

60018680AD Special Electronic Black Epoxy Screen Ink has been formulated with high quality epoxy resins for excellent adhesion to various plastics, metals, glass and a wide range of hard-to-print substrates.

The 60018680AD is a two-part ink and must be initiated with a catalyst prior to use. The ink exhibits a high gloss finish and is intended for indoor applications only.

**SUBSTRATES** Treated polypropylene, treated polyethylene, epoxy, melamine, metals, glass, PC boards

## 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** 255-420 threads per inch (100-165 threads per centimeter) monofilament polyester mesh or stainless steel mesh for most applications

**STENCIL** Solvent resistant direct emulsions and capillary films

**SQUEEGEE** 70-80 durometer polyurethane squeegee

**COVERAGE** 1200-2500 square feet (111-167 square meters) per gallon depending upon ink deposit

**PRINTING**

*Ink Preparation:* Add 1 part ADE678 Glass Catalyst to 5 parts 60018680AD ink by weight. Allow the catalyzed ink mixture to stand for a period of about 30 to 45 minutes. This time lag, referred to as the “induction period,” is necessary to allow the catalyst to become uniformly mixed and available for the polymerization (cross linking) process. Pot life of the catalyzed ink is approximately 6 to 8 hours.

To maintain on-screen stability, add additional ink in small increments throughout the print run. Thoroughly mix the inks prior to printing.

Maintain ink temperature at 65°-90°F (18°-32°C) for optimum print and 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/  
CURING**

Baking for at least 20 minutes at 140°F (60°C) is recommended. The ink will continue to cure for several days so final properties will not be achieved immediately. Increasing the time and/or temperature of the baking process will increase initial level of adhesion.

Good air circulation is necessary to remove the vaporized solvents. Multiple layers of ink may require longer drying times than a single layer.

**ADDITIVES**

All additives should be thoroughly mixed into the ink before each use.

*Reducer:* Use RE190 Thinner or RE189 Slow Thinner to reduce the viscosity of these inks for best printing results. Add up to 15% by weight.

*Retarder:* To prevent drying in the screen during hot humid conditions, add RE182 Retarder sparingly.

*Catalyst:* ADE678 Glass Catalyst, add 1 part catalyst to 5 parts ink by weight. Ink mixed with ADE678 has a 6 to 8 hour pot life.

*Flow Control:* CARE8 Flow Control Agent may be added from ½% to 1% by weight



# 60018680AD SPECIAL ELECTRONIC BLACK EPOXY SCREEN INK

## TECHNICAL DATA SHEET

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

**STORAGE** Store tightly covered at temperatures between 65°-90°F (18°-32°C). Catalyzed ink taken from the press must be disposed of properly.

### 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 60018680AD Material Safety Data Sheet for further instructions and warnings.

**ADHESION TESTING** 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.

**PACKAGING** 60018680AD is available in kilogram and/or gallon containers.

**PACKAGING** Additives/Reducers are available in quart, liter and/or gallon containers.  
Cleaners are available in 1-gallon, 5-gallon and 55-gallon containers.

Stock Number	Additives/Reducers	Stock Number	Clean Up
ADE678	Glass Catalyst (liters only)	IMS201	Premium Graphic Screen Wash
CARE8	Flow Control Agent	IMS301	Premium Graphic Press Wash
RE182	Retarder (gallons only)		
RE189	Slow Thinner (gallons only)		
RE190	Thinner (gallons only)		

*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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