Color Vue 8800 Series Screen Inks have been formulated specifically for automotive, membrane overlay and appliance decorating applications, where strong transparent colors with lens-like clarity and high opacity colors are required. The 8800 Series is compatible with most acrylic transfer adhesives.

SUBSTRATES	Polycarbonate and some print-treated polyester

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 - 330 threads per inch (77 – 130 centimeters per inch) monofilament polyester mesh for most applications
STENCIL	Solvent resistant direct emulsions and capillary films
SQUEEGEE	70 to 80 durometer polyurethane squeegee
COVERAGE	1200 - 1800 square feet (112 – 167 square meters) per gallon depending upon ink deposit
PRINTING	Thoroughly mix the inks prior to 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. 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	8800 Series dries by solvent evaporation and dries at temperatures of 130° - 150°F (54° - 66°C). Good air circulation is necessary to remove the vaporized solvents. Multiple layers of ink may require longer drying times than a single layer; flood coats will take longer to dry compared to fine copy.
CLEARS / VARNISHES	*Mixing Clear / Metallic Mixing Clear:* Use 8826 Mixing Clear to reduce the density of colors or as a clear base for specialty additives such as Metallics. *Overprint Clear:* Use 8827S Satin Overprint Clear for first surface printing to provide a low gloss finish.
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 RE180 Thinner to reduce the viscosity. Add up to 20% by weight. *Flattening Powders:* Use 8848 Flatting Paste to produce a satin finish. Add up to 20% by weight. *Retarder:* Use RE183 Retarder to slow the drying process and increase ink stability on the press. Add up to 15% by weight. RE180 Thinner and RE183 Retarder may be added to the same ink.

CLEAN UP	*Screen Wash (Prior to Reclaim):* Use IMS201 Premium 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.

PROCESSING	*Die Cutting/Embossing/Adhesive Lamination:* Make sure the ink is thoroughly dry prior to any post print processing.

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 8800 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 and flow characteristics.

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® Management System software uses Pantone Matching System® Base Colors. These color formulations are also available at www.nazdar.com.

SINGLE PIGMENT TONERS	The Single Pigment Toners can be used in color matches, or let down with mixing clear.

TRANSPARENT COLORS	The Transparent Colors are specially formulated for lens-like clarity and can be used in color matches, or let down with mixing clear.

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 8800 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 Single Pigment Toners.

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.

'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.

Stock Number	Standard Printing Colors	Stock Number	Standard Printing Colors
88LF10	Primrose Yellow	8822	Ultra Blue
88LF11	Lemon Yellow	8824	Tinting Black
88LF12	Medium Yellow	8825	White
88LF13	Emerald Green	8826	Mixing Clear
8819	Fire Red	8827S	Satin Overprint Clear
88LF20	Brilliant Orange	8852	Super Opaque Black
8821	Peacock Blue	8875	Super Opaque White

Stock Number	Single Pigment Toners
8881	Orange Toner
8882	Carmine Toner
8883	Magenta Toner
8884	Maroon Toner
8886	Blue Toner (GS)
8888	Violet Toner

Stock Number	Transparent Colors
88PB10	Trans Primrose Yellow
88PB12	Trans Medium Yellow
88PB13	Trans Green
88PB18	Trans Red BS
88PB22	Trans Blue
88PB24	Dead Front Black
88PB60	Ruby Red

Stock Number	Pantone Matching System® Base Colors
88358	Tinting White
88359	Tinting Black
88360	Orange
88361	Yellow
88362	Warm Red
88363	Rubine Red

Stock Number	Pantone Matching System® Base Colors
88364	Rhodamine Red
88365	Purple
88366	Violet
88367	Reflex Blue
88368	Process Blue
88369	Green

PACKAGING
Additives/Reducers are available in quart and/or gallon containers.
Cleaners are available in 1-gallon, 5-gallon and 55-gallon containers.

Stock Number	Additives/Reducers
8848	Flatting Paste
RE180	Thinner
RE183	Retarder

Stock Number	Clean Up
IMS201	Premium 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.