

The W300 Series Water-Base Film Ink is specifically formulated to meet the demands of today's Narrow Web Label converters. The W300 Series Water-Base Film Ink features:

- ❖ High Speed Printing
- ❖ Easy to use
- ❖ High Color Strength
- ❖ Compatible with Water-base and UV Coatings
- ❖ Fast Drying
- ❖ Available in 3 bcm, 4 bcm, and 5 bcm
- ❖ Process Colors available for 1.0 bcm to 2.0 bcm

SUBSTRATES

Pressure sensitive vinyl, top coated and print treated polyester, BOPP films, coated paper and board.

Note: As with all film substrates, lots may vary and testing is recommended before use.

USER INFORMATION

Anilox Volumes – Recommended 3.0 bcm - 5.0 bcm

Viscosity – On average 14-25 sec., #3 Zahn @ 77°F

pH Range – 9.0 – 10.0

Printing – The W300 Series inks have excellent adhesion to a wide variety of substrates. Surface energy should be at least 38 dynes/cm to achieve proper adhesion. The use of in line, on press corona treatment can increase the dyne level of most substrates.

Listed below are other tips to consider during the printing process:

1. **Viscosity too high** – An addition of 2 – 3 ounces at a time of CARE73 Stabilizer will reduce the viscosity without reducing color strength too quickly.
2. **Increase Dry Rate** – A mixture of Isopropyl Alcohol/Water (50%/50%) will help increase the dry rate. Care should be used in premixing the Isopropyl Alcohol and Water first to avoid shocking the ink.
3. **Decrease Dry Rate** – The addition of RE198 Slow Reducer in increments of 1% up to 5% is used to slow down dry rate.
4. **Color too Strong**-Additions in the amounts of 2%-5% at a time of Transparent White can be used to reduce color strength without reducing viscosity. Record all adds to inks along with the amounts.

5. **Ink foaming**-The addition of CARE75 Defoamer in small amounts to the ink pan will help reduce foaming. (Add a half a capful to end of the journals or 1 capful per gallon to the pump container). Too much CARE75 can cause pinholes in the print.
6. **Increase pH**-Add 1% of CARE74 PH Adjuster to the ink pan or pump container. The pH of the inks should be maintained between 9.0-10.0. Let adds mix for a few minutes to ensure they have been mixed thoroughly into the ink. If inks have been allowed to set in the pan or pump for extended time, viscosity and pH should be checked and adjusted if necessary.
7. Clean anilox rolls on a regular basis. Use a brass brush for Chrome rolls and a stainless brush for ceramic rolls.

GENERAL INFORMATION

STORAGE

Always store ink in a tightly closed container. Ink storage of 6 months should not affect the print quality. Longer periods of storage, simply open the container and add 1-2 ounces of Paper Print Aid and stir or shake well.

Adhesion Testing- Use 610 / 810 Tape

INK HANDLING

Safety glasses and gloves are suggested in areas where product may be splashed. If product 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 W300 Series Material Safety Data Sheet for further instructions and warnings

PRODUCT OFFERING

Standard Printing Colors – The W300 Film Series is available in 3 ranges of standard printing colors when using a 3bcm, 4bcm and 5bcm anilox rollers. There is also a set of (FR) colors.

4 Color Process- The W300 Series 4 color process inks are designed to print with anilox rollers having 1-2 bcm. W300 is also available in fade resistant (FR) colors.

Fade Resistance- The W300 Series Ink offers a line of Fade Resistant colors. These colors are designated with (FR) in their descriptions.

ADDITIVES

CARE75 Defoamer- Designed to be poured directly into an ink to stop foaming. It is recommended to add ½%-1% into the ink when needed. Do not add more than 1% or pinholes in the print may occur.

CARE74 PH Adjuster-Designed to replace the Amines that are lost due to evaporation on long press runs. PH Adjuster is compatible with most Water-base ink, which has a PH range of 9.0-10.0. PH Adjuster should be used on long press runs where ink had been maintained with water.

CARE73 Stabilizer-Designed to reduce the viscosity, replace the Amines, and water lost due to evaporation.

CARE77 Film Print Aid- Formulated for Film Ink System to raise the PH and slow down drying without lowering the viscosity of the ink. Film Print Aid will aid in cleaner print, less build up on the plates by increasing the re-wetability of an ink.

CARE90 Viscosity Increaser-Designed to increase the viscosity of the ink with affecting color strength. It is recommended to add 0.25%-0.50% into the ink to raise the viscosity 5-10 seconds in a #3Zahn cup.

ADDITIVE PERCENTAGE

	1 Qt. = 32 oz.	½ Gal. = 64 oz.	1 Gal. = 128 oz.	5 Gal.= 640 oz.
1%	.32 oz.	.64 oz.	1.28 oz.	6.40 oz.
2%	.64 oz.	1.28 oz.	2.56 oz.	12.80 oz.
3%	.96 oz.	1.92 oz.	3.84 oz.	19.20 oz.
4%	1.28 oz.	2.56 oz.	5.12 oz.	25.60 oz.
5%	1.60 oz.	3.20 oz.	6.40 oz.	32.00 oz.

The following products are available in 3bcm, 4bcm and 5bcm. Part numbers for the 3bcm and 4 bcm are listed below. Part numbers for the 5 bcm are not shown but are available upon request.

Standard Colors	3bcm/PN	4bcm/PN
Opaque White	W300308	W300408
Black	W300309	W300409
Transparent White	W300010	W300010
Yellow	W300311	W300411
Orange	W300312	W300412
Warm Red	W300313	W300413
Rubine Red	W300314	W300414
Rhodamine Red	W300315	W300415
Purple	W300316	W300416
Violet	W300317	W300417
Reflex Blue	W300318	W300418
FR Process Blue (BW8)	W300319	W300419
FR Green (BW8)	W300320	W300420

Fade Resistant Colors	3bcm/PN	4bcm/PN
FR Yellow (BW6)	W300321	W300421
FR Orange (BW6)	W300322	W300422
FR Warm Red (BW6)	W300323	W300423
FR Rubine Red (BW6)	W300324	W300424
FR Rhodamine Red (BW8)	W300325	W300425
FR Purple (BW8)	W300326	W300426
FR Violet (BW8)	W300327	W300427
FR Reflex Blue (BW8)	W300328	W300428
Process Colors	Part No's	
Process Yellow	W300041	
Process Magenta	W300042	
FR Process Yellow (BW6)	W300051	
FR Process Magenta (BW6)	W300052	
FR Process Cyan (BW8)	W300053	
FR Process Black (BW8)	W300054	
Process Extender	W300090	
Additives		
Stabilizer	CARE73	
PH Adjuster	CARE74	
Defoamer	CARE75	
Print Aid Film	CARE77	
Reducers		
Slow Reducer	RE198	
Cleaner		
EZ Cleaner	NCW10	

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 flexo 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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