

6100 Series Fast Dry Enamel Screen Ink is a solvent-based ink developed for use on flame-treated polyethylene containers, fiber drums and other hard-to-adhere-to surfaces.

6100 Series has a built-in catalyst that accelerates curing and offers excellent resistance to soaps and detergents.

**SUBSTRATES** Fiber drums and treated polyethylene containers

## 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** 200-305 threads per inch (80-120 threads per centimeter) monofilament polyester mesh for most applications

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

**SQUEEGEE** 70-80 durometer polyurethane squeegee

**COVERAGE** 900-2500 square feet (83-232 square meters) per gallon depending upon ink deposit

**PRINTING** The 6100 Series ink may be thinned with 5560 Fast Thinner. 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 inks prior to printing. Maintain ink temperatures at 65°-90°F (18°-32°C) for optimum print drying performance. Lower temperatures increase the ink viscosity, impairing both flow and drying. 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, press, and drying variables/conditions.

**DRYING** 6100 Series will air dry in 30-60 minutes. Force drying at 180°F (82°C) for about 5 minutes will make the ink film tack free. Good air circulation is necessary to remove the vaporized solvents. Multiple layers of ink may require longer drying times than a single layer. Drying times are dependent on ink deposit and air flow.

**CLEAR / VARNISHES** Mixing Clear / Metallic Mixing Clear: Use 6126 Mixing Clear to reduce the density of colors or as a clear base for specialty additives such as Metallics.  
Overprint Clear: Use 6127 Overprint Clear to provide added surface protection. Overprint only after the printed colors are thoroughly dried.

**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 5560 Fast Thinner to reduce the viscosity of the ink and maximize flow characteristics. Add up to 15% by weight.  
Retarder: Use 9050 Retarder to optimize on screen stability in hot environmental conditions. Add up to 5% by weight.

### CLEAN UP

Screen Wash (Prior to Reclaim): Use 2555 Screen Wash or IMS202 Universal Graphic Screen 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

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 6100 Series Material Safety Data Sheet for further instructions and warnings.

### ADHESION TESTING

1. Touch of ink surface – the ink will be smooth and slick.
2. Thumb twist – the ink surface will not mar or smudge.
3. Scratch surface – the ink will resist scratching.
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

The Standard Printing Colors have excellent opacity.

### PANTONE MATCHING SYSTEM® BASE COLORS

The Pantone Matching System® Base Colors are used to simulate the Pantone® Color Formulation Guide. These inks can be used in matches to achieve Pantone® color simulations, or let down with mixing clear. The ColorStar® Color Management System software uses Pantone Matching System® Base Colors. These color formulations are also available at [www.nazdar.com](http://www.nazdar.com).

### SPECIAL ADDITIVES

When inks are to be printed over a special effect color, the overprinting ink(s) must be evaluated for intercoat adhesion before proceeding with the production run. To maximize intercoat adhesion, specialty colors should be printed as late as possible in the print sequence.

The following special effect pigments may be added to the 6100 Series inks. These pigments are available in 1-pound containers. Contact Nazdar for the item number(s) and availability of each special effect product. Pigments may settle in the container; prior to printing, thoroughly mix the ink.

Silver (aluminum) Metallic: add up to 8% by weight.

Gold (bronze) Metallic: add up to 15% by weight.

Mix only enough metallic ink to be used the same day. Chemical reactions in metallic inks may result in viscosity, color and printability changes over time.

Pearlescents / Interference Pigments: add up to 20% by weight.

Multi-Chromatic Pigments: add up to 10% by weight.

See the Pearlescent, Interference, and Multi-Chromatic Technical Data Sheets for more information.

Phosphorescents: Add up to 20% by weight.

Fluorescents: Add up to 25% by weight. Fluorescent colors fade quickly with exposure to ultraviolet light.

### COLOR CARD MATERIALS

The following is a list of screen printed samples available.

Conventional Color Card: shows the Standard Printing Colors and Pantone Matching System® Base Colors.

Special Effects Color Card: shows Metallic, Pearlescent, Interference, and Multi-Chromatic effects mixed with clear

**PACKAGING** All items listed below are available in quart and/or gallon containers.

Stock Number	Standard Printing Colors	Stock Number	Pantone Matching System® Base Colors
6110	Primrose Yellow	6126	Mixing Clear
6111	Lemon Yellow	6158	Tinting White
6112	Medium Yellow	6159	Tinting Black
6119	Fire Red	6160	Orange
6120	Brilliant Orange	6161	Yellow
6121	Peacock Blue	6162	Warm Red
6122	Ultra Blue	6163	Rubine Red
6127	Overprint Clear	6164	Rhodamine Red
6152	Super Opaque Black	6165	Purple
6175	Super Opaque White	6166	Violet
		6167	Reflex Blue
		6168	Process Blue
		6169	Green

**PACKAGING** Additives/Reducers are available in gallon containers.  
Cleaners are available in gallon, 5 gallon and 55 gallon containers.

Stock Number	Additives/Reducers	Stock Number	Clean Up
5560	Fast Thinner	2555	Screen Wash
9050	Retarder	IMS202	Universal Graphic Screen Wash
		IMS301	Premium Graphic Press Wash

*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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