

667702KI Special Mirror Silver Screen Ink is a solvent-based ink for printing second surface on transparent polycarbonate film. The ink film exhibits a mirror-like reflective surface when viewed through the top or first surface of the polycarbonate film. Adhesion of the ink to substrates other than polycarbonate must be tested prior to any production run. The mirror silver ink is not compatible with laminating adhesives. See section on Overprint. The thoroughly dried ink film may be overprinted with Nazdar screen inks, including 9700 Series, 1800 Series and 2400 Series ink for further protection. Over-printing the mirror ink with other ink systems is not recommended.

Substrates

Polycarbonate (PC)

Substrate recommendations are based on commonly available materials intended for the ink's specific market when the inks are processed according to this technical data. 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. Reference the 'Quality Statement' at the end of this document.

Mesh

305-380 tpi (120-150 tpcm) monofilament polyester mesh for most applications.

Stencil

Use direct emulsions and capillary films which are solvent resistant.

Squeegee

70-80 durometer polyurethane squeegee.

Coverage

Depending upon ink deposit, the estimated coverage per gallon: 2,500 – 3,500 square feet (232 - 325 square meters)
Reference www.nazdar.com/en-us/ColorStar for examples of coverage calculations.

Screen Printing

Add only enough ink to the screen to be able to print for 5-10 minutes. Add additional ink in small increments throughout the print run to maintain screen stability. Thoroughly mix the ink prior to printing. Improper mixing can lead to inconsistent color and ink performance.

Maintain ink temperature at 65°-90°F (18°-32°C) for optimum print and cure performance. Lower temperatures increase the ink viscosity, impairing flow and increasing film thickness. Elevated temperatures lower the ink viscosity, reducing print definition and film thickness.

Pretest to determine optimum printing parameters for a particular set of ink, substrate, screen, press, and curing variables/conditions.

Nazdar does not recommend inter-mixing this ink series with other inks or series.

Drying / Curing Parameters

The ink may be dried at room temperature or in a 140°F (60°C) oven for at least 15 minutes (drying time depends on mesh used and other factors affecting ink film thickness). Drying at higher temperatures may affect the mirror-like appearance. The ink must be thoroughly dried for optimal properties.

Due to varying ink deposits and production equipment, it is recommended that the printer evaluate the drying time and temperature that will allow the maximum reflectance for the specific application. Good air circulation is necessary to remove the vaporized solvents.

Inter-Printable

Thoroughly dry 667702KI ink film before overprinting. Overprinting with a clear or solid color ink will provide some protection to the metallic. Due to the pigment load and nature of metallic pigments, the 667702KI may not exhibit satisfactory adhesion to the substrate and overprints may not pass cross hatch tape test. Overprinting with other ink systems may cause incompatibility which affects the mirror finish; test thoroughly.

Nazdar 667702KI Special Mirror Silver Screen Ink



These inks are suitable to overprint the following screen ink series. Refer to each ink system's Technical Data Sheet for more information regarding either of these inks.

- Nazdar 9700 SV Ink Series
- Nazdar 1800 UV Ink Series
- Nazdar 2400 UV/UV-LED Ink Series

Due to the nature of the metallic pigments used in these types of the product, the layer of mirror silver may not pass tape and cross hatch tape tests. The pigment has the tendency to split or lift off upon removal of tape or adhesives from the printed surface making the mirror layer the weakest interface. Overprinting with other ink systems may cause incompatibility which affects the mirror finish; test thoroughly.

Cleanup

For screen cleaning, similar products to those listed below may be used.

Screen Wash (Prior to Reclaim): Use IMS201 Premium Graphic Screen Wash or IMS203 Economy Graphic Screen Wash
Press Wash (On Press): Use IMS301 Premium Graphic Press Wash

Ink Modifications

Clears / Varnishes

Overprint Clears: the following overprint clear inks may be printed over a thoroughly dried 667702KI ink film: 9727 Mixing Clear.

General Information

Handling

Refer to the SDS for recommendations on handling.

Wear gloves and barrier cream to prevent direct skin contact. Safety glasses are suggested in areas where ink 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 applicable Safety Data Sheet (SDS / MSDS) for further instructions and warnings. For assistance on a wide range of important regulatory issues, consult the following Regulatory Compliance Department link at <http://www.nazdar.com> or contact Nazdar Ink Technologies - World Headquarters (see contact listing at the end of this document).

Storage / Shelf Life

Store closed containers at temperatures between 65°-78°F (18°-25°C). Storing products outside of these recommendations may shorten their shelf life.

Storing products outside of these recommendations could cause the ink to expand in the container. Standard items useable for a period of at least **48 months** from the date of manufacture.

Shelf life above applies to the standard ink items listed on this TDS. To obtain the shelf life for special inks and additives, contact Nazdar Customer Service or Nazdar Technical Service. See contact listing at the end of this document.

Standard Color Range

Based on information from our raw material suppliers, these ink products are formulated to contain less than 0.06% lead. If exact heavy metal content is required, independent lab analysis is recommended.

Packaging / Availability

Contact your Nazdar distributor for product availability and offering.

Item Type	Item Number	Item (or Color) Description
Standard Colors	667702KI	Special Mirror Silver Screen Ink
Cleaners	IMS201	Premium Graphic Screen Wash
Cleaners	IMS203	Economy Graphic Screen Wash

Cleaners	IMS301	Premium Graphic Press Wash
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Nazdar Quality Statement

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®.

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