

60028546WB Waterbase Peelable Mask (clear) and 60035897WB Waterbase Peelable Mask (frosted) are water-soluble, screen-printable inks for use as a temporary protective coating on polycarbonate and coated metal substrates. The dried coating can be easily peeled away from the substrate.

Substrates

- Polycarbonate
- Coated Metal

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.

User Information

Mesh

60-110 tpi (24-43 tpcm) monofilament polyester mesh for most applications.

Stencil

Use direct emulsions and capillary films which are solvent resistant.

Squeegee

60-70 durometer polyurethane squeegee.

Printing

60028546WB and 60035897WB are formulated to be press ready. Add only enough ink to the screen to be able to print for 5-10 minutes. Add additional ink in small increments throughout the print run to maintain screen stability. Thoroughly mix the ink prior to printing. Improper mixing can lead to inconsistent performance.

Application of too little mask will result in a dry film with less integrity, making eventual removal more difficult. Apply generously to produce a strong, robust film which will peel easily.

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 and film thickness.

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

60028546WB and 60035897WB can be inter-mixed. 60028546WB (clear) provides greater adhesion to the substrate and higher clarity. 60035897WB (frosted) provides easier release from the substrate and higher opacity.

Nazdar does not recommend inter-mixing of 60028546WB and 60035897WB with any other inks.

Drying / Curing Parameters

Good air circulation is necessary to dry the inks.

Air Drying: 60028546WB and 60035897WB air dries in approximately 30 minutes by evaporation depending on the ambient conditions.

Forced Drying: For best results, 60028546WB and 60035897WB should be force dried at 150°-180°F (66°-82°C).

Common Performance Additives

When required, any additives should be thoroughly mixed before each use. Prior to production, test any additive adjustment to the ink. Inks containing additives should not be mixed with other inks.

Example for additives: Ink at 100g with 8% of an additive is calculated as:

$$100\text{g ink} + 8\text{g additive} = 108\text{g total}$$

Reducer: Use water or RE180 Thinner to reduce the viscosity of these inks. Add up to 5% by weight.

Cleanup

Screen Wash (Prior to Reclaim): Use 2537 Screen Wash.

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.

General Information

Ink Handling

All personnel mixing and handling these products must wear gloves and eye protection. Clean up spills immediately. If ink does come in contact with skin, wipe ink off with a clean, dry, absorbent cloth (do not use solvent or thinner). 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).

Manufacturer’s Product Offering

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.

Standard Ink Item

Item Number	Color
60028546WB	Waterbase Peelable Mask (clear)
60035897WB	Waterbase Peelable Mask (frosted)

Additives / Reducers

Item Number	Color
RE180	Thinner

Cleaners / Clean Up

Item Number	Color
2537	Screen Wash

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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