

70000 Series Platic-Vac Gloss Screen Ink is designed for Point-of-Sale displays and signage printed onto a variety of substrates, especially where post-print forming is required. 70000 Series has excellent adhesion to such surfaces as acrylics, cellulose acetate butyrate, styrene and rigid vinyl. 70000 Series exhibits excellent formability. Please check to determine suitability for the depth of draw desired. Adhesion and gloss are normally improved by the heating involved in most vacuum forming processes.

SUBSTRATES Polystyrene, rigid vinyl, acrylics

USER INFORMATION

MESH 200-305 tpi (78-120 tpcm) monofilament polyester mesh for most applications

STENCIL Solvent resistant direct emulsions and capillary films

SQUEEGEE 70-80 durometer polyurethane squeegee

COVERAGE 1,200-1,600 square feet (111 - 148 square meters) per gallon depending upon ink deposit

PRINTING 70000 Series requires 10% - 15% reduction to prevent drying in the screen and assure consistent ink flow during printing (See Additives section). 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 inks prior to printing.

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 70000 Series will air dry in 20-40 minutes. 70000 Series may be jet dried in a dryer with temperatures from 90°-150°F (32°-66°C). Drying times are dependent on ink deposit and air flow.

CLEAR / VARNISHES Mixing Clear / Metallic Mixing Clear: Use 70170 Clear to reduce the density of colors or as a clear base for specialty additives such as Metallics.

ADDITIVES All additives should be thoroughly mixed into the ink before each use. Prior to production, test any additive adjustment to the ink.

Reducer: Use 70180 to reduce the viscosity and improve flow of these inks. Add up to 15% by weight.

Retarder: Use a blend of 10%-15% of 70180 and 5% of 70182 to prevent drying in the screen during hot climate conditions or for slower drying. Over reduction with retarder can result in blocking.

CLEAN UP Screen Wash (Prior to Reclaim): Use IMS201 Premium Graphic Screen Wash
Press Wash (On Press): Use IMS301 Premium Graphic Press Wash

STORAGE

The inks react to temperature. 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

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 70000 Series Material Safety Data Sheet for further instructions and warnings.

ADHESION TESTING

1. Touch of ink surface – the ink will be dry.
2. Scratch surface – the ink will resist scratching.
3. 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

STANDARD PRINTING COLORS

Standard Printing Colors have excellent opacity.

TRANSPARENT COLORS

Transparent Colors can be used in color matches or let down with mixing clear.

METALLIC COLORS

70185 Brilliant Pale Gold and 70187 Silver are available as stock colors. (See Special Additives for more information)

SPECIAL ADDITIVES

When inks are to be printed over a special effect color, the overprinting ink(s) 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 70170inks. These pigments are available in 1-pound containers. Contact Nazdar for the item number(s) and availability of each special effect product.

Metallics: Mix only enough metallic ink to be used the same day. Chemical reactions in metallic inks may result in viscosity, color and printability changes over time.

Pearlescents / Interference / Multi-Chromatic: See the Pearlescent, Interference, and Multi-Chromatic Technical Data Sheets for more information.

COLOR CARD MATERIALS

The following is a list of screen printed samples available.

Special Effects Color Card: shows Metallic, Pearlescent, Interference, and Multi-Chromatic effects mixed with clear

PACKAGING

All items listed below are available in gallon containers.

Stock Number	Standard Printing Colors	Stock Number	Transparent Colors
70104	Bright Red	+ 70110	Transparent Red
70105	Permanent Red	+ 70139	Majestic Yellow
+ 70107	Permanent Maroon	+ 70149	Permanent Green
+ 70111	Black	+ 70159	Permanent Blue
+ 70112	White	+ Stock Number	Metallic Colors
+ 70114	Brown	+ 70185	Brilliant Pale Gold
70124	Orange	+ 70187	Silver
70130	Primrose Yellow		
70134	Chrome Yellow		
70142	Emerald Green		
70148	Dark Green		
+ 70152	Light Blue		
+ 70157	Royal Blue		
+ 70170	Clear		

PACKAGING

Additives/Reducers are available in gallon and 5 gallon containers.

Cleaners are available in gallon, 5 gallon and 55 gallon containers.

Stock Number	+Additives/Reducers	Stock Number	+Clean Up
70180	Thinner	IMS201	Premium Graphic Screen Wash
70182	Retarder	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, these products are formulated to contain less than 0.06% lead. If exact heavy metal content is required, independent lab analysis is recommended.

Nazdar 8501 Hedge Lane Terrace, Shawnee, KS 66227-3290
 Toll Free: 866.340.3579 Phone: 913.422.1888 Fax: 913.422.2296
<http://www.nazdar.com>; e-mail: custserv@nazdar.com