

7900 Series Corogloss is a solvent-based screen ink formulated for transportation graphics, real estate signs, POP, and other outdoor signage applications.

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Substrates

- Treated polypropylene
- Treated polypropylene corrugated plastic
(Minimum surface treatment level of 45 dynes per cm)

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.

Squeegee

70-80 durometer polyurethane squeegee.

Coverage

Estimated 1,400-1,800 square feet (130-170 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 7900 Series with other inks besides the 7900 Series.

Drying Parameters

7900 Series ink dries by solvent evaporation in 20-40 minutes or may be force dried in a jet dryer at 130°F (54°C). Good air circulation is necessary to remove the vaporized solvents. Multiple layers of ink may require longer drying times than a single layer.

Clears / Varnishes

Mixing Clear / Metallic Mixing Clear / Overprint Clear: Use 7927 Mixing/Overprint Clear to reduce the density of colors or as a clear base for specialty additives such as Metallic additives. Use 7927 Mixing/Overprint Clear to provide added surface protection and extend outdoor durability of 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:

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

Thinner: Use 5560 Fast Thinner to reduce the viscosity of the ink. Add up to 15% by weight. Over thinning with 5560 can result in blocking.

Retarder: Use 9050 Retarder to reduce the viscosity or to prevent drying in the screen during hot climate conditions or for slower drying of these inks. Add up to 15% by weight. Over thinning with 9050 can result in blocking.

Cleanup

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

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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.

Printing Colors

Printing Colors have excellent opacity and printing characteristics.

Pantone Matching System® Base Colors

Pantone Matching System Base Colors are used to simulate the Pantone® Formulation Guide. These inks 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: 7960-7969 colors have a high pigment concentration. These colors are formulated to have opaque pigments to increase opacity.

Single Pigment Toners

Single Pigment Toners produce clean and vibrant colors. Single Pigment Toners can be used as supplied, in color matches or let down with mixing clear.

Halftone Colors

Halftone Extender Base is used to reduce the density of any of the halftone colors.

Halftone Colors are formulated with increased densities in order to have the flexibility to satisfy most process color density requirements.

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 7900 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.

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Color Card Materials

The following is a list of available screen printed samples of the 7900 Series.

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

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

Packaging / Availability

Contact your Nazdar distributor for product availability and offering.

'LF' Item Numbers

Colors with an item number containing 'LF' indicate a lead-free alternative that replaced a lead containing color. All colors listed in this document are lead-free.

Standard Ink Items

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

Printing Colors

Item Number	Color
7919	Fire Red
79LF20	Brilliant Orange
7922	Ultra Blue
7945	Forest Green
7927	Mixing/Overprint Clear
7952	Opaque Black
7975	Super Opaque White
79LF10	Primrose Yellow
79LF11	Lemon Yellow
79LF12	Medium Yellow
79LF13	Emerald Green
79LF18	Scarlet Red
7921	Peacock Blue

Pantone Matching System® Base Colors

Item Number	Color
7958	Tinting White
7959	Tinting Black

7960	Orange
7961	Yellow
7962	Warm Red
7963	Rubine Red
7964	Rhodamine Red
7965	Purple
7966	Violet
7967	Reflex Blue
7968	Process Blue
7969	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 1 kilogram and gallon containers.

Printing Colors

Item Number	Color
7955	Brilliant Blue

Single Pigment Toners

Item Number	Color
7983	Magenta Toner
7984	Maroon Toner
7985	Green Toner
7988	Violet Toner

Additives / Reducers

Item Number	Description
5560	Fast Thinner
9050	Retarder

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

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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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