

AquaSafe 2700 Series All Purpose Screen Ink is a water-based ink that produces a glossy ink film, offers good weather resistance and is flexible enough for vacuum forming.

**SUBSTRATES** Coated paper, cardboard, pressure-sensitive vinyl, top-coated polyester, static-cling, polycarbonate, some coated metals and styrene

### USER INFORMATION

*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. See full disclaimer at the end of the document.*

**MESH** 180-305 tpi (70-120 tpcm) monofilament polyester mesh for most applications

**STENCIL** Water resistant direct emulsions and capillary films

**SQUEEGEE** 70-90 durometer polyurethane squeegee

**COVERAGE** 2,000-3,000 square feet (185 - 278 square meters) per gallon depending upon ink deposit

**PRINTING** 2700 Series ink may be thinned to achieve proper ink flow (see Additives section). Thoroughly mix the ink prior to printing.  
 Maintain ink temperature at 65°-90°F (18°-32°C) for optimum print performance. Lower temperatures increase the ink viscosity, impairing flow. Elevated temperatures lower the ink viscosity, reducing print definition, film thickness and opacity.  
 Pretest to determine optimum printing performance for a particular set of ink, substrate, screen, and press variables/conditions.

**DRYING** 2700 Series ink dries by evaporation in 20-30 minutes depending on temperature and humidity. Jet dry at 150°- 170°F (66°- 77°C) for approximately 30-45 seconds using maximum air flow through the oven. Adequate cooling may be necessary to avoid blocking problems when stacked.

**CLEAR / VARNISHES** Overprint Clear: Use 2727 Overprint Clear to reduce the density of colors or as an overprint clear. If foaming or flow issues are experienced during printing, add additional thinner until required flow-out is achieved.

## ADDITIVES

All additives should be thoroughly mixed into the ink before each use. Prior to production, test any additive adjustment to the ink.

Thinner: Use 2732 Thinner to reduce the viscosity of these inks. Add up to 10% by weight. Adding more than 10% thinner will raise the VOC level above 3.5 lbs per gallon. If the ink dries too slowly, use water instead of 2732 Thinner to reduce the viscosity. Add up to 15% by weight.

Retarder: Use RE192 Retarder to slow drying times. Add up to 10% by weight.

Adhesion Promoter: To gain additional adhesion performance to coated metal and flat polyolefin stock, use AQ58 Aquacat. Add up to 10% by weight. Ink mixed with AQ58 Aquacat has a 6-12 hour pot life.

Gloss / Flattening Powders / Improved Slip: Use 2748 Flattening Paste to reduce gloss, improve slip, and prevent blocking on highly plasticized substrates and card stocks. Add up to 20% by weight.

## CLEAN UP

Screen Wash (Prior to Reclaim): Use 2537 Screen Wash or 2738 Heavy Duty Screen Wash  
Press Wash (On Press): Use IMS503 Press Wash

## STORAGE

Store tightly covered at a temperature between 65°-90°F (18°-32°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

Wear gloves 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 cloth (do not use solvent). Wash the affected area with soap and water. Consult the 2700 Material Safety Data Sheet for further instructions and warnings.

### ADHESION TESTING

1. Touch of ink surface – the ink surface will be dry.
2. Thumb twist – the ink surface will not mar or smudge.
3. Scratch surface – the ink surface will resist scratching. Coated paper scratches easily, so use magnification to determine if scratches are ink only or ink and top layer of substrate.
4. Cross hatch tape test – 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, wait for 1 minute and rip off at a 180 degree angle. Ink should only come off in actual cut areas.

## PRODUCT OFFERING

### STANDARD PRINTING COLORS

Standard Printing Colors have excellent opacity.

### TONERS

Toners are highly concentrated, clean transparent colors. These inks are press ready and also can be used in color matches.

**PACKAGING / AVAILABILITY**

All items listed below are inventoried items and available in gallon containers.

Stock Number	Standard Printing Colors	Stock Number	Toners
2710	Primrose Yellow	2782	Carmin Toner
2711	Lemon Yellow	2783	Magenta Toner
2712	Medium Yellow	2784	Maroon Toner
2713	Emerald Green	2785	Green Toner
2718	Scarlet Red	2786	Blue Toner (GS)
2719	Fire Red	2787	Blue Toner (RS)
2720	Brilliant Orange	2788	Violet Toner
2721	Peacock Blue		
2722	Ultra Blue		
2724	Black		
2727	Overprint Clear		
2775	Super Opaque White		

**PACKAGING / AVAILABILITY**

All items listed below are inventoried items.  
Additives/Reducers are available in quart and gallon containers.  
Cleaners are available in gallon containers.

Stock Number	Additives/Reducers	Stock Number	Cleaners
2748	Flattening Paste	2537	Screen Wash
2732	Thinner (gallon only)	2738	Heavy Duty Screen Wash
RE192	Retarder (gallon only)	IMS503	Press Wash
AQ58	Aquacat (quart only)		

*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®.*

Based on information from our raw material suppliers, these products are formulated to contain less than 0.06% lead. If exact heavy metal content is required, independent lab analysis is recommended.

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