

The W500 Series Water-Base Shrink Sleeve Ink is designed to meet the demands of today's Narrow Web Shrink Labels. The W500 Series was made for "Reverse Print" Shrink Sleeves for PVC and PET Films.

The W500 Series Water-Base Shrink Sleeve Ink features

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

## SUBSTRATES

PVC and PET

**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 W500 Series inks have excellent adhesion to PVC and PET 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 Film 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 W500 Series Material Safety Data Sheet for further instructions and warnings

## PRODUCT OFFERING

**Standard Printing Colors** – The W500 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 W500 Series 4 color process inks are designed to print with anilox rollers having 1-2 bcm. W500 is also available in fade resistant (FR) colors.

**Fade Resistance**- The W500 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.

### 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 and 4bcm. Part numbers for the 3bcm are listed below. Part numbers for the 4 bcm are not shown but are available upon request.

Standard Colors	3bcm/PN
Opaque White	W500308
Black	W500309
Transparent White	W500010
Yellow	W500311
Orange	W500312
Warm Red	W500313
Rubine Red	W500314
Rhodamine Red	W500315
Purple	W500316
Violet	W500317
Reflex Blue	W500318
FR Process Blue (BW8)	W500319
FR Green (BW8)	W500320
Reverse Print Shrink White	60016140W5

Fade Resistant Colors	3bcm/PN
FR Yellow (BW6)	W500321
FR Orange (BW6)	W500322
FR Warm Red (BW6)	W500323
FR Rubine Red (BW6)	W500324
FR Rhodamine Red (BW8)	W500325
FR Purple (BW8)	W500326
FR Violet (BW8)	W500327
FR Reflex Blue (BW8)	W500328
Process Colors	Part No's
Process Yellow	W500041
Process Magenta	W500042
FR Process Yellow (BW6)	W500051
FR Process Magenta (BW6)	W500052
FR Process Cyan (BW8)	W500053
FR Process Black (BW8)	W500054
Process Extender	W500090
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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