

PX Series is formulated as a pigmented adhesive for flocking applications on a wide variety of natural textile materials and some synthetic material. The excellent opacity and “short” body allow ease in achieving a thick adhesive deposit for flocking. PX Series is ideal for use without a high temperature dryer.

Substrates

Cotton
Cotton blends
Cotton/Polyester Blends
Sunbrella®

Substrate Material(s) listed below may be Limited in Adhesion (*testing highly recommended for each print run*)
Synthetics

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

86-110 tpi (34-43 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: 400 - 600 square feet (34 - 56 square meters)

Screen Printing

Standard items are formulated to be press ready. Thoroughly mix the ink prior to printing. Improper mixing can lead to inconsistent color and ink performance.

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

PX Series dries by oxidation, requiring 24-48 hours for total cure/dry. Tack free dry time is about 4-6 hours. To obtain a faster tack free surface, heat set at 180°F (83°C) for 30 minutes. Multiple layers of ink may require longer drying times than a single layer.

Cleanup

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

Screen Wash (Prior to Reclaim): IMS401C Premium Textile Screen Wash

Ink Modifications

Additives

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.

PX30 Thinner: add up to 10%.

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.

Ink taken from the press should not be returned to the original container; store separately to avoid contaminating unused ink. Store closed containers at temperatures between 65°-78°F (18°-25°C). Storing products outside of these recommendations may shorten their shelf life.

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 and flow characteristics. These colors are intended to work as supplied.

Packaging / Availability

Contact your Nazdar distributor for product availability and offering.

Item Type	Item Number	Item (or Color) Description
Standard Colors	PX10	Yellow
Standard Colors	PX13	Orange
Standard Colors	PX15	Dark Green
Standard Colors	PX16	Brown
Standard Colors	PX18	Scarlet Red
Standard Colors	PX19	Fire Red
Standard Colors	PX21	Royal Blue
Standard Colors	PX23	Navy Blue
Standard Colors	PX24	Black
Standard Colors	PX25	White
Standard Colors	PX28	Purple
Standard Colors	PX32	Gold

Nazdar PX Perma-Flex Flock Adhesive Screen Ink

Standard Colors	PX33	Kelly Green
Standard Colors	PX75	Super Opaque White
Additives	PX30	Thinner
Cleaners	IMS401C	Premium Textile Screen 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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