

PSPC Nitrogen Texture Overprint Clear UV Screen Inks have been specifically formulated for top or first surface printing on polycarbonate and some top coated or print treated polyester used in membrane overlay applications. These inks are not recommended for hard coated polycarbonate and polyester surfaces.

These inks will produce a variety of textures when cured in an inert atmosphere using a germicidal lamp. The appearance of the texture will depend on ink deposit, nitrogen flow and belt speed. Some of the inks may be mixed together to achieve different textures. Please refer to the chart on the last page to determine ink compatibility.

Properly cured, these inks will exhibit excellent adhesion as well as solvent, moisture and mar resistance.

SUBSTRATES Polycarbonate and some pre-treated or primed polyesters

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 305 - 420 threads per inch (120 – 165 threads per cm) monofilament polyester mesh for most applications.

STENCIL Solvent resistant, UV ink compatible direct emulsions and capillary films

SQUEEGEE 70-90 durometer polyurethane squeegee

COVERAGE 2500 to 4000 square feet (232 – 372 square meter) per gallon depending upon ink deposit

PRINTING The PSPC Series inks are 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, and film thickness.
 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 to "skin," caused by initial chemical reaction with room lighting or other stray lights. Light filters are recommended.

CURE PARAMETERS PSPC Nitrogen Texture Overprint Clears need an inert atmosphere (nitrogen) for texturing and curing. Texture is achieved using a germicidal lamp in an inert atmosphere. Surface hardness is exhibited after curing in an inert atmosphere immediately after texturing. The appearance of the texture will depend on ink deposit, nitrogen flow and conveyor speed.

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 RE301 UV Reducer to reduce the viscosity of these inks. Add up to 10% by weight. The addition of reducer may increase gloss and/or change texture effect.

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

Inks react to light and 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.

PROCESSING

Finishing: Allow at least a 24-hour post cure before die cutting or embossing.

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 these products 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 PSPC Series Material Safety Data Sheet for further instructions and warnings.

The PSPC Series inks are a one-part, 100% solids UV-curable screen printing inks.

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 dry to touch.
2. Thumb twist – the ink surface will not mar or smudge.
3. Scratch surface – the ink surface will resist scratching
4. 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.

Full adhesion characteristics are demonstrated within 24 hours after cure.

PRODUCT OFFERING

STANDARD TEXTURES

The Standard Textures have excellent flow characteristics, and are intended to work well from the container.

COLOR CARD MATERIALS

The following is a list of screen printed samples available.

UV Texture Clears Color Card: shows all standard UV texture clears available.

3400 Series UV Screen Ink Color Card: shows all standard 3400 colors.



PSPC SERIES NITROGEN TEXTURE OVERPRINT CLEAR UV SCREEN INKS

TECHNICAL DATA SHEET

PACKAGING All items listed below are available in gallon containers.

Stock Number	Standard Textures	Compatible With
PSPC27	Very Coarse Nitrogen TC	PSPC27T
PSPC27H*	Very Fine Nitrogen TC	
PSPC27T	Fine Nitrogen TC	PSPC27
PSPC27Y*	Fine Nitrogen TC	

* These clears contain N-vinyl-2-Pyrrolidone (NVP), trade name V-Pyrol®. These clears are intermixable with each other and with other PSPC clears.

PACKAGING Additives/Reducers are available in quarts.
Cleaners are available in quart and gallon containers.

Stock Number	Additives/Reducers	Stock Number	Cleaners
RE301	UV Reducer	IMS203	Economy Graphic Screen Wash
		IMS207C	Graphic Recirculating 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, these products are formulated to contain less than 0.06% lead. If exact heavy metal content is required, independent lab analysis is recommended.

Nazdar Worldwide Headquarters
8501 Hedge Lane Terrace, Shawnee, KS 66227-3290 USA
Toll Free: 866.340.3579 or Tel: 913.422.1888 Fax: 913.422.2296
e-mail: custserv@nazdar.com

Nazdar Limited
Barton Road, Heaton Mersey, Stockport, England SK4 3EG
Tel: + (44) 0.161.442.2111 Fax: + (44) 0.161.442.2001
e-mail: technicalservicesuk@nazdar.com

<http://www.nazdar.com>