

ADDITIVE	PROBLEM	WHEN TO USE	RECOMMENDED AMMOUNT	POSSIBLE SIDE EFFECTS
RE392 / RE393 Reducer/Thinner	Ink not flowing in pan. Ink spitting.	Ink too high in viscosity for press configuration.	Up to 10% in 2% increments	Improper cure, loss of adhesion, absorption in porous substrate.
CARE71 Non-silicone defoamer	Excessive foam builds up in pan or return container.	When other sources of ink foam have been eliminated.	Up to 3% in ½% increments.	Re-coatability, intercoat adhesion and substrate adhesion
CARE41 Silicone flow additive	Ink rubs off substrate; poor trapping over different inks.	When properly cured ink rubs or scratches easily. Ink crawling.	Up to 3% in ½% increments.	Intercoat adhesion and trapping, adhesion. NOT Re-coatable.
CARE86 Photoinitiator for whites and light/pastel colors	Poor ink adhesion and rub.	When > 5% reducer added to ink. Standard inks formulated with proper photoinitiator levels.	Up to 3% in ½% increments.	Cost, ink film properties.
CARE70 Photoinitiator for dark colors	Poor ink adhesion and rub.	When > 5% reducer added to ink. Standard inks formulated with proper photoinitiator levels.	Up to 3% in ½% increments.	Cost, ink film properties. May yellow light colors.

Note: Pretest any additions prior to production run.

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