

60005380GM UV Soft Feel Clear is a matte overprint clear ink for providing a somewhat soft feel, touchable surface that resists scuffing. 60005380GM UV Soft Feel Clear can also be used to print in selected areas to enhance the feel of a graphic image.

**SUBSTRATES** Rigid Vinyl, Styrene, Polycarbonate, and some Coated Papers

**INTER PRINTING** 60005380GM UV Soft Feel Clear can be inter printed with the following Nazdar<sup>®</sup> inks: PowerPrint<sup>®</sup> 1600 Series UV Screen Ink, PowerPrint<sup>®</sup> Banner 1900 Series UV Screen Ink, and 3200 Series UV Point-of-Sale (POS) Screen Ink.

Inter printing recommendations are based on the proper Nazdar<sup>®</sup> ink with a given substrate. See separate Nazdar<sup>®</sup> Technical Data Sheets for each ink and substrate suitability.

## 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** 110-355 tpi (43-140 tpcm) monofilament polyester mesh for most applications

**STENCIL** Solvent resistant, UV ink compatible direct emulsions and capillary films

**SQUEEGEE** 70-90 durometer polyurethane squeegee

**PRINTING** 60005380GM UV Soft Feel Clear is formulated to be press ready. Thoroughly mix the ink prior to printing.

Maintain ink temperature at 65°-90°F (18°-32°C) for optimum print and cure performance. Lower temperatures increase the ink viscosity, impairing both flow and cure. Elevated temperatures lower the ink viscosity, reducing print definition, and film thickness.

Pretest to determine optimum printing performance 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 and in uncovered containers. Light filters are recommended.

**CURE PARAMETERS** 60005380GM Soft Feel Clear cures when exposed to a medium pressure mercury vapor lamp with millijoules (mJ) and milliwatts (mW) of:

180-220 mJ/cm<sup>2</sup> @ 600+ mW/cm<sup>2</sup>

The values mentioned above are representative of measurements taken using an EIT UVICURE Plus radiometer measuring the UVA bandwidth (320-390 nm). These guidelines are intended only as a starting point for determining cure parameters, which must be determined under actual production conditions.

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 condition and focus to the substrate.

### ADDITIVES

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

Reducer: Use RE302 to reduce the viscosity. Add up to 10% by weight. The addition of RE302 may increase gloss.

### CLEAN UP

Screen Wash (Prior to Reclaim): Use IMS203 Economy Graphic Screen Wash or IMS207C Graphic Recirculating Wash

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

### STORAGE

Store tightly covered at temperatures 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

Direct skin contact to UV inks is the primary route of exposure and irritation. Therefore, it is recommended that all personnel handling inks to 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 Material Safety Data Sheet for further instructions and warnings.

60005380GM UV Soft Feel Clear is a one-part, 100% solids UV-curable screen printing ink and does not contain N-vinyl-2-pyrrolidone (trade name V-Pyrol®).

### ADHESION TESTING

Even when recommended UV energy output levels are achieved, it is imperative to check adhesion on a **cooled down** print:

1. Touch of ink surface – the ink surface will be not tacky.
2. Thumb twist – the ink surface will not mar or smudge.
3. 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.

### PACKAGING

60005380GM Soft Feel Clear is available in one gallon containers.

### PACKAGING

Additives/Reducers are available in quart and/or gallon containers. Cleaners are available in gallon, 5 gallon, and 55 gallon containers.

Stock Number	Additives/Reducers	Stock Number	Cleaners
RE302	UV Reducer	IMS203	Economy Graphic Screen Wash
		IMS207C	Graphic Recirculating Wash
		IMS301	Premium Graphic Press Wash



# 60005380GM UV SOFT FEEL CLEAR SCREEN INK

## TECHNICAL DATA SHEET

*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.

Nazdar Worldwide Headquarters  
8501 Hedge Lane Terrace, Shawnee, KS 66227-3290 USA  
Toll Free: 866.340.3579 or Tel: 913.422.1888 Fax: 913.422.2296  
e-mail: [custserv@nazdar.com](mailto:custserv@nazdar.com)

Nazdar Limited  
Barton Road, Heaton Mersey, Stockport, England SK4 3EG  
Tel: + (44) 0.161.442.2111 Fax: + (44) 0.161.442.2001  
e-mail: [technicalservicesuk@nazdar.com](mailto:technicalservicesuk@nazdar.com)

<http://www.nazdar.com>