

Powerprint® 1600 & 1610 Series UV Screen Ink

Code Ref: D495 / D472

technical information and application instructions

Substrates Styrene, ABS, rigid vinyls, pressure sensitive vinyls, polycarbonates, some acrylics, coated papers and coated cardstocks.

End Uses Retail applications. Use 1600 Series for indoor applications and 1610 Series for outdoor applications.

Product Information

The multi-purpose PowerPrint® 1600 & 1610 Series UV Retail Display Screen Ink has been formulated to meet the increased processing speeds of modern printing, while curing at lower levels of ultraviolet energy, thereby reducing energy costs and substrate heat exposure. The PowerPrint® 1600 & 1610 Series inks will cure to a low odour, tough, gloss finish that will resist blocking in two-sided print applications on rigid plastics. This ink is engineered to be cost effective for indoor and short-term outdoor retail displays. The PowerPrint® 1600 Series is inter-printable with both the 3200 Series and 1610 Series.

The 1610 Series UV uses the same resin, oligomer & photoinitiator formulation, the pigmentation is chosen for outdoor use and is suitable for 2 years outdoor exposure.

The PowerPrint® 1600 & 1610 Series is a one-part, 100% solids UV-curable screen printing ink which exhibits a gloss finish in the Standard Printing and Pantone Matching System® Base Colours, a semi-gloss finish in the Halftone Colours and a flat finish in the Matte Colours. This ink is intended to work well straight from the container on a wide range of printing equipment.

Do not use for Board & Paper applications that require 90° or 180° bends – the system is too hard and may crack.

Application Information

Mesh 140-150T Monofilament polyester mesh is recommended for most applications.

120-165T Monofilament polyester can be used for specialty applications.

Stencil Direct emulsions and thin capillary films that are solvent resistant, UV ink compatible, and yield a thin ink deposit will work best.

Squeegee Sharp 70-90 single durometer polyurethane blades as well as multi-durometer blades that produce an even, thin ink deposit will work best.

Coverage 60-100 Square metres/kilo depending upon ink deposit.

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manufacturing under licence to NAZDAR

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Reducer	D564-S082 UV Reducer is to be used to reduce the viscosity of these inks by adding no more than 5% by weight. It is recommended that these inks be thoroughly mixed and acclimatised to an 18°C - 30°C environment prior to reducing.
Mixing Clear	Mixing Clear is used to reduce the density of colours, or as a clear base for metallic powders (refer to Metallic Colours mixing Guidelines later in this TDS). In process colours use Process Medium to maintain structure.
Clean Up	Use Special UV Screen Wash D574-S016
Storage	<p>These inks are reactive to light and temperature extremes. Store in a clean area below 35°C sealed tightly in dark plastic containers out of direct sunlight. For maximum shelf life, store ink in ambient temperatures of 15°C to 30°C. Ink taken from the press should not be returned to the original container; store separately to avoid contaminating unused ink.</p> <p>Shelf life is 2 years from date of manufacture.</p>

General Guidelines

Ink Handling	Direct contact with the skin is the primary route of exposure and irritation with UV inks. Therefore, it is recommended that all personnel mixing and handling these products 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 absorbent cloth or rag (DO NOT USE SOLVENT OR REDUCER). Proceed to wash and rinse the affected area with soap and water. Consult the 1600 SDS for further instructions and warnings.
Printing	PowerPrint® 1600 & 1610 Series Inks are formulated to print from the container with excellent flow characteristics. If the need arises to reduce the viscosity, add up to 5% of D564-S082 UV Reducer. The use of a mixer is recommended to thoroughly mix inks prior to printing. Inks will maintain optimum print and cure performance when the ink temperature is 18°C - 30°C. Temperatures below 18°C will increase the ink viscosity, impairing both flow and cure. Elevated temperatures will lower the ink viscosity, reducing print definition, film thickness and opacity. When the ink is cold, it is best to mix the ink with a high-speed mixer until it returns to the proper temperature, 18°C - 30°C. Add reducer at this point if necessary.
Cure Parameters	<p>The PowerPrint® 1600 & 1610 Series Inks are formulated to cure when exposed to a medium pressure mercury vapour lamp set at 200 watts per inch with millijoules and milliwatts of:</p> <p style="text-align: center;">80-100mJ/cm² @ 600mW/cm² for most 1600 Series colours</p> <p style="text-align: center;">100-130mJ/cm² @ 600mW/cm² for dense black and white</p> <p>The values mentioned above are representative of measurements taken using an EIT UVICURE Plus radiometer measuring the UVA bandwidth (320-390nm). When measuring the peak irradiance using the UVICURE Plus, it is recommended that a belt speed less than 12 meters per minute be used in order to obtain accurate readings.</p>

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These high-performance Inks can be affected by stray UV light in and around a printing facility resulting in the appearance of an ink drying in the screen during the course of a long run. Be aware of skylights, windows and overhead lights possibly curing the ink in the screen. Precautions include the use of light filters that block out the damaging wavelengths.

If ink is left on screen while not printing (lunch breaks etc.) it is advisable to cover with black plastic sheeting.

NOTE: Porous substrates can allow ink to dive below the surface requiring a more thorough cure to overcome the added ink thickness

Adhesion Testing

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

1. **Touch of ink surface** – The 1600 & 1610 Series UV ink will be smooth and slick.
2. **Thumb twist** – The ink surface will not mar or smudge.
3. **Scratch surface** – The 1600 & 1610 Series ink will resist scratching when cool. Some cardstocks scratch 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 a cut area, rub down and rip off. Ink should only come off in actual cut areas.

Full adhesion characteristics will be demonstrated within 4 hours after cure.

Warning: Multilayer Printing

UV ink by its nature becomes brittle and inflexible when printed in multiple layers, and after multiple and repeated exposure to curing lamps. This will manifest itself most noticeably when printing onto flexible substrate, where more than 2 to 3 layers of ink are printed on top of each other.

This problem is also more frequently found on highly plasticized substrates where it is possible that some plasticizer has migrated to the surface, and this can give a weak ink bond. Unfortunately, this failure of adhesion may only become apparent several days after printing.

We have seen instances where thin gauge Vinyl and Styrene may become brittle after printing

We must therefore emphasise the importance of testing both a new print construction and new supplies of substrate.

Colour Availability

For the US market NAZDAR has a range of PMS matching colours available, as well as a selection of popular spot colours, 2 or more ranges of Process Colours and a range of single pigment toners.

The demands of the SA market are very different and at GL we hold stocks of the Process Colours and a small selection of popular corporate colours. All other colours are quickly blended in our factories to customer specific requirements.

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Weathering / Outdoor Durability

These colours are formulated for economy and certain colours will only provide 3-6 months outdoor durability.

For colours requiring 2 years outdoor durability – use 1610 Series UV.

Use 1610 overprint clear or 3227 overprint clear.

Fluorescent Colours These colours require special consideration due to their high pigment content. Best results are obtained when printing through a mesh, 120-140 that offers more open area. These inks will tend to settle, so high speed mixing is required prior to printing. The cured ink will have a satin finish. Fluorescent colours will fade on exposure to ultraviolet light – this includes UV reactor exposure as well as outdoor exposure. It is recommended to adjust the artwork so that these colours are the last printed on the image.

Metallic Colours Recommended mesh for printing metallics is 120T plain weave monofilament polyester. Mix only enough metallic ink to be used the same day – Chemical reactions in metallic inks may result in viscosity, colour, and printability changes over time. Check curing – Metallic colours are possibly more difficult to cure.

When inks are to be printed over a metallic colour, the overprinting ink(s) must be evaluated for intercoat adhesion over the metallic colour before proceeding with the production run. To maximize intercoat adhesion over metallic colours, we recommend that the metallic be printed as late as possible in the print sequence.

Recommended Ratios: Metallic Powders

Silver (Aluminium)	8% by weight	80gms powder to 1kg Clear
Gold (Bronze)	15% by weight	150gms powder to 1kg Clear

Finishing The excellent adhesion and hard surface finish of the 1600 Inks allow the stacking of printed sheets ink to ink without blocking problems on coated paper, coated board, Styrene, ABS, rigid vinyl and rigid plastic substrates.

Troubleshooting Guide

Ink Not Curing Check for proper mesh count.

Check squeegee pressure, angle and sharpness. Too much pressure or a dull edge blade will significantly affect ink film thickness and cure.

Check UV unit for effective millijoules and milliwatts (UV output).

Colour may be too opaque for UV light to penetrate. This can occur when a colour match requires the use of opaque white or black. Reduce the opaque colour with the addition of Mixing Clear until effective cure is obtained.

Poor Adhesion Excess ink deposit causing poor through-cure.

Surface contamination on substrate. Wipe a section of the substrate with isopropyl alcohol prior to print, and check adhesion.

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Try another type or batch of substrate.

Insufficient cure. Check UV unit for effective millijoules and milliwatts (UV output). Ensure the reflectors are clean & shiny bright silver.

Note

The PowerPrint® 1600 & 1610 Series have been formulated to render exceptional performance on a wide variety of substrates; however, due to variables in the chemical make-up of some substrates from batch to batch, a thorough test relative to all performance characteristics should be conducted prior to production printing. For further assistance please call GL SPECIALIZED INKS: +27 (0)31-700-6455.

caution

Please proof this ink, reduced to the consistency you wish to adopt, on a sample of the ACTUAL SUBSTRATE you will be printing BEFORE starting a production run.

Give the proof 24 hours to post cure then check for: Abrasion resistance, adhesion, print appearance and correctness of colour. The adequacy of this ink in these properties cannot be fully established on laboratory equipment on a small scale.

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.

GL stands behind the quality of this product. GL cannot, however, guarantee the finished results because GL 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 GL.

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Last date amended: 06 February 2023