

# Nazdar Doming Receptive & Doming Repelling Clears UV Screen Ink

**652663PS Doming Receptive Clear** is a UV curable ink for screen printing on areas where a doming resin is going to be applied, providing a barrier coat between the doming resin and the substrate. The application of 652663PS is necessary in cases where the doming resin does not adhere to the substrate or does not wet the substrate appropriately.

**657101PS Doming Repelling Clear** is a UV curable ink that has been formulated for screen printing around areas where a doming resin is going to be applied to limit the spread of the doming resin.

*Substrate recommendations are based on commonly available materials intended for the ink's specific market when the inks are processed according to this technical data. While technical information and advice on the use of this product is provided in good faith, the User bears sole responsibility for selecting the appropriate product for their end-use requirements. Reference the 'Quality Statement' at the end of this document.*

## Mesh

280 - 355 tpi (110 - 140 tpcm) monofilament polyester mesh with a mesh opening of 22-38 um for most applications.

## Stencil

Use direct emulsions and capillary films which are solvent resistant and UV compatible.

## Squeegee

70-80 durometer polyurethane squeegee.

## Coverage

Depending upon ink deposit, the estimated coverage per gallon: 2,500 – 3,500 square feet (232 - 325 square meters)  
Reference [www.nazdar.com/en-us/ColorStar](http://www.nazdar.com/en-us/ColorStar) for examples of coverage calculations.

## Screen Printing

Standard items are formulated to be press ready. Thoroughly mix the ink prior to printing. Improper mixing can lead to inconsistent color and ink performance.

Maintain ink temperature at 65°-90°F (18°-32°C) for optimum print and cure performance. Lower temperatures increase the ink viscosity, impairing flow and increasing film thickness. Elevated temperatures lower the ink viscosity, reducing print definition and film thickness.

Pretest to determine optimum printing parameters for a particular set of ink, substrate, screen, press, and curing variables/conditions.

The ink can be affected by stray UV light. Be aware of skylights, windows and overhead lights curing the ink in the screen; light filters are recommended. Leaving a container uncovered may result in the ink's surface forming a "skin", caused by reaction with ambient lighting. Keep containers covered.

Nazdar does not recommend inter-mixing this ink series with other inks or series.

## Cure Parameters

These guidelines are intended only as a starting point for determining cure parameters, which must be determined under actual production conditions. "Undercuring" the ink may result in poor adhesion, lower block resistance, reduced durability, and higher residual odor. "Overcuring" the ink may reduce the flexibility of the printed part and adhesion of subsequent ink layers.

Mercury Vapor UV Curing: this series has been optimized for 395nm LED curing; however, most colors cure when exposed to a single medium pressure mercury vapor lamp emitting output millijoules (mJ) and milliwatts (mW) of:

180+ mJ/cm<sup>2</sup> @ 600+ mW/cm<sup>2</sup>

These guidelines are representative of measurements taken using an EIT® UVICURE® Plus radiometer measuring the UVA bandwidth (320-390 nm). To obtain accurate mJ readings with the UVICURE® Plus, reduce the belt speed to less than 40 ft/min.

## Adhesion Testing

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Revision 6

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When recommended UV energy output levels are achieved, checking the degree of cure on a **cooled down** print is imperative:

- Touch of ink surface – the ink surface should be smooth.
- Thumb twist – the ink surface should not mar or smudge.
- Scratch surface – the ink surface should resist scratching.
- Cross hatch tape test – per the ASTM D-3359 method, use a cross hatch tool or a sharp knife to cut through ink film only; then apply 3M #600 clear tape on cut area, rub down, and rip off at a 180 degree angle. Ink should only come off in actual cut areas.

## Cleanup

Screen Wash (Prior to Reclaim): Use IMS201 Premium Graphic Screen Wash or IMS203 Economy Graphic Screen Wash For screen cleaning, similar products to those listed below may be used.

Press Wash (On Press): Use IMS301 Premium Graphic Press Wash

## General Information

### Handling

Refer to the SDS for recommendations on handling.

Wear gloves and barrier cream to prevent direct skin contact. Safety glasses are suggested in areas where ink may be splashed. If product does come in contact with skin, wipe ink off with a clean, dry cloth (do not use solvent or reducer). Wash the affected area with soap and water.

Consult the applicable Safety Data Sheet (SDS / MSDS) for further instructions and warnings.

For assistance on a wide range of important regulatory issues, consult the following Regulatory Compliance Department link at <http://www.nazdar.com> or contact Nazdar Ink Technologies - World Headquarters (see contact listing at the end of this document).

### Storage / Shelf Life

Store closed containers at temperatures between 65°-78°F (18°-25°C). Storing products outside of these recommendations may shorten their shelf life.

Ink taken from the press should not be returned to the original container; store separately to avoid contaminating unused ink. Store closed containers at temperatures between 65°-78°F (18°-25°C). Storing products outside of these recommendations may shorten their shelf life.

Standard items supplied in 1-gallon (4/5 kilo) containers or smaller. Useable for a period of at least **24 months** from the date of manufacture.

Shelf life above applies to the standard ink items listed on this TDS. To obtain the shelf life for special inks and additives, contact Nazdar Customer Service or Nazdar Technical Service. See contact listing at the end of this document.

## Standard Color Range

Based on information from our raw material suppliers, these ink products are formulated to contain less than 0.06% lead. If exact heavy metal content is required, independent lab analysis is recommended.

## Packaging / Availability

Contact your Nazdar distributor for product availability and offering.

Item Type	Item Number	Item (or Color) Description
Clears / Varnishes	652663PS	UV Doming Receptive Clear
Clears / Varnishes	657101PS	UV Doming Repelling Clear
Cleaners	IMS201	Premium Graphic Screen Wash
Cleaners	IMS203	Economy Graphic Screen Wash
Cleaners	IMS301	Premium Graphic Press Wash

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## Nazdar Quality Statement

*Nazdar® stands behind the quality of this product. Nazdar® cannot, however, guarantee the finished results because Nazdar® exercises no control over individual operating conditions and production procedures. While technical information and advice on the use of this product is provided in good faith, the User bears sole responsibility for selecting the appropriate product for their end-use requirements. Users are also responsible for testing to determine that our product will perform as expected during the printed item's entire life-cycle from printing, post-print processing, and shipment to end-use. This product has been specially formulated for screen printing, and it has not been tested for application by any other method. Any liability associated with the use of this product is limited to the value of the product purchased from Nazdar®.*

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