

60024029KI Special Mirror Silver Screen Ink is a solvent-based ink for printing second surface on transparent polycarbonate and pre-treated polyester film. The ink film exhibits a mirror-like reflective surface when viewed through the top or first surface of the transparent film. The 60024029KI is not compatible with laminating adhesives. See section on Overprint.

Printing the ink over other ink systems is not recommended. The thoroughly dried ink film may be overprinted with a clear, black or white for enhanced protection, but not necessary for the mirror effect. Compatible Nazdar inks for overprinting are the 3400 Series UV Nameplate Ink and 9700 Series Conventional Ink.

**SUBSTRATES** Polycarbonate, pre-treated polyester

### USER INFORMATION

*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. See full disclaimer at the end of the document.*

**MESH** 255-355 threads per inch (100-140 threads per centimeter) monofilament polyester mesh for most applications

**STENCIL** Solvent resistant direct emulsions and capillary films

**SQUEEGEE** 70-80 durometer polyurethane squeegee

**COVERAGE** 1800- 3000 square feet per gallon depending upon ink deposit

**PRINTING** The 60024029KI Special Mirror Silver ink exhibits excellent on-screen stability. Adding small, incremental amounts of fresh ink to the screen throughout the print run also helps maintain on-screen stability. Thoroughly mix the ink prior to printing. The ink must be mixed at low shear to prevent damaging the aluminum pigment.

The ink appears very viscous but breaks down with shear or stirring.

Maintain ink temperatures at 65°-90°F (18°-32°C) for optimum print drying performance. Lower temperatures increase the ink viscosity, impairing both flow and drying. Elevated temperatures lower the ink viscosity, reducing print definition, film thickness and opacity.

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

**DRYING** 60024029KI ink dries by solvent evaporation. The ink may be dried at room temperature or in a 140°F (60°C) oven for at least 15 minutes (drying time depends on mesh used and other factors affecting ink film thickness). Conveyor drying may be used using temperatures at or below 140°F (60°C). The ink film must be dry to touch, after which time the ink film may be dried at higher temperature to speed up the drying. Drying at higher temperatures may affect the mirror-like appearance. The ink must be thoroughly dried for optimal properties. Due to varying ink deposits and production equipment, it is recommended that the printer evaluate the drying time and temperature that will allow the maximum reflectance for the specific application. Good air circulation is necessary to remove the vaporized solvents.

**ADDITIVES** Thinner: RE180 Thinner may be added up to 30% by weight. The 60024029KI is press ready straight out of the container. RE180 may be added if necessary for printability.

#### OVERPRINT

*Overprints:* The Nazdar 3400 Series UV ink system or the 9700 Series solvent ink system may be printed over a thoroughly dried 60024029KI ink film. Refer to the each ink series Technical Data Sheet for more information regarding these inks. Overprinting with a clear or solid color ink will provide some protection to the metallic. Due to the pigment load and nature of metallic pigments, the 60024029KI may not exhibit satisfactory adhesion to the substrate and overprints will not pass tape and cross hatch tape tests. The absence of overprint will not affect the mirror effect. Overprinting with other inks systems may cause incompatibility which affects the mirror finish; test thoroughly.

*Due to the nature of the metallic pigments used for these types of products, the layer of mirror silver may not pass tape and cross hatch tape tests. The metallic pigment has the tendency to split or parts will lift off upon removal which makes the mirror layer the weakest interface. Overprinting with a compatible ink layer will not improve this interface. It is the printer's or end user's responsibility to pre-test prior to any production run to determine acceptability of the printed part to end use requirements.*

#### CLEAN UP

*Screen Wash (Prior to Reclaim):* Use IMS201 Premium Graphic Screen Wash.

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

#### STORAGE

Store tightly covered at temperatures between 65°-90°F (18°-32°C). Ink taken from the press should not be returned to the original container; store separately to avoid contaminating unused ink.

#### 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 60024029KI Material Safety Data Sheet for further instructions and warnings.

### PRODUCT OFFERING

#### PACKAGING

60024029KI is available in 1- kilogram and 1-gallon containers.

#### PACKAGING

Cleaners are available in 1-gallon, 5-gallon and 55-gallon containers. Additives are available in 1-gallon containers.

Stock Number	Additive	Stock Number	Clean Up
RE180	Thinner	IMS201	Premium Graphic Screen Wash
		IMS301	Premium Graphic Press Wash

*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®.*

Based on information from our raw material suppliers, this product is formulated to contain less than 0.06% lead. If exact heavy metal content is required, independent lab analysis is recommended.

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