

9800 Series Poly Plus Screen Ink is specifically formulated to produce a high gloss finish with a stretchable bond on treated polyethylene banner material. Substrates must have a minimum surface energy level of 45 dynes per cm for optimum ink flow and adhesion.

SUBSTRATES Treated polyethylene banner

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 230-260 tpi (90-100 tpcm) monofilament polyester mesh for most applications

STENCIL Solvent resistant direct emulsions and capillary films

SQUEEGEE 70-80 durometer polyurethane squeegee

COVERAGE 1,200-1,400 square feet (110 - 130 square meters) per gallon depending upon ink deposit

PRINTING To improve flow, reduce 9800 Series ink up to 20% (see Additives section). 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 inks prior to printing.
Maintain ink temperature at 65°-90°F (18°-32°C) for optimum print 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 9800 Series ink air dries in 15-20 minutes and may be force dried in a conveyORIZED jet dryer at 130°F (55°C) for 20-30 seconds.

CLEAR / VARNISHES Mixing Clear / Metallic Mixing Clear: Use 9826 Mixing Clear to reduce the density of colors or as a clear base for specialty additives such as Metallics.

ADDITIVES All additives should be thoroughly mixed into the ink before each use. Prior to production, test any additive adjustment to the ink.

Thinner: Use RE185 Thinner to reduce the viscosity of these inks. Add up to 20% by weight.

Retarder: Use RE181 Retarder to prevent drying in the screen during hot climate conditions or for slower drying. Add up to 10% by weight. Over reduction with retarder can result in blocking.

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). Ink taken from the press should not be returned to the original container; store separately to avoid contaminating unused ink.

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 9800 Series Material Safety Data Sheet for further instructions and warnings.

ADHESION TESTING

1. Touch of ink surface – the ink will be smooth and tack free.
2. Thumb twist – the ink surface will not mar or smudge.
3. Scratch surface – the ink will resist scratching.
4. 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.

PRODUCT OFFERING

STANDARD PRINTING COLORS Standard Printing Colors have excellent opacity and printing characteristics.

SPECIAL ADDITIVES When inks are to be printed over a special effect color, the overprinting ink(s) must be evaluated for intercoat adhesion before proceeding with the production run. To maximize intercoat adhesion, specialty colors should be printed as late as possible in the print sequence. Pigments may settle in the container; prior to printing, thoroughly mix the ink. The following special effect pigments may be added to the 9800 inks. These pigments are available in 1-pound containers. Contact Nazdar for the item number(s) and availability of each special effect product.

Metallics: Silver (aluminum) - Add up to 8% by weight, Gold (bronze) - add up to 15% by weight. Mix only enough metallic ink to be used the same day. Chemical reactions in metallic inks may result in viscosity, color and printability changes over time.

Pearlescents / Interference / Multi-Chromatic: Pearlescent and Interference pigments - Add up to 20% by weight, Multi-Chromatic pigments - Add up to 10% by weight. See the Pearlescent, Interference, and Multi-Chromatic Technical Data Sheets for more information.

COLOR CARD MATERIALS The following is a list of screen printed samples available.

Conventional Color Card (CARD375): shows most of the Standard Printing Colors

Special Effects Color Card (CARDSPL): shows Metallic, Pearlescent, Interference, and Multi-Chromatic effects

'LF' ITEM NUMBERS Colors with a stock number containing 'LF' indicate a lead-free alternative that replaced a lead containing color. All colors listed in this document are lead-free.

PACKAGING All items listed below are inventory items available in gallon containers.

Item Number	Standard Printing Colors	Item Number	Standard Printing Colors
98LF10	Primrose Yellow	9826	Mixing Clear
98LF11	Lemon Yellow	98410	Yellow
98LF12	Medium Yellow	98411	Warm Red
98LF13	Emerald Green	98417	Rubine Red
9819	Fire Red	98418	Rhodamine Red
98LF20	Brilliant Orange	98422	Reflex Blue
9821	Peacock Blue	98440	Process Blue
9822	Ultra Blue	98441	Green
9824	Black	98433	Purple
9825	White		

PACKAGING Additives/Reducers are available in gallon and 5 gallon containers.
Cleaners are available in gallon, 5 gallon and 55 gallon containers.

Item Number	Additives/Reducers	Item Number	Clean Up
RE181	Retarder	IMS201	Premium Graphic Screen Wash
RE185	Thinner	IMS301	Premium Graphic Press Wash

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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