69097118 UV SPDR CLEAR PRIMER

TECHNICAL DATA SHEET

69097118 UV SPDR Clear Primer has been formulated to be used as a screen printable, digital receptive primer coat for treated polypropylene corrugated plastic to increase adhesion of UV Digital Inks.

SUBSTRATES	Treated polypropylene corrugated plastic with a surface tension at or above 44 dynes/cm (not recommended for container or nameplate applications)
DIGITAL PRINTERS	The digital printers at the stated settings have exhibited excellent results. These guidelines are intended only as a starting point for determining print settings, which must be determined under actual production conditions. *Vutek 320 UV Digital Inks:* 40 IPS, heavy smoothing, single head cure, medium lamp speed, 100% vacuum *Vutek 200 UV Digital Inks:* 40 IPS, medium smoothing, double head cure, medium lamp speed, 100% vacuum

SCREEN PRINTING 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	355-380 tpi (140-150 tpcm) monofilament polyester mesh for most applications
STENCIL	Solvent resistant, UV ink compatible direct emulsions and capillary films
SQUEEGEE	70-90 durometer polyurethane squeegee
PRINTING	Maintain ink temperature at 65°-90°F (18°-32°C) for optimum print and cure performance. 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. Be aware of skylights, windows and overhead lights curing the ink in the screen. Leaving a container uncovered may result in the ink's surface forming a "skin," caused by reaction with room lighting or other stray lights. Keep containers covered. Light filters are recommended.
CURE PARAMETERS	69097118 UV SPDR Clear Primer cures when exposed to a medium pressure mercury vapor lamp set at 200 watts per inch with millijoules (mJ) and milliwatts (mW) of: 100-130 mJ/cm² @ 600+ mW/cm² for 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, block resistance, and higher residual odor. "Overcuring" the ink may reduce the flexibility of the printed part and adhesion of subsequent printing. 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.

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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.

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 affected area with soap and water. Consult the Material Safety Data Sheet for further instructions and warnings. 69097118 UV SPDR Clear Primer 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: • Scratch the surface of the print using light pressure. Full adhesion characteristics are demonstrated within 24 hours after cure.
PACKAGING	69097118 UV SPDR Clear Primer is available in gallon containers. Cleaners are available in gallon, 5 gallon, and 55 gallon containers.

Stock Number	Clean Up		Stock Number	Clean Up
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, these products are formulated to contain less than 0.06% lead.
If exact heavy metal content is required, independent lab analysis is recommended.

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