**Description:** Arrowstar® Low VOC HS 4041 is a high strength, duct fresh process series formulated from renewable vegetable oils resulting in very low VOC content. This series provides excellent print sharpness and good rub resistance. The Arrowstar® Low VOC HS 4041 is ideally suited for folding carton applications and optimally suitable for printing on perfecting presses, as well as straight-line printing. The high solids content provides high brilliance and gloss along with excellent through drying properties.

**Process:** Sheetfed Offset

**Application:** Process printing for folding carton and label applications, as well as general commercial printing, via sheetfed offset presses

**Substrate:** Gloss coated and uncoated paper and paperboard

**Key Features:**
- Less than 3% VOC per colour
- High colour strength
- Improved low misting properties
- Minimal dot gain
- Excellent through drying and rub resistance
- Excellent press stability
- Formulated with high levels of bio-renewable resources – NAPIM BRC = 70
- High gloss
- Suitable for off-line UV coating, lamination and foil stamp (testing recommended)

**Limitations:**
- Slightly slower setting speed than traditional vegetable based series

**Colour Range:**
- SF-K4041 Arrowstar® Low VOC HS 4041 Black
- SF-C4041 Arrowstar® Low VOC HS 4041 Cyan
- SF-M4041 Arrowstar® Low VOC HS 4041 Magenta
- SF-Y4041 Arrowstar® Low VOC HS 4041 Yellow

**ISO Compliance:** Complies with ISO 2846-1

**Fastness Properties:**

<table>
<thead>
<tr>
<th></th>
<th>Light</th>
<th>Alcohol</th>
<th>Solvent</th>
<th>Alkali</th>
<th>Hot Calendering</th>
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</thead>
<tbody>
<tr>
<td>Black – blue toned</td>
<td>8</td>
<td>-</td>
<td>-</td>
<td>+</td>
<td>+</td>
</tr>
<tr>
<td>Cyan</td>
<td>8</td>
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<tr>
<td>Magenta</td>
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<td>-</td>
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<tr>
<td>Yellow</td>
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<td>+</td>
<td>+</td>
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</tr>
</tbody>
</table>

Lightfastness properties according to ISO12040: from 1 (low) to 8 (high)
Fastness properties according to ISO2836: + = resistance provided, - = resistance not provided

**Printing Properties:**
- Dot Gain 7
- Gloss 6
- Setting 5
- Oxidative Drying 5
- Rub Resistance 6
- Rapid Further Processing 5
- Suitability for Glossy Coated Papers/Board 7
- Suitability for Uncoated Papers/Board 5
- Suitability for Matte Coated Papers/Board 5

**Rating Scale** - 1 (poor) to 7 (excellent)