



# TECHNICAL DATA SHEET

NAZDAR®

TECHNICAL INFORMATION AND APPLICATION INSTRUCTIONS

**MK SERIES MIRAKAL TINPLATE SCREEN INKS**

**CODE REF: 480/483/  
485/486**

**SUBSTRATES:** Roller coated tinplate.

**END USES :** Drums and cans.

## PRODUCT INFORMATION

This series is a variation on conventional MIRAKAL ink specifically designed for printing on acrylic roller coated tinplate. **THE 2 SERIES MUST NOT BE INTERMIXED.** Whilst the series numbers are presently the same, in the near future a unique series number will be allocated to MIRAKAL TINPLATE INKS.

## APPLICATION INFORMATION

**MESH** 90T or finer mesh is recommended.

**STENCIL** All direct photoemulsions, photostencils and hand cut stencil films that are solvent resistant.

**SQUEEGEE** Sharp edge 70-80 durometer polyurethane blades as well as triple durometer blades that produce an even ink deposit.

**COVERAGE** 25-40 sq m / kilo

**PRINTING** To improve flow, reduce the ink with 15-20% by weight of D564 S026 – Special Tinplate Reducer. **DO NOT USE ANY OTHER THINNERS AS THEY CAN CAUSE PRINT DEFECTS.**

**DRYING** MIRAKAL TINPLATE inks will air-dry in 20-40 minutes or can be heat dried requiring 1-3 minutes @ 80°C.  
Do not stack in piles whilst the print is still hot as heat generation in the pile can resoften the inks and can cause set-off or blocking.



*GL Specialized Inks (Pty) Ltd*

Registration No.: 1997/13081/007

PO Box 1026  
Westville, 3630  
SOUTH AFRICA

Tel: +27 (0)31 7006455  
Fax: +27 (0)31 7006187  
Website: www.gl-inks.com

Email: jay@gl-inks.com  
Email: gordon@gl-inks.com

**STOVING**

Do not stove at over 100°C for more than 5 minutes. Whites and light colours will yellow and/or darken.

Do not stack in piles whilst the print is still hot as heat generation in the pile can resoften the inks and can cause set-off or blocking.

**CLEAR /  
EXTENDERS /  
ADDITIVES**

Thinner – use only D564 S026 MIRAKAL TINPLATE THINNER to reduce the viscosity. 10-20% can be added, this is a slow thinner and a retarder should not be required – consult your local branch before adding any other solvent.

MIRAKAL TINPLATE Clear may be used to reduce colour strength or as a metallic mixing varnish for silver powder only.

**METALLIC**

Only metallic silvers are possible, as gold powders are not stable in this system. Imitation golds are possible, consult your local branch with regard to shades.

**ADHESION**

Allow the substrate to fully cool before testing.

Cross hatch tape test – use a cross hatch tool or sharp knife to cut through the ink film only. Apply 3M#600 clear tape on cut area, rub down and rip off. Ink should only come off from actual cut areas.

Fingernail scratch test – thoroughly dried ink will resist scratching.

**OVER VARNISH**

Pre-test carefully with any roller-coat overvarnish as reticulation is very likely to occur.

**CLEAN UP**

Use N660 S344 Screen Wash or N615 IMS 201 Premium Graphic Screen Wash for cleaning ink from the screen.

**GENERAL GUIDELINES****INK HANDLING**

All personnel mixing and handling inks must wear gloves and eye protection. Clean up spills immediately. If ink does come in contact with skin, wipe off with a clean, dry, absorbent cloth (do not use solvent or thinner). Wash and rinse affected area with soap and water. Consult the Mirakal Series Material Safety Data Sheet for further instructions and warnings.

**STORAGE**

Store tightly covered at temperatures between 15°C - 32°C. Ink taken from the press should not be returned to the original container. Store separately to avoid contaminating unused ink.

**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 dry out 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.

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.

Keep away from heat and open flame. Use with adequate ventilation. Avoid prolonged or repeated contact with skin. Avoid prolonged breathing of vapour or spray mist. Keep container closed when not in use.