

**WORK INSTRUCTIONS FOR INK MIXING PROCESS**

| SN. | Instructions   |
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| 1   | Clean the surroundings before starting the ink mixing process.   |
| 2   | Ensure the accessories to be used for ink mixing are clean.<br>[Like ink spatula, stirrer blades, weighing scale top etc.]                               |
| 3   | Get the plan for the ink/shade to be prepared & get all the inputs like inks to be mixed, ink formulation, reducer on work station.                      |
| 4   | Verify the ink code, manufacturing date, expiry date before starting ink mixing process.   |
| 5   | Start the power supply of weighing scale, place the container on weighing scale in which inks are to be mixed and then set the weighing scale to "Zero". |
| 6   | Add ink quantities one by one as per standard shade formulation.   |
| 7   | Also, add required reducer as per standard ink formulation.  |
| 8   | After mixing all inks in container, keep it for stirring for around 30 min at slow or moderate speed.  |
| 9   | Ensure homogeneous mixture of all inks and then stop the stirrer.  |
| 10  | Visually verify the mixed shade and then close the container with lid or cover.  |
| 11  | Enter the ink mixing details in log book and mention batch details on container.   |
| 12  | If shade is not used for more than 24 hours then before issuing shade for production, additional stirring for 10-15 min is to be done.                   |
| 13  | Check on machine performance of the shade by measuring L a b values and verifying them with standard.  |
| 14  | Make correction in shade (if required) only after getting approval from authority.   |
| 15  | After use, collect the shade in container from screen, close the container with lid and store it in ink mixing area with proper identification.          |

Prepared by: Production Engineer

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