

The multi-purpose PowerPrint® Plus1800 Series UV Screen Ink has been formulated to meet the processing speeds of the most modern printing equipment including in-line presses, for a wide range of substrates including treated corrugated polypropylene. 1800 features include: fast curing, hard ink surface, and high block resistance.

Substrates

Coated paper / Coated cardstock
Styrene (PS)
Rigid vinyl (PVC)
Matte vinyl (PVC)
Pressure sensitive calendered vinyl (PVC)
Top coated / Print treated polyester (PET)
Treated fluted/corrugated polypropylene (PP)
Treated polypropylene banner (PP)

Substrate Material(s) listed below may be Limited in Adhesion (testing highly recommended for each print run)
Some high density polyethylene sheeting (HDPE)

Notes & Cautions

The surface tension for polyethylene and polypropylene substrates should be at or above 44 dynes/cm.

Not recommended for highly plasticized vinyl materials such as vinyl banner and static cling, and not recommended for container or nameplate applications.

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) with a mesh opening of 50 um or more monofilament polyester can be used for specialty applications (i.e. pearlescents, aluminums, etc.).

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

Stencil

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

Squeegee

70-90 durometer polyurethane squeegee.

Coverage

Depending upon ink deposit, the estimated coverage per gallon: 2,500 – 3,500 square feet (232 - 325 square meters)
www.nazdar.com 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.

Pad Printing

When pad printing with a UV ink on a 3D image, care must be taken to assure the correct amount of UV light output reaches the entire ink surface. Cure units that rotate the printed part in front of the cure lamp are the best solution for UV pad printing. These UV inks can be pad printed. The use of thinners may be required to achieve the correct transfer. Please follow the printing and curing guidelines.

Use a silicone pad with good chemical resistance for printing. Clean equipment using the chemicals listed below in the cleanup section.

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: Standard ink cures when exposed to a single medium pressure mercury vapor lamp emitting output millijoules (mJ) and milliwatts (mW) of:

80-100 mJ/cm² @ 600+ mW/cm² for most colors

100-130 mJ/cm² @ 600+ mW/cm² for 1820, 1878, 1879, and 18156

To increase mJ levels, slow down the belt speed or scan speed. To increase mW levels, increase the wattage setting of the UV reactor. To optimize mJ and mW output, maintain the bulb and reflector, and ensure proper focus to the substrate. 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.

Note: *Porous substrates allow ink to dive below the surface requiring a more thorough cure to overcome the added ink thickness.*

Processing

Qualify 1800 Series with respect to finishing processes before conducting full scale production; see the 'Additives' section for suggested Additives/Reducers to enhance finishing process performance.

Inter-Printable

When these inks are to be inter-printed with the following ink(s), all ink layers must be evaluated for inter-coat adhesion before proceeding with the production run.

CoroPlus® 32800's® Series inks

Fluorescent colors fade with exposure to UV light. This includes outdoor exposure as well as UV reactor exposure. It is therefore recommended to adjust art so that these colors are the final colors printed on any image.

Adhesion Testing

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

For screen cleaning, similar products to those listed below may be used.

Screen Wash (Prior to Reclaim): Use IMS201 Premium Graphic Screen Wash or IMS203 Economy Graphic Screen Wash
Press Wash (On Press): Use IMS301 Premium Graphic Press Wash

Ink Modifications

Clears / Varnishes

Overprint Clear: use to provide added surface protection and increase durability.

Mixing Clear: use to reduce the density of colors.

Additives

The market specific performance properties of this ink series / ink item 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: 100g ink + 8g additive = 108g total

Reducer / Thinner

Use the following item(s) to reduce the viscosity of these inks. Over reduction can reduce print definition, film thickness and adversely affect cure.

RE310 UV Reducer: add up to 10%

Flexibilizer

Use the following item(s) to increase the flexibility of these inks. The addition of flexibilizer could show a decrease in block resistance.

RE308 UV Reducer: add up to: 10%

Adhesion Promoter

Use the following item(s) to enhance adhesion.

NB80 UV Adhesion Promoter: add up to: 5%. Improved adhesion will be demonstrated within 8-24 hours, with full crosslinking in 4-7 days. Ink mixed with NB80 UV Adhesion Promoter has a 4-8 hour pot life.

Gloss / Flattening Powders / Improved Slip

Use to reduce gloss and improve slip.

CARE118 UV Satin Paste add up to 20%, power mix into the ink.

Use to reduce the potential for blocking, reduce gloss, and improve slip.

CARE63 Anti Blocking Additive: add up to: 10%, power mix into the ink.

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).

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

Weathering / Outdoor Durability

At full strength and properly cured, the outdoor durability when mounted vertically in the Central U.S.A: **2 years**

Outdoor durability can be increased by applying an overprint clear.

Outdoor Durability Exceptions

18EC142 and 18EC143 have a projected **6 months** outdoor durability.

Outdoor Durability Variables

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, and/or 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.

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.

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.

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.

Dense Halftone Colors are formulated with increased densities over the Standard Halftone colors and are designed for printers who want to have the latitude to adjust the density levels.

Yellow Dense (RS) Halftone is intended to better facilitate matching redder shades without blending Halftone Magenta into the Halftone Yellow.

High Intensity Halftone Black has been developed to function as a dense halftone and line color in a single pass.

Low Tack Rheology (LTR) Halftones can achieve the fastest processing speeds on newer in-line presses and cylinder presses while maintaining dot quality with very minimum dot pile.

Medium Tack Rheology (MTR) Halftones can achieve processing speeds for flatbed, clam shell and most in-line presses while maintaining dot quality.

Economy (EC) Magenta & Economy (EC) Yellow Halftones are formulated to provide a cost effective alternative to the more durable Halftone Magenta and Yellow. Economy Halftone Colors are indoor/short-term outdoor colors.

T7 Halftones are designed to print to the targeted values of the seven colors (CMYK & RGB) as stated in ISO 12647-2 specification for process color reproduction. These inks can meet the ISO targeted numbers and achieve a neutral 100x3 black when printed on a substrate with a white value similar to a #1 Grade Coated Paper. Best results are achieved when printing these inks at the following solid ink density values and printing sequence: Cyan 1.45 – 1.50, Yellow 0.95 – 1.00, Magenta 1.25 – 1.30.

Standard Printing Colors

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

Pantone 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.

360 Series Colors: These colors are formulated to have no white or opaque pigments. This allows the colors to be more vibrant and allows for a better match of intense and darker colors.

Pantone 871c-877c Metallic

Pantone® 871c to 877c colors have been matched using pearlescent pigments. When printed on a white background, a gold or silver metallic effect is achieved. A 305 tpi (120 tpcm) mesh with a mesh opening of 50 um or more is recommended.

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 the ink. Contact Nazdar for the item number(s) and availability of special effect products or they can be found at www.nazdar.com.

Metallic Silver (aluminum), add up to: 8%

Metallic Gold (bronze), add up to: 15%

Chemical reactions in metallic inks may result in viscosity, color and printability changes over time; due to this, mix only enough metallic ink to be used the same day.

Pearlescent / Interference, add up to: 20%

Multi-Chromatic, add up to: 10%

Color Card Materials

The following is a list of available literature representing this ink series.

- 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.

Item Type	Item Number	Item (or Color) Description
LTR Halftone Colors	18120	Halftone Extender Base
MTR T7 Halftone Colors	18140	Halftone Extender Base
MTR T7 Halftone Colors	18141	Halftone Cyan
MTR T7 Halftone Colors	18143	Halftone Yellow
MTR T7 Halftone Colors	18144	Halftone Black
MTR T7 Halftone Colors	18146	Halftone Magenta
MTR T7 Halftone Colors	18151	Halftone Cyan Dense
MTR T7 Halftone Colors	18153	Halftone Yellow Dense
MTR T7 Halftone Colors	18154	Halftone Black Dense
MTR Halftone Colors	18142	Halftone Magenta
MTR Halftone Colors	18EC142	Economy Halftone Magenta
MTR Halftone Colors	18EC143	Economy Halftone Yellow
MTR Halftone Colors	18152	Halftone Magenta Dense
MTR Halftone Colors	18156	High Intensity Halftone Black
Standard Colors	1810	Primrose Yellow
Standard Colors	1811	Lemon Yellow

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Standard Colors	1812	Medium Yellow
Standard Colors	1813	Emerald Green
Standard Colors	1819	Fire Red
Standard Colors	1820	Brilliant Orange
Clears / Varnishes	1826	Mixing Clear
Clears / Varnishes	1827	Overprint Clear
Standard Colors	1852	Super Opaque Black
Standard Colors	1867	Reflex Blue
Standard Colors	1868	Process Blue
Standard Colors	1875	Super Opaque White
Standard Colors	1878	High Intensity White
Standard Colors	1879	High Intensity Black
Pantone Base Colors	18358	Tinting White
Pantone Base Colors	18359	Tinting Black
Pantone Base Colors	18360	Orange
Pantone Base Colors	18361	Yellow
Pantone Base Colors	18362	Warm Red
Pantone Base Colors	18363	Rubine Red
Pantone Base Colors	18364	Rhodamine Red
Pantone Base Colors	18365	Purple
Pantone Base Colors	18366	Violet
Pantone Base Colors	18367	Reflex Blue
Pantone Base Colors	18368	Process Blue
Pantone Base Colors	18369	Green
Pantone 871c-877c Metallic	68157518	SPL 18 871C Pearl Gold
Pantone 871c-877c Metallic	68157618	SPL 18 872C Pearl Gold
Pantone 871c-877c Metallic	68157718	SPL 18 873C Pearl Gold
Pantone 871c-877c Metallic	68157818	SPL 18 874C Pearl Gold
Pantone 871c-877c Metallic	68157918	SPL 18 875C Pearl Gold
Pantone 871c-877c Metallic	68158018	SPL 18 876C Pearl Gold
Pantone 871c-877c Metallic	68158118	SPL 18 877C Pearl Silver
Additives	CARE118	UV Satin Paste
Additives	CARE63	Anti-Blocking Additive
Additives	NB80	UV Adhesion Promoter
Additives	RE308	UV Reducer
Additives	RE310	UV Reducer
Cleaners	IMS201	Premium Graphic Screen Wash
Cleaners	IMS203	Economy Graphic Screen Wash
Cleaners	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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