

Nazdar PX Perma-Flex Flock Adhesive Screen Ink

PX Series is formulated as a pigmented adhesive for flocking applications on a wide variety of natural textile materials and some synthetic material. The excellent opacity and “short” body allow ease in achieving a thick adhesive deposit for flocking. PX Series is ideal for use without a high temperature dryer.

v 4 EN

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Substrates

- Cotton
- Cotton/Polyester Blends
- Some synthetics fabrics
- Sunbrella®

Substrate recommendations are based on commonly available materials intended for the inks' 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

86-110 tpi (34-43 tpcm) monofilament polyester mesh for most applications.

Stencil

Use direct emulsions and capillary films which are solvent resistant.

Squeegee

70-80 durometer polyurethane squeegee.

Coverage

Estimated 400 - 600 square feet (34 - 56 square meters) per gallon depending upon ink deposit. Reference www.nazdar.com for examples of coverage calculations.

Printing

PX Series is 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 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.

Nazdar does not recommend inter-mixing PX Series with other inks besides the PX Series.

Drying / Curing

PX Series dries by oxidation, requiring 24-48 hours for total cure/dry. Tack free dry time is about 4-6 hours. To obtain a faster tack free surface, heat set at 180°F (83°C) for 30 minutes. Multiple layers of ink may require longer drying times than a single layer.

Common Performance Additives

The market specific performance properties of the PX Series 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:

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

Thinner: Use PX30 Thinner to reduce the viscosity of these inks. Add up to 10% by weight.

Cleanup

Screen Wash (Prior to Reclaim): Use IMS401C Premium Textile 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.

Standard PX Series items are useable for a period of at least 48 months from the date of manufacture. 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

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.

Color Card Materials

The following screen printed samples of the PX Series are available.

[CARDDA-PX Color Selector Guide](#): shows the Standard Printing Colors.

Packaging / Availability

Contact your Nazdar distributor for product availability and offering.

Standard Ink Items

Ink items listed below are supplied in 1 Kilo containers. Items marked with an asterisk (*) are also available in gallon containers.

Item Number	Color
PX10	Yellow
PX13	Orange
PX15	Dark Green
PX16	Brown
PX18	Scarlet Red
PX19	Fire Red
PX21	Royal Blue

PX23	Navy Blue
PX24	Black*
PX25	White*
PX28	Purple
PX32	Gold
PX33	Kelly Green
PX75	Super Opaque White*

Additives / Reducers

Available in gallons only.

Item Number	Color
PX30	Thinner

Cleaners / Clean Up

Available in gallon and five gallon containers.

Item Number	Color
IMS401C	Premium Textile 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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Solvent-Based Screen Ink