

**NSC UV Crystal Clear Transparent Screen Inks have been formulated for membrane overlays. These inks exhibit excellent clarity with very little haze, making them ideal for use as transparent window colors. NSC UV Crystal Clear Transparent inks may be printed top or sub surface.**

## Substrates

Polycarbonate (PC)

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

Top coated / Print treated polyester (PET)

*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

255 tpi (100 tpcm) monofilament polyester mesh for most applications.

Coarser mesh counts and/or twill weave result in heavier ink deposit requiring additional cure output. Finer mesh counts reduce the ink deposit and impair the flowing out of the ink.

## Stencil

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

## Squeegee

70-90 durometer polyurethane squeegee.

## Coverage

Depending upon ink deposit, the estimated coverage per gallon: 2,000 – 3,000 square feet (185 - 278 square meters)

Reference [www.nazdar.com/en-us/ColorStar](http://www.nazdar.com/en-us/ColorStar) for examples of coverage calculations.

## Screen Printing

NSC Crystal Clear inks are formulated as concentrates and are intended primarily as color matching toners. Color density may be reduced and cure speed is increased with the addition of NSC29 Mixing Clear and/or RE310 UV Reducer.

To achieve the best results some experimentation may be necessary. Variables to consider include: mesh count, flood speed, squeegee hardness, squeegee type, squeegee angle, print speed, peel, off-contact, and viscosity. The addition of NSC29 Mixing Clear or RE310 UV Reducer and/or CARE65 Flow Agent may be necessary for acceptable printability.

Mixing the inks at least 24 hours before printing may also optimize print appearance. Prior to printing, gently mix with a spatula only, to minimize air bubbles in the ink.

Exposure to heat or infrared immediately after printing or allowing time between printing and curing allows the ink film to flow-out better resulting in a smoother appearance.

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.

## Cure Parameters

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 and adhesion of subsequent ink layers.

Mercury Vapor UV Curing: this series has been optimized for 395nm LED curing; however, most colors cure when exposed to a single medium pressure mercury vapor lamp emitting output millijoules (mJ) and milliwatts (mW) of:  
300+ mJ/cm<sup>2</sup> @ 800+ mW/cm<sup>2</sup>

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

### Inter-Printable

Laminating Adhesives: NSC UV Crystal Clear inks are not recommended for use with laminating adhesives.

UV Inks: NSC Crystal Clear inks may be over-printed and under-printed with the 3400 Series UV Screen ink. Inter-coat or ink-to-ink compatibility with the 3400 Series improves with the addition of NSC29 Mixing Clear to the NSC UV Crystal Clear Transparent colors. Reference the 3400 Series Technical Data Sheet at [www.nazdar.com](http://www.nazdar.com) for processing information.

Solvent-based Inks: NSC Crystal Clear inks may be over-printed onto thoroughly dried 8800 Series Color-Vue Membrane solvent-based ink. NSC Crystal Clear inks cannot be overprinted with solvent-based ink. Reference the 8800 Series Technical Data Sheet at <http://www.nazdar.com> for processing information.

### Adhesion Testing

When recommended UV energy output levels are achieved, checking the degree of cure on a **cooled down** print is imperative:

- Touch of ink surface – the ink surface should be smooth.
- Thumb twist – the ink surface should not mar or smudge.
- Scratch surface – the ink surface should resist scratching.
- 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.

Full adhesion characteristics at proper cure levels are demonstrated within: 4 hours

### Cleanup

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

Screen Wash (Prior to Reclaim): Use IMS201 Premium Graphic Screen Wash or IMS203 Economy Graphic Screen Wash

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

## Ink Modifications

### Clears / Varnishes

Mixing Clear: use to reduce the density of colors.

### Additives

The market specific performance properties of this ink series / ink item should be acceptable for most applications without the need for 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.

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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.

RE310 UV Reducer: add up to 20%

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## Flow Control / Leveling Agent

Flow Agent: Use CARE65 Flow Agent to improve flow. Add up to 1%. CARE 65 will make the ink film cloudy.

## 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).

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®).

### 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.

### Color Card Materials

The following is a list of available literature representing this ink series.

- NSC Crystal Clear Transparent Ink (CARDCC2): shows the NSC30 to NSC39 colors printed subsurface on polycarbonate.

## Packaging / Availability

Contact your Nazdar distributor for product availability and offering.

Item Type	Item Number	Item (or Color) Description
Standard Colors	NSC29	UV Crystal Mixing Clear
Standard Colors	NSC30	UV Crystal Clear Yellow (GS)
Standard Colors	NSC31	UV Crystal Clear Yellow (RS)
Standard Colors	NSC32N	UV Crystal Clear Red (BS)
Standard Colors	NSC33	UV Crystal Clear Red (YS)
Standard Colors	NSC34	UV Crystal Clear Magenta
Standard Colors	NSC35	UV Crystal Clear Violet
Standard Colors	NSC36	UV Crystal Clear Blue (GS)
Standard Colors	NSC37	UV Crystal Clear Blue (RS)
Standard Colors	NSC38	UV Crystal Clear Green
Standard Colors	NSC39	UV Crystal Clear Black
Additives	CARE65	Flow Agent
Additives	RE310	UV Reducer
Cleaners	IMS201	Premium Graphic Screen Wash

# Nazdar NSC Crystal Clear Transparent UV Screen Inks

Cleaners	IMS203	Economy Graphic Screen Wash
Cleaners	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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