

Nazdar 652663PS Doming Receptive Clear & 657101PS Doming Repelling Clear UV Screen Ink

 v 4 EN
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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.

User Information

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

Estimated 2,500 – 3,500 square feet (232 – 325 square meters) per gallon depending upon ink deposit.

Printing

652663PS Doming Receptive Clear and 657101PS Doming Repelling Clear are formulated to be press ready. Thoroughly mix the ink prior to printing. Improper mixing can lead to inconsistent 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 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 of 652663PS Doming Receptive Clear and 657101PS Doming Repelling Clear with each other or with other inks.

Cure Parameters

652663PS Doming Receptive Clear and 657101PS Doming Repelling Clear cure when exposed to medium pressure mercury vapor lamps emitting millijoules (mJ) and milliwatts (mW) of:
 180+ mJ/cm² @ 600+ mW/cm² UVA

These guidelines are intended only as a starting point for determining cure parameters, which must be determined under actual production conditions.

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

Cleanup

Screen Wash (Prior to Reclaim): Use IMS201 Premium Graphic Screen Wash, IMS203 Economy Graphic Screen Wash, or IMS206 Graphic Auto Screen Wash.

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

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Standard 652663PS Doming Receptive Clear and 657101PS Doming Repelling Clear are supplied in 1 gallon (4/5 kilo) containers or smaller are useable for a period of at least 24 months from the date of manufacture. Inks packaged in 5 gallon or greater (20 kilo or greater) containers may have a significantly reduced shelf life. For more detail pertaining to the shelf life of Nazdar's ink products, contact Nazdar Technical Service at InkAnswers@nazdar.com or see contact listing at the end of this document.

General Information

Ink Handling

Wear gloves and barrier cream to prevent direct skin contact. Safety glasses are suggested in areas where ink may be splashed. If ink 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).

Adhesion Testing

Even when recommended UV energy output levels are achieved, it is imperative to check the degree of cure on a **cooled down** print:

1. Touch of ink surface – the ink surface should be smooth.
2. Thumb twist – the ink surface should not mar or smudge.
3. Scratch surface – the ink surface should resist scratching.
4. 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.

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.

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Packaging / Availability

Contact your Nazdar distributor for product availability and offering.

Standard Ink Items

Standard ink items listed are packaged in gallon containers.

Item Number	Color
652663PS	UV Doming Receptive Clear
657101PS	UV Doming Repelling Clear

Cleaners / Clean Up

Item Number	Item Description
IMS201	Premium Graphic Screen Wash
IMS203	Economy Graphic Screen Wash
IMS206	Graphic Auto Screen Wash
IMS301	Premium Graphic Press 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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UV Screen Ink

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