

9400 Paper Series UV Flexo Ink was specifically formulated for Tag and Label printing. These inks have excellent rheology characteristics making them ideal for most printing equipment, and product applications.

## SUBSTRATES

Paper, Board and some films.

## USER INFORMATION

### ANILOX ROLLS

300-1200 line (cells per inch) corresponding to a volume from 7.5 to 0.8 bcm.

### PLATES

9400 Series is compatible with most UV Flexo plates on the market

### PRINTING

9400 Series can be printed over Rotary Screen 8376 No-Sil Combination White. (See the 8300 Series technical data sheet for more information).

The 9400 Series ink is 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. Pretest to determine optimum printing performance for each set of ink, substrate, anilox, press, curing variables/conditions and any post printing processes. The 9400 Series can be affected by stray UV light in and around a printing facility. Be aware of skylights, windows and overhead lights curing the ink. Light filters are recommended. Keep ink containers covered when not in use.

### CURE PARAMETERS

9400 Series ink cures at web speeds up to 1000 fpm when exposed to a medium pressure mercury vapor lamp set at 300 - 600 watts per inch

These guidelines are intended only as a starting point for determining cure parameters, which must be determined under actual production conditions.

### CLEAR / VARNISHES

9410 Base Transparent White can be used to reduce the strength of the base, process, metallics and fluorescent colors.

### 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 RE393 UV Reducer to reduce the viscosity of these inks. Add up to 10% by weight.

### CLEAN UP

Use NWC10 EZ Cleaner

### STORAGE

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

Direct skin contact to UV inks is the primary route of exposure and irritation. Therefore, it is recommended that all personnel handling UV 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 9400 Series Material Safety Data Sheet for further instructions and warnings.

The 9400 Series ink is a one-part, 100% solids UV-curable Flexo printing ink and does not contain HDODA or Benzophenone.

### 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 smooth and slick.
2. Thumb twist – the ink surface will not mar or smudge.
3. Scratch surface – the ink surface will resist scratching.
4. Tape test – apply 3M #610/810 clear tape, rub down, and rip off at a 180 degree angle. Ink should not come off.

### FADE RESISTANCE

The 9400 Series inks are designed for interior applications only. The colors designated with (FR) use pigments which have extended fade resistance.

## PRODUCT OFFERING

### PROCESS COLORS

Standard process colors are formulated to print using up to 1200 line (0.8 bcm) anilox.

### BASE COLORS

9400 Base Colors are designed to be high strength. The colors can be mixed together to achieve an unlimited number of strong vibrant colors.

### OTHER AVAILABLE PRODUCTS

Fluorescent Colors – See 9300 UV Flexo Fluorescent Data Sheet.

Metallic Colors- See 9300 UV Flexo Metallic Data Sheet.

### PACKAGING

The Opaque White is available in 11 lb and 50 lb containers, Base Transparent White is available in 8 lb and 40 lb containers, all other colors are available in 9 lb and 45 lb containers.

Stock No.	Base Printing Colors
9408	Opaque Base White/Blanco (BW8)
9409	Base Black/Negro (BW8)
9410	Base Transparent White/Blanco
9411	Base Yellow/Amarillo (BW5)
9412	Base Orange/Naranja(BW6)
9413	Base Warm Red/Rojo (BW5)
9414	Base Rubine Red/Rojo (BW4)
9415	Base Rhodamine Red/Rojo (BW4)
9416	Base Purple/Morado (BW4)
9417	Base Violet/Violeta (BW5)
9418	Base Reflex Blue/Azul (BW5)
9419	Base Process Blue/Azul (BW8)
9420	Base Green/Verde (BW8)
Stock No.	Fade Resistant (FR) Colors
9421	FR Yellow/Amarillo (BW7)
9422	FR Orange/Naranja (BW7)
9423	FR Warm Red/Rojo (BW7)
9424	FR Rubine Red/Rojo (BW8)
9425	FR Rhodamine Red/Rojo (BW8)
9426	FR Purple/Morado (BW8)
9427	FR Violet/Violeta (BW8)
9428	FR Reflex Blue/Azul (BW8)

Stock No.	Process Colors
9441	Process Yellow/Amarillo (BW5)
9442	Process Magenta/Rojo (BW5)
9443	FR Process Cyan /Azul (BW8)
9444	FR Process Black/Negro (BW8)
9447	FR Process Yellow/Amarillo (BW7)
9448	FR Process Magenta/Rojo (BW8)
Stock No.	Additives
RE393	UV Reducer
Stock No.	Cleaner
NWC10	EZ Cleaner

*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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