652663PS
DOMING RECEPTIVE CLEAR UV SCREEN INK

TECHNICAL DATA SHEET

652663PS Doming Receptive Clear is a UV curable ink for screen printing on areas where a doming clear is going to be applied, providing a barrier coat between the doming clear and the substrate. The application of 652663PS is necessary in cases where the doming clear does not adhere to the substrate or does not wet the substrate.

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	280 – 355 tpi (110 - 140 tpcm) monofilament polyester mesh for most applications
STENCIL	Solvent resistant, UV ink compatible direct emulsions and capillary films
SQUEEGEE	70 - 80 durometer polyurethane squeegee
COVERAGE	2500 - 3500 square feet (232 – 325 square meters) per gallon depending upon ink deposit
PRINTING	The 652663PS is formulated to be press ready. Thoroughly mix the ink prior to printing. Maintain ink temperature at 65˚-90˚F (18˚-32˚C) for optimum print and cure performance. Lower temperatures increase the ink viscosity, impairing both flow and cure. 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 curing variables/conditions. The ink can be affected by stray UV light in and around a printing facility. Be aware of skylights, windows and overhead lights curing the ink in the screen. Light filters are recommended.
CURE PARAMETERS	The 652663PS cures when exposed to a medium pressure mercury vapor lamp set at 200 watts per inch with millijoules (mJ) and milliwatts (mW) of: 180 mJ/cm² @ 600 mW/cm² These guidelines are intended only as a starting point for determining cure parameters, which must be determined under actual production conditions. 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 condition and focus to the substrate. The values mentioned above 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.
CLEAN UP	*Screen Wash (Prior to Reclaim):* Use IMS203 Economy Graphic Screen Wash or IMS207C Graphic Recirculating 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.

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GENERAL INFORMATION

INK HANDLING	Direct skin contact to UV inks is the primary route of exposure and irritation. Therefore, it is recommended that all personnel handling this product 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 652663PS Material Safety Data Sheet for further instructions and warnings. The 652663PS is a one-part, 100% solids UV-curable screen printing ink and does not contain N-vinyl-2-pyrrolidone (trade name V-Pyrol®).
ADHESION TESTING	Even when recommended UV energy output levels are achieved, it is imperative to check adhesion on a **cooled down** print: 1. Touch of ink surface – the ink surface will be smooth and slick. 2. Thumb twist – the ink surface will not mar or smudge. 3. Scratch surface – the ink surface will resist scratching. Cross hatch tape test – 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, wait for 1 minute and rip off at a 180 degree angle. Ink should only come off in actual cut areas.

PRODUCT OFFERING

PACKAGING	652663PS Doming Receptive Clear is available in one gallon containers.
PACKAGING	Additives/Reducers are available in gallons containers. Cleaners are available in gallon, 5 gallon and 55 gallon containers.

Stock Number	Cleaners	Stock Number	Cleaners
IMS203	Economy Graphic Screen Wash	IMS301	Premium Graphic Press Wash
IMS207C	Graphic Recirculating 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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