

650 Series

650 Series Rotary Screen

THINNING

Stir well before every use. Ink can be thinned up to 8% with 650-TH Thinner. To increase cure speed, thin up to 5% with 650-FTH Fast Thinner.

MESH

Rotary Screen: 5 to 15 micron rotary screens are recommended. Flat Screen applications use 305-420T (120-165/cm) monofilament or equivalent.

STENCILS

Stencil materials must be solvent resistant and produce a thin film stencil (3-6 microns over mesh). Dirasol 911, SuperCoat 915, SuperCoat 916, and SuperCoat 917 dual cure, or Dirasol 132 one pot direct emulsions are recommended to give the highest print quality, minimize deposit variables, and improve economy.

COVERAGE

Standard line colors should give a coverage of 3000-3800 square feet/gallon (74-86 m²/liter) provided the ink deposit is between .50 and .70 mil. thick (12 and 18 microns)

UV Gloss rotary screen Applications

650 Series Rotary Screen Key

Features:

- Flexible, high-gloss finish
- Intense color strength
- Fast cure speeds
- High chemical and solvent resistance
- Excellent opacity
- Low odor
- Minimal substrate edge curl
- Wide adhesion range

Media Type

- Coated & Uncoated paper and board
- Pressure sensitive vinyls
- Top coated or print treated, polyesters, polyethylenes and BOPP films
- Polystyrenes

CURING

In a curing unit containing two 300-watt/inch (120-watt/cm) lamps, cure speeds of up to 200 ft. (43m) per minute are possible. Cure speeds are dependent on colors, film thickness, opacity, and condition of the lamps.

PRE-PRODUCTION TEST

It is strongly recommended that all plastics be tested before use as supposedly similar plastics can vary between different manufacturers and even between different batches from the same manufacturer.

Certain plastics may be impregnated with lubricants which, like plasticizer migration, may impair adhesion and block resistance even a considerable period after printing. In line corona treatment of the substrate may improve adhesion where surface tension levels are below 38-40 dyne/cm.

END-USER MUST DETERMINE SUITABILITY OF THIS PRODUCT FOR THE INTENDED USE PRIOR TO PRODUCTION.

PRODUCT RESISTANCE CHARACTERISTIC

650 Series inks have excellent resistance to chemicals and abrasion. For optimum resistance using 650 Series inks, a durable UV varnish overprint can also be used. 650-MX can be used as an overprint varnish.

THE INTENSE MATCHING SYSTEM

The Intense Matching System has been designed to enable printers to readily match special colors in house. The system consists of eight base colors, each of which has been selected for its cleanliness of tone and suitability for intermixing. Using the Intense base colors plus Black, Tinting White, and Mixing Clear, almost any color can be produced.

SPECIAL MATCHES

Special colors can be supplied against prints, wet ink, PANTONE®* numbers, or other Nazdar standard colors.

*Pantone, Inc's check-standard trademark for reproduction and color reproduction.

WASH UP

Anilox rolls can be washed up with commercial wash solutions designed for UV flexographic inks. Consult screen and supplier for recommended cleaning solutions

650-CW RS COMBINATION WHITE

This revolutionary new product has been designed specifically for use in combination printing as a basecoat white. Its unique chemistry eliminates the need to add adhesion modifiers to the flexo and/or letterpress inks printed over top and simplifies the combination printing process.

650-CWHD is an optically bright white, which delivers improved productivity and ease of use while maintaining Nazdar's high standards for image quality. It works well with all Gallus, Stork and Telstar screen units. It is not recommended for use as a tinting white in color matches. For best results, contamination from other silicone containing products should be avoided

STORAGE

Containers should be tightly closed immediately after use. At the end of long printing runs, surplus ink from the screen should be disposed of. 650 Series Rotary Screen inks and reducers should not be stored in direct sunlight or extreme temperatures. Refer to Material Safety Data Sheet (MSDS) for materials and conditions to be avoided.

In the interest of maximum shelf life, storage temperatures should be between 50°F (10°C) and 77°F (25°C).

Shelf Life: 18 months from date of manufacture (Unopened 1 gallon containers). Please consult Shelf Stability from Date of Manufacture at [Shelf Life Chart](#) for other container sizes, fluorescents & metallics

SAFETY AND HANDLING

Refer to MSDS for safety, handling, and waste disposal information.

SPECIFICATIONS: 650 SERIES

Metallic Shades

Metallic shades can be obtained by mixing 650-MX Mixing Clear with Gold and Silver powders. Recommended mixing ratios are as follows:

- ▶ Gold Powder - 20 parts by weight
- ▶ 650-MX - 80 parts by weight
- ▶ Silver Powder - 10 parts by weight
- ▶ 650-MX - 90 parts by weight

All percentages by weight. 600 Series Metallics may be tinted if required by 5-10% additions of 650 Rotary Screen Intense Matching System colors.

Standard Color Range

- ▶ 650-064 - IMS Yellow GS
- ▶ 650-066 - IMS Yellow RS
- ▶ 650-114 - IMS Orange
- ▶ 650-121 - IMS Red YS
- ▶ 650-164 - IMS Red BS
- ▶ 650-165 - IMS Magenta
- ▶ 650-127 - IMS Violet
- ▶ 650-230 - IMS Blue GS
- ▶ 650-233 - IMS Blue RS
- ▶ 650-325 - IMS Green
- ▶ 650-MX - Mixing Clear
- ▶ 650-TW - Tinting White
- ▶ 650-026 - Brilliant White
- ▶ 650-SB - Shading Black
- ▶ 650-301 - Opaque Black
- ▶ 600-CW - Combination White

Technical Tips for

Running 650-CWHD:

Everything that comes into contact with the ink must be completely clean.

- ▶ No left-over ink can be in the screen head.
- ▶ If ink is pumped to screen head, pump and lines must be flushed or replaced.
- ▶ Squeegee, as well as the inside and outside of squeegee arm, must be clean.
- ▶ Use a new syringe that has been cleaned in Press Wash.

- ▶ Use new screen or clean old one well.

A full head of 650-CWHD is needed.

- ▶ Fill screen head with ink.
- ▶ Use a larger screen mesh circumference to allow more ink inside screen.
- ▶ For smaller diameter screens 650530960 is also recommended.

Fine tuning of the squeegee will be needed.

- ▶ Check pressure and angle of the squeegee.

Reducers

- ▶ 650-TH - Thinner