

7900 Series is a solvent-based screen ink formulated for transportation graphics, real estate signs, POP, and other outdoor signage applications.

Substrates

Treated polypropylene (PP)

Treated fluted/corrugated polypropylene (PP)

Notes & Cautions

The surface tension for polyethylene and polypropylene substrates should be at or above 45 dynes/cm.

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

230-305 tpi (90-120 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: 1,400-1,800 square feet (130-170 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

Dries by solvent evaporation in 20-40 minutes or may be force dried in a jet dryer at 130° - 150°F (54° - 66°C). Good air circulation is necessary to remove the vaporized solvents. Multiple layers of ink may require longer drying times than a single layer.

Adhesion Testing

- Touch of ink surface – the ink surface should be smooth.
- Thumb twist – the ink surface should not mar or smudge.
- Scratch surface – the ink surface should resist scratching.
- Cross hatch tape test – per the ASTM D-3359 method, 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, and rip off at a 180 degree angle. Ink should only come off in actual cut areas.

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): IMS301 Premium Graphic Press Wash.

Ink Modifications

Clears / Varnishes

Overprint Clear / Mixing Clear/Metallic Clear: use to reduce the density of colors or as a clear base for specialty additives such as Metallic additives. Use as an overprint clear to provide added surface protection to colors.

Additives

The market specific performance properties of this ink series / ink item should be acceptable for most applications without the need for additives. When required, any additives should be thoroughly mixed before each use. Prior to production, test any additive adjustment to the ink. Inks containing additives should not be mixed with other inks.

Example for additives: Ink at 100g with 8% of an additive is calculated as: 100g ink + 8g additive = 108g total

Reducer / Thinner

Use 59000 Thinning Varnish or 5560 Fast Thinner to reduce the viscosity of the 59000 Series. Add up to 15%. The 59000 Thinning Varnish may also be used to reduce ink viscosity for roller coating applications.

Retarder

Use 9050 Retarder to reduce the viscosity or to prevent drying in the screen during hot climate conditions or for slower drying of these inks. Add up to 15%. Over thinning with 9050 can result in blocking.

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.

Standard items useable for a period of at least **48 months** from the date of manufacture.

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.

Halftone Colors

Halftone Extender Base is used to reduce the density of any of the halftone colors.

Standard Halftone Colors are formulated with hues and densities common to the graphic industry.

Standard Printing Colors

Standard Printing Colors: have excellent opacity and flow characteristics. These colors are intended to work as supplied.

LF Colors

Colors with an item number containing "LF" are lead-free alternatives that replaced a lead containing color. All Nazdar manufactured inks are lead-free.

Pantone Base Colors

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Pantone Matching System Base Colors are used to simulate the Pantone® Formulation Guide when printed on a white substrate. These inks are press ready, can be used in matches to achieve Pantone color simulations, or let down with mixing clear. ColorStar® Color Management System software uses Pantone Matching System Base Colors to match Pantone colors. Blend formulations are also available at www.nazdar.com using ColorStar On-Line.

60 Series Colors: 61-69 colors have a high pigment concentration. These colors are formulated to have some white pigment or opaque pigment to increase opacity.

Toners

Single Pigment Toners produce clean and vibrant colors. Single Pigment Toners can be used as supplied, in color matches or let down with mixing clear.

Special Effect Pigments

When inks are to be printed with a special effect color, all ink layers 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 ink. Contact Nazdar for the item number(s) and availability of special effect products or they can be found at www.nazdar.com.

Metallic Additives: Chemical reactions in metallic inks may result in viscosity, color and printability changes over time; due to this, mix only enough metallic ink to be used the same day.

Pearlescent / Interference, add up to: 20%

Multi-Chromatic, add up to: 10%

Color Card Materials

The following is a list of available literature representing this ink series.

- Conventional Color Card (CARD375): shows the Standard Colors, Pantone Matching System Base Colors, and Halftone Colors.
- Special Effects Color Card (CARDSPL): shows various special effect pigments mixed with clear

Packaging / Availability

Contact your Nazdar distributor for product availability and offering.

Item Type	Item Number	Item (or Color) Description
Standard Colors	79LF10	Primrose Yellow
Standard Colors	79LF11	Lemon Yellow
Standard Colors	79LF12	Medium Yellow
Standard Colors	79LF13	Emerald Green
Standard Colors	79LF18	Scarlet Red
Standard Colors	7919	Fire Red
Standard Colors	79LF20	Brilliant Orange
Standard Colors	7921	Peacock Blue
Standard Colors	7922	Ultra Blue
Standard Colors	7927	Mixing/Overprint Clear
Standard Colors	7945	Forest Green
Standard Colors	7955	Brilliant Blue
Standard Colors	7952	Opaque Black
Standard Colors	7975	Super Opaque White
Pantone Base Colors	7958	Tinting White
Pantone Base Colors	7959	Tinting Black
Pantone Base Colors	7960	Orange
Pantone Base Colors	7961	Yellow
Pantone Base Colors	7962	Warm Red
Pantone Base Colors	7963	Rubine Red
Pantone Base Colors	7964	Rhodamine Red
Pantone Base Colors	7965	Purple

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Pantone Base Colors	7966	Violet
Pantone Base Colors	7967	Reflex Blue
Pantone Base Colors	7968	Process Blue
Pantone Base Colors	7969	Green
Blending Toners / Toners	7983	Magenta Toner
Blending Toners / Toners	7984	Maroon Toner
Blending Toners / Toners	7985	Green Toner
Blending Toners / Toners	7988	Violet Toner
Additives	5560	Fast Thinner
Additives	9050	Retarder
Cleaners	IMS201	Premium Graphic Screen Wash
Cleaners	IMS203	Economy Graphic Screen Wash
Cleaners	IMS301	Premium Graphic Press Wash

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®.

**Nazdar Ink Technologies
Offices**

Nazdar Ink Technologies - World Headquarters
 8501 Hedge Lane Terrace
 Shawnee, KS 66227-3290 USA
 Toll Free US: 866-340-3579
 Tel: +1 913-422-2255
 Fax: +1 913-422-2296
 Customer Service E-mail: NazdarOrders@nazdar.com
 Technical Support E-mail: TechSupport@Nazdar.com

Nazdar Limited – EMEA
 Battersea Road, Heaton Mersey
 Stockport, England SK4 3EA
 Tel: + 44 (0)-161-442-2111
 Fax: + 44 (0)-161-442-2001
 EMEA Customer Service E-mail: infoUK@nazdar.com
 EMEA Technical Service E-mail: technicalservicesUK@nazdar.com

Nazdar – Asia Pacific
 11 Changi North Street 1
 #03-03/04
 Singapore 498823
 Tel: +65 6385 4611
 E-mail: aspac@nazdar.com