobacco outer packaging. Formulated for coated art papers, holographic transfer papers, and aluminum foil laminated boards. It offers rapid curing, outstanding slip and scratch resistance, and full compliance with tobacco packaging VOC standards.

2. Product Features

- **High Gloss & Clarity:** Enhances image contrast with an exquisite mirror-like shine.
- **Tobacco VOC Compliance:** Strictly compliant with domestic cigarette packaging VOC limits.
- **Superb Slip & Rub Resistance:** Imparts high surface slickness to withstand folding carton packing lines.
- **Fast Inline Drying:** Exceptional through-drying performance allowing fast turnaround times.
- **Non-Yellowing Stability:** Outstanding thermal and UV color stability.

3. Suitable Substrates

Suitable for coated art paper, holographic transfer paper, and aluminum foil laminated paperboards.

4. Technical Specifications

Property	Unit	Typical Value	Test Method / Notes
Appearance & Color	-	Translucent viscous liquid	Visual inspection
Viscosity	s	60±5	Zahn #2 cup, 25°C
pH Value	-	8.0–9.0	25°C
Solid Content	%	40±1	Oven drying, 105°C × 2 h
Gloss (60°)	GU	50–70	60° angle

5. Application Guidelines

Ink Preparation	Stir thoroughly for 5–10 minutes prior to use. Filtration through ≥200 mesh screen is recommended before loading onto press. 1-pack system; consume promptly after opening.
Plate / Cylinder Specs	Inline Offset: applied via inline coating coater, anilox screen selected according to coating weight requirements (typically 80–120 L/cm), moderate blade pressure.
Dilution Ratio	Deionized water or dedicated aqueous diluent, dilution ratio 5%–10% (adjust based on press speed and target operating viscosity).
Press Viscosity	50–60 s (Zahn cup, 25°C).
Press Speed	7,000–16,000 sheets/hour (optimized for high-speed sheetfed offset; adjust according to press model and dryer capacity).
Drying Method	Hot air drying, air temperature 60–90°C; ensure complete drying before rewinding.
Equipment Cleaning	Clean printing plates and ink circulating systems promptly after printing with water or dedicated aqueous cleaning agents to prevent ink drying and clogging.
Application Note	Prior to initial commercial production, thorough trials must be conducted under actual operating conditions to verify intercoat adhesion between base ink and varnish, as well as anti-blocking and drying performance.

6. Regulatory & Safety

Regulatory Compliance	Complies with RoHS and REACH (SVHC) directives.
Food Contact Statement	Formulated for external non-food-contact secondary packaging. If specialized food contact compliance or low-migration performance is required, project-specific technical evaluation and formulation confirmation by HCOLOR are required.
Usage Note	VOC content complies with domestic cigarette packaging regulations; suitable for domestic cigarette outer packaging printing.
Safety Data Sheet (SDS)	Safety Data Sheets (SDS) are available upon request.
User Responsibility	Users must independently verify product suitability, regulatory compliance, and processing performance under actual commercial production conditions prior to full-scale adoption.

7. Packaging & Storage

Standard Packaging	20 kg / 25 kg plastic pails; 1,000 kg IBC containers (custom packaging available upon request).
Storage Conditions	Store tightly sealed in original containers. Keep in a dry, cool, and well-ventilated warehouse at 5–35°C, away from direct sunlight and rain. Strictly protect from freezing; prevent winter frost damage or high-temperature degradation.
Shelf Life	12 months from production date in unopened original containers.
Post-Opening Care	Reseal immediately and tightly after dispensing; recommended to use within 6 months.

8. Typical Product Grades

Product Code	Key Features	Suitable Substrates	Target Applications
WOF1308	High gloss / Wear resistance / High-speed inline offset stability	Coated paper, holographic transfer paper, aluminum foil laminated paper	Cigarette outer packaging

1. Baseline Platforms & Customization: The products listed above are core baseline platforms proven through extensive commercial mass production. To meet specific press speeds (e.g., ultra-high-speed inline coating), substrate absorbency variations, or demanding rub/crease-crack resistance requirements, HCOLOR provides tailored viscosity adjustments, customized additive packages, and bespoke functional performance development.

2. Specialty Process Integration: If specialized finishes such as drip-off / drip-relief combination effects or tactile matte finishes are required, please contact HCOLOR technical support for a comprehensive turnkey printing formulation.

9. Disclaimer

1. The data are typical values intended for product selection and technical reference only. Unless otherwise agreed in writing, they do not constitute guaranteed specifications.

2. The information contained herein is based on our current knowledge and experience and is provided in good faith for general application guidance only. It does not constitute a legal warranty, guarantee, or binding technical specification. Users are strictly responsible for evaluating and confirming product suitability, process compatibility, and commercial usability under their actual operating conditions and production equipment prior to commercial use.