

Nazdar Waterbase Peelable Mask Screen Inks

60028546WB Waterbase Peelable Mask (clear) and 60035897WB Waterbase Peelable Mask (frosted) are water-soluble, screen-printable inks for use as a temporary protective coating on polycarbonate and coated metal substrates. The dried coating can be easily peeled away from the substrate.

Substrates

Polycarbonate (PC)
Coated metals

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

60-110 tpi (25-45 tpcm) monofilament polyester mesh for most applications.

Heavier ink deposit may require additional cure output.

Stencil

Use direct emulsions and capillary films which are solvent and water resistant.

Squeegee

60-70 durometer polyurethane squeegee.

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.

Application of too little mask will result in a dry film with less integrity, making eventual removal more difficult. Apply generously to produce a strong, robust film which will peel easily.

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.

60028546WB and 60035897WB can be inter-mixed.

60028546WB (clear) provides greater adhesion to the substrate and higher clarity; 60035897WB (frosted) provides easier release from the substrate and higher opacity. does not recommend inter-mixing of 60028546WB and 60035897WB with any other inks.

Drying / Curing Parameters

Good air circulation is necessary to dry the inks.

Air Drying: 60028546WB and 60035897WB air dries in approximately 30 minutes by evaporation depending on the ambient conditions.

Forced Drying: For best results, 60028546WB and 60035897WB should be force dried at 150°-180°F (66°-82°C).

Cleanup

Use 2537 Screen Wash or 2738 Heavy Duty Screen Wash.

Ink Modifications

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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

Retarder

Use water or RE180 Thinner to reduce the viscosity of these inks. Add up to 5%.

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 supplied in 1-gallon (4/5 kilo) containers or smaller. Useable for a period of at least **24 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	60028546WB	Waterbase Peelable Mask (<i>clear</i>)
Standard Colors	60035897WB	Waterbase Peelable Mask (<i>frosted</i>)
Additives	RE180	Thinner
Cleaners	2537	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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