

7200 Series offers clean, bright colors for printing POP displays, signs and book covers. 7200 Series dries quickly once printed.

v 8 EN

Ref: v 7 EN

Substrates

- Coated paper
- Card stock
- Polyolefins
- Some synthetic paper stocks
- Foils
- Wood
- Tyvek®
- Some 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.

User Information

Mesh

230-305 tpi (90-120 tpcm) monofilament polyester mesh for most applications.

Stencil

Use direct emulsions and capillary films which are solvent resistant.

70-80 durometer polyurethane squeegee.

Coverage

Estimated 1,800-2,500 square feet (90-120 square meters) per gallon depending upon ink deposit. Reference www.nazdar.com for examples of coverage calculations.

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 of 7200 Series with other inks besides the 7200 Series.

Drying Parameters

7200 Series ink air dries in 10-15 minutes at normal room temperature. Force drying is achieved in 40-60 seconds at 90°-150°F (32°-66°C). It is important to have good air flow to help remove solvents and accelerate drying. If the temperature is too high without good air flow, blocking may occur when the sheets are stacked warm. Multiple layers of ink may require longer drying times than a single layer.

Clears / Varnishes

Overprint Clear / Mixing Clear / Metallic Mixing Clear: Use 7227 Mixing/Overprint Clear as a mixing clear 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.

Common Performance 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:

$$100\text{g ink} + 8\text{g additive} = 108\text{g total}$$

Reducer: Use RE185 Thinner to reduce the viscosity of these inks. Add up to 5% by weight.

Retarder: Use a blend of 5% of RE185 Thinner and 5% of RE181 Retarder to prevent drying in the screen during hot climate conditions or for slower drying. Over reduction with retarder can result in blocking.

Flattening Powders / Improved Slip: Use 7248 Flattening Paste to reduce gloss and improve slip. Add up to 20% by weight.

Nazdar 7200 Series Lacquer Screen Ink

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

Store closed containers at temperatures between 65°-78°F (18°-25°C). Ink taken from the press should not be returned to the original container; store separately to avoid contaminating unused ink.

General Information

Ink Handling

All personnel mixing and handling these products must wear gloves and eye protection. Clean up spills immediately. If ink does come in contact with skin, wipe ink off with a clean, dry, absorbent cloth (do not use solvent or thinner). 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).

Adhesion Testing

1. Touch of ink surface – the ink surface should be smooth.
2. Thumb twist – the ink surface should not mar or smudge.
3. Scratch surface – the ink surface should resist scratching.
4. 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.

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.

Standard Printing Colors

Standard Printing Colors have excellent opacity and flow characteristics.

Pantone Matching System[®] Base Colors

Pantone Matching System Base Colors are used to simulate the Pantone[®] Formulation Guide. 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: 7260-7269 colors have a high pigment concentration. These colors are formulated to have some white pigment or opaque pigment to increase opacity.

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. Pigments may settle in the container; prior to printing, thoroughly mix the ink.

The following special effect pigments may be added to 7200 Series. Contact Nazdar for the item number(s) and availability of special effect products. Technical Data Sheets for each of the following special effect pigments 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% by weight.

Multi-Chromatic: Add up to 10% by weight.

Color Card Materials

The following is a list of available screen printed samples of the 7200 Series.

Conventional Color Card (CARD375): shows the Standard Printing Colors, Pantone Matching System Base Colors, and Halftone Colors.

Nazdar 7200 Series Lacquer Screen Ink



Special Effects Color Card (CARDSPL): shows various special effect pigments mixed with clear.

Packaging / Availability

Contact your Nazdar distributor for product availability and offering.

Standard Ink Items

Standard ink items listed below are inventoried in 1 kilogram and gallon containers.

Printing Colors

Item Number	Color
7211	Lemon Yellow
7212	Medium Yellow
7219	Fire Red
7221	Peacock Blue
7227	Mixing/Overprint Clear
7252	Super Opaque Black
7275	Super Opaque White

Pantone Matching System® Base Colors

Item Number	Color
7258	Tinting White
7259	Tinting Black
7260	Orange
7261	Yellow
7262	Warm Red
7263	Rubine Red
7264	Rhodamine Red
7265	Purple
7266	Violet
7267	Reflex Blue
7268	Process Blue
7269	Green

Non-Standard Ink Items

Non-Standard ink items listed below are special order, non-inventoried colors which may require additional lead time. These items are available in gallon containers.

Printing Colors

Item Number	Color
7210	Primrose Yellow
7220	Brilliant Orange

Additives / Reducers

Item Number	Description
7248	Flattening Paste
RE181	Retarder
RE185	Thinner

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Solvent-Based Screen Ink

Cleaners / Clean Up

Item Number	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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Solvent-Based Screen Ink