

Nazdar 2800 LED Decal Screen Ink

2800 Series LED Decal Screen Ink is formulated to cure using a LED output source at 395 nanometers. This ink series is intended for decals used in the Durable Graphic Market. 2800 Series exhibits excellent chemical resistance and exterior durability. These inks will thermal die cut and accept pre-mask.

The use of LED curing systems rather than traditional mercury vapor curing units reduces energy costs, reduces heat within the curing process and provides significantly longer lamp life.

Substrates

- Pressure-sensitive calendered vinyls
- Pressure-sensitive cast vinyls (for extended outdoor weathering)
- Print treated polyesters

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

355-420 tpi (140-165 tpcm) with a mesh opening of 22-38 um monofilament polyester mesh for most applications.

305-355 tpi (120-140 tpcm) monofilament polyester mesh can be used for specialty applications with the mesh opening appropriate to the effect (*i.e. pearlescents, aluminums, etc.*).

Coarser mesh counts and/or twill weave result in heavier ink deposit and may require additional cure output.

Stencil

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

Squeegee

70-90 durometer polyurethane squeegee.

Coverage

Estimated 3,200 - 4,200 square feet (295 - 390 square meters) per gallon depending upon ink deposit. Reference www.nazdar.com for examples of coverage calculations.

Printing

2800 Series LED Graphic Screen Ink is 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 of 2800 Series LED Graphic Screen Ink with other inks besides the 2800 Series LED Graphic Screen Ink.

Cure Parameters

LED Curing

2800 Series LED Graphic Screen Ink cures when exposed to an LED curing unit. Requirements:

- 4 w/cm² or higher cure unit
- 395 nanometer wavelength
- At or less than 4mm distance from substrate to cure unit
- Belt speed at or less than 50-70 ft/min (15-30 m/min) depending on color

It is suggested to expose the print to heat for 1-2 seconds prior to curing to increase the speed of curing.

Mercury Vapor Curing

The 2800 Series ink cures when exposed to a medium pressure mercury vapor lamp set at 200 watts per inch with millijoules (mJ) and milliwatts (mW) of:

- 90-100 mJ/cm² @ 600 mW/cm² for (Pantone® Base Colors, Most Standard Printing Colors and Halftone colors)
- 100-130 mJ/cm² @ 600 mW/cm² for (28178, 28179)

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, and higher residual odor.

Clears / Varnishes

Mixing Clear: Use 2836 metallic mixing clear to reduce the density of colors.

Overprint Clear: Use 2827 Label Overprint Clear to provide added surface protection and optimum chemical resistance.

Overprint Clear: Use 2829 Durable Overprint Clear to provide added surface protection, increase chemical resistance and outdoor durability.

Common Performance Additives

The market specific performance properties of the 2800 Series LED Graphic Screen Ink should be acceptable for most applications without the need for 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 RE306 UV Reducer to reduce the viscosity of these inks. Add up to 5% by weight. Over reduction can reduce print definition, film thickness and adversely affect cure.

Flexibilizer: Use RE308 UV Reducer to increase the flexibility of these inks. Add up to 5% by weight. There is no pot life; however, the

addition of RE308 could show a decrease in block resistance.

Adhesion Promoter: Use NB80 UV Adhesion Promoter to enhance adhesion. Add up to 5% by weight. Improved adhesion will be demonstrated within 8-24 hours, with full cross linking in 4-7 days. Ink mixed with NB80 UV Adhesion Promoter has a 4-8 hour pot life.

Gloss / Flattening Powders / Improved Slip: Use CARE59 Satin Paste to reduce gloss and improve slip. Add up to 10% by weight. CARE59 should be power mixed into 2800 Series ink.

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.

Standard 2800 Series LED Graphic Screen Inks supplied 1 gallon (4 to 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. To obtain the official shelf life letter, 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

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affected area with soap and water. Consult the applicable [Safety Data Sheet](#) (SDS / MSDS) for further instructions and warnings.

This ink series is a one-part, 100% solids LED-curable screen printing ink and does not contain N-vinyl-2-pyrrolidone (trade name V-Pyrol[®]).

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-LED 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.

Weathering / Outdoor Durability

At full strength and properly cured, 2800 Series LED Graphic Screen Ink colors are formulated to provide 4 years outdoor durability when mounted vertically in the Central U.S.A. 2800 Series is recommended for durable decals mounted over smooth flat surfaces. (2800 Series is not intended for fleet applications mounted over rough surfaces containing rivets or corrugation).

The use of 2829 Durable Overprint Clear increases outdoor durability by 1 year. (The use of 2827 Label Overprint Clear does not enhance weather durability of the colors, but does provide greater chemical resistance for indoor or shorter term 3 year outdoor decal labels).

Outdoor durability cannot be specified exactly. Slight color change and loss of gloss should be expected. Variables affecting a printed part's durability include:

- Ink film thickness and degree of curing
- Color formulation:
 - Large amounts of mixing clear or white
 - Mixing several colors into one match
 - Mixing a small quantity of any single color
- Substrate type and age
- Mounting angle and directional orientation
- Geographical location
- Degree of air pollution
- Excessive abrasion
- Non-clear coated prints exhibit more color change and loss of gloss

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.

Halftone Colors

Halftone Extender Base is used to reduce the density of any of the halftone colors.

Standard Halftone Colors are formulated with hues and densities common to the graphic industry.

Standard Printing Colors

Standard Printing Colors have excellent opacity and flow characteristics. These colors are intended to work as supplied.

Pantone Matching System[®] Base Colors

Pantone Matching System Base Colors are used to simulate the Pantone[®] Formulation Guide. These inks are press ready, can be used in matches to achieve Pantone color simulations, or let down with mixing clear. ColorStar[®] Color Management System software uses Pantone Matching System Base Colors to match Pantone colors. Blend formulations are also available at www.nazdar.com using ColorStar On-Line.

2800 Series Toner Colors: Toner colors are formulated to have no white or opaque pigments. This allows the colors to be more vibrant and

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allows for a better match of intense and darker colors.

Special Effect Pigments

When inks are to be printed with a special effect color, all ink layers must be evaluated for intercoat adhesion before proceeding with the production run. To maximize intercoat adhesion, specialty colors should be printed as late as possible in the print sequence.

Pigments may settle in the container; prior to printing, thoroughly mix the ink.

The following special effect pigments may be added to 2800 Series LED Graphic Screen Ink. Contact Nazdar for the item number(s) and availability of special effect products. Technical Data Sheets for each of the following special effect pigments can be found at www.nazdar.com.

Recommended Aluminum Pigments:

- SIPM571 313 Aluminum Paste (Coarse Aluminum)
- SIPM606 Aluminum 6600 (Medium Aluminum)
- SIPM573 2871 Aluminum Pigment (Fine Aluminum)

Using the above recommended aluminums with 2836 metallic mixing clear, will result in a minimum of 1 month shelf life. Using any other aluminum pigments may cause the mixed ink to have shorter shelf life and may affect exterior durability.

Aluminum Pigment Load: The maximum recommended aluminum load is 15% in 2836 metallic mixing clear. Mixing aluminum with colors will lower the allowable concentration of metallic in a formulation. The allowable concentration will depend on ink deposit and curing parameters. Care should be taken to ensure proper cure and adhesion. Exceeding these recommendations may lead to degradation of the ink's overall performance, including flexibility, adhesion, intercoat adhesion and exterior durability.

Gold and Bronze Powders: Gold and bronze powders are not recommended due to poor exterior durability. To achieve gold and bronze colors use pearlescent and aluminum pigments.

Pearlescent: Using Automotive Grade Pearlescent Pigments add up to 20% by weight.
 SIPI519 9307 SW Gold Auto Grade
 SIPI520 9520 SW Bronze Auto Grade
 SIPI536 Card Silver BN001
 Pantone® 871c to 877c can be matched in 2800 Series Ink using Automotive Grade Pearlescent Pigments. To achieve extended durability overprint these special colors with 2829 Durable Overprint Clear, starting formulas are available through contacting technical service.

Interference: Using Interference Pigments add up to 20% by weight (Refer to Special Effects Color Card). Note: Interference Pigments shift in shade and color with outdoor exposure.

Multi-Chromatic: Using Multi-Chromatic Pigments add up to 10% by weight (Refer to Special Effects Color Card).

Color Card Materials

The following is a list of available screen printed sample literature representing 2800 Series LED Graphic Screen Ink.

UV Color Card (CARDUV): shows the Standard Printing Colors, Pantone Matching System Base Colors, and Halftone Colors.

Special Effects Color Card (CARDSPL): shows various special effect pigments mixed with clear.

Packaging / Availability

Contact your Nazdar distributor for product availability and offering.

Standard Ink Items

Standard ink items listed below are inventoried in gallon containers.

Standard Halftone Colors

Item Number	Color
28120	Halftone Extender Base (LTR)
28131	Halftone Cyan (LTR)
28132	Halftone Magenta (LTR)
28133	Halftone Yellow (LTR)
28134	Halftone Black (LTR)

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Standard Printing Colors

Item Number	Clears, White, Black
2827	Label Overprint Clear
2829	Durable Overprint Clear
2836	Metallic Mixing Clear
28178	High Intensity White
28179	High Intensity Black

Standard Line Colors

Item Number	Color
2858	Tinting White
2859	Tinting Black
28159	Tran Orange Toner
28160	Tran Yellow Toner (YS)
28161	Primrose Yellow
28162	Yellow Toner (GS)
28163	Yellow Toner (RS)
28164	Medium Yellow
28165	Permanent Orange Toner
28166	Red Toner
28167	Deep Red Toner
28168	Carmine Toner
28169	Magenta Toner
28170	Maroon Toner
28171	Violet Toner
28172	Green Toner (YS)
28173	Green Toner (BS)
28174	Blue Toner (GS)
28175	Blue Toner (RS)

Additives / Reducers

Item Number	Item Description
RE306	UV Reducer
RE308	UV Reducer

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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