

Color Vue 8800 Series Screen Inks have been formulated specifically for automotive, membrane overlay and appliance decorating applications, where strong transparent colors with lens-like clarity and high opacity colors are required. The 8800 Series is compatible with most acrylic transfer adhesives.

Substrates

Polycarbonate (PC)

Substrate Material(s) listed below may be Limited in Adhesion (*testing highly recommended for each print run*)
Top coated / Print treated polyester (PET)

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

195-330 tpi (77-130 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: 1,200-1,800 square feet (111-167 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.

Processing

Cutting/Embossing/Adhesive Lamination: Make sure the ink is thoroughly dry prior to any post print processing.

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**

Mixing Clear/Metallic Clear: use to reduce the density of colors or as a clear base for specialty additives such as Metallic additives.
Satin Overprint Clear: use for first surface printing to provide a low gloss finish.

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 the following item(s) to reduce the viscosity of these inks. Over reduction can reduce print definition, film thickness and adversely affect cure.

RE181 Thinner/ Retarder: add up to 20%

Retarder

Use RE183 Retarder to slow the drying process and increase ink stability on the press. Add up to 15%.

RE181 Thinner/Retarder and RE183 Retarder may be added to the same ink

Gloss / Flattening Powders / Improved Slip

Use 8848 Flattening Paste to produce a satin finish. Add up to 20%.

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.

Standard Printing Colors

Standard Printing Colors have excellent opacity over a variety of substrates.

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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

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.

360 Series Colors: These colors are formulated to have no white or opaque pigments. This allows the colors to be more vibrant and allows for a better match of intense and darker colors.

Toners

Transparent Colors produce very good transparency and depth of color. Transparent 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 Silver (aluminum), add up to: 8%

Metallic Gold (bronze), add up to: 15%

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	88LF10	Primrose Yellow
Standard Colors	88LF11	Lemon Yellow
Standard Colors	88LF12	Medium Yellow
Standard Colors	88LF13	Emerald Green
Standard Colors	8819	Fire Red
Standard Colors	88LF20	Brilliant Orange
Standard Colors	8821	Peacock Blue
Standard Colors	8822	Ultra Blue
Standard Colors	8824	Tinting Black
Standard Colors	8825	White
Standard Colors	8826	Mixing Clear
Standard Colors	8827S	Satin Overprint Clear
Standard Colors	8852	Super Opaque Black
Standard Colors	8875	Super Opaque White
Standard Colors	8879	High Intensity Black

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Transparent Colors	88PB10	Trans Primrose Yellow
Transparent Colors	88PB12	Trans Medium Yellow
Transparent Colors	88PB13	Trans Green
Transparent Colors	88PB18	Trans Red (BS)
Transparent Colors	88PB22	Trans Blue
Transparent Colors	88PB24	Dead Front Black
Transparent Colors	88PB60	Ruby Red
Pantone Base Colors	88358	Tinting White
Pantone Base Colors	88359	Tinting Black
Pantone Base Colors	88360	Orange
Pantone Base Colors	88361	Yellow
Pantone Base Colors	88362	Warm Red
Pantone Base Colors	88363	Rubine Red
Pantone Base Colors	88364	Rhodamine Red
Pantone Base Colors	88365	Purple
Pantone Base Colors	88366	Violet
Pantone Base Colors	88367	Reflex Blue
Pantone Base Colors	88368	Process Blue
Pantone Base Colors	88369	Green
Blending Toners / Toners	8881	Orange Toner
Blending Toners / Toners	8882	Carmine Toner
Blending Toners / Toners	8883	Magenta Toner
Blending Toners / Toners	8884	Maroon Toner
Blending Toners / Toners	8886	Blue Toner (GS)
Blending Toners / Toners	8888	Violet Toner
Additives	8848	Flatting Paste
Additives	RE181	Thinner/Retarder
Additives	RE183	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®.

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