

Nazdar NFX54 UV Soft Tac Clear Screen Ink

(Formerly 676154PS UV Mouse Pad Non-Slip Clear)

NFX54 UV Soft Tac Clear is intended to provide a rubbery, semi-tacky surface that resists slipping. The NFX54 UV Soft Tac Clear may be printed over the following Nazdar ink systems: 1600 Series, 1900 Series, 3400 Series, 3500 Series, 3600 Series and 3900 Series. The NFX54 UV Soft Tac Clear is NOT for flooring applications.

Substrates

- Polycarbonate
- Top-Coated or Primed Polyester
- Vinyl

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.

User Information

Mesh

60-305 tpi (25-120 tpcm) monofilament polyester mesh for most applications.

Coarser mesh counts and/or twill weave result in heavier ink deposit and may require additional cure output.

Stencil

Use direct emulsions and capillary films which are solvent resistant and UV compatible.

Squeegee

60-70 durometer polyurethane squeegee.

Coverage

Estimated 1,000 - 1,800 square feet (93 - 167 square meters) per gallon depending upon ink deposit. Reference www.nazdar.com for examples of coverage calculations.

Printing

NFX54 UV Soft Tac Clear is formulated to be press ready. Thoroughly mix the ink prior to printing. Improper mixing can lead to inconsistent ink performance.

The NFX54 UV Soft Tac Clear cures with a tacky surface, therefore, applying a protective covering or slip sheet over the cured ink is necessary for the printed piece to stack.

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.

The ink can be affected by stray UV light. Be aware of skylights, windows and overhead lights curing the ink in the screen; light filters are recommended. Leaving a container uncovered may result in the ink's surface forming a "skin", caused by reaction with ambient lighting. Keep containers covered.

Nazdar does not recommend inter-mixing of NFX54 UV Soft Tac Clear with other inks.

Cure Parameters

NFX54 UV Soft Tac Clear cures when exposed to a single medium pressure mercury vapor lamp emitting output millijoules (mJ) and milliwatts (mW) of:

150-200 mJ/cm² @ 600+ mW/cm²

These guidelines are intended only as a starting point for determining cure parameters, which must be determined under actual production conditions. "Undercuring" the ink may result in poor adhesion, lower block resistance, reduced durability, and higher residual odor. "Overcuring" the ink may reduce the flexibility of the printed part.

To increase mJ levels, slow down the belt speed or scan speed. To increase mW levels, increase the wattage setting of the UV reactor. To optimize mJ and mW output, maintain the bulb and reflector, and ensure proper focus to the substrate.

These guidelines are representative of measurements taken using an EIT[®] UVICURE[®] Plus radiometer measuring the UVA bandwidth (320-390 nm). To obtain accurate mW readings with

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the UVICURE® Plus, reduce the belt speed to less than 40 ft/min.

Processing

Finishing: Finishing requirements are dependent on the combination of the underprint ink and the NFX54 UV Soft Feel Clear. All finishing processes should be qualified prior to full scale print production.

Cleanup

Screen Wash (Prior to Reclaim): Use IMS201 Premium Graphic Screen Wash, IMS203 Economy Graphic Screen Wash, or IMS206 Graphic Auto Screen Wash.

Press Wash (On Press): Use IMS301 Premium Graphic Press Wash.

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

NFX54 UV Soft Tac Clear supplied in 1 gallon containers or smaller are useable for a period of at least 24 months from the date of manufacture. To obtain the official shelf life letter, Contact Nazdar Technical Service at InkAnswers@nazdar.com or see contact listing at the end of this document.

General Information

Ink Handling

Wear gloves and barrier cream to prevent direct skin contact. Safety glasses are suggested in areas where ink may be splashed. If ink 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.

This ink series is a one-part, 100% solids UV-curable screen printing ink and does not contain N-vinyl-2-pyrrolidone (trade name V-Pyrol®).

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).

Adhesion Testing

NFX54 UV Soft Tac Clear is intended to produce a “grabby”, tacky surface. The definition of proper cure and adhesion will vary, depending on the end use. Test appropriately.

Manufacturer’s Product Offering

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.

NFX54 UV Soft Tac Clear is available in 1-gallon containers.

Cleaners are available in gallon, 5 gallon and 55 gallon containers.

Cleaners / Clean Up

Item Number	Item Description
IMS201	Premium Graphic Screen Wash
IMS203	Economy Graphic Screen Wash
IMS206	Graphic Auto Screen Wash
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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