



UV LED Rotary Screen White 3265

Technical Data Sheet

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Smiley 3265 is a UV LED curable opaque white screen printing ink specifically developed for combination printing with UV-Flexo.

- Fast cure speeds for high production output
- Flexible, high-gloss finish
- Intense color strength
- Fast cure speeds
- High chemical and solvent resistance
- Excellent opacity
- Low odor
- Minimal substrate edge curl
- Wide adhesion range

Substrates:

- Coated and Uncoated paper and board
- Pressure sensitive vinyls
- Top coated and print treated, polyesters, polyethylenes and BOPP films
- Polystyrenes

USER INFORMATION

Mesh:

Rotary Screen : 5 to 15 micron rotary screens recommended.
Flat Screen applications use 305-420T (120/165cm) monofilament equivalent.

Stencil:

Emulsion Recommended:
6063-009A One Pot Rotary Screen Emulsion

Pre-Production Test:

Before the print job is started, new materials must be checked for compatibility with the planned varnish/inks Combination, even if there suitability on a comparable type of the same substrate group is proved. The test prints, especially on self-adhesive labels, have to be determined after die-punching (in particular at the edges) for adhesion, resistance to scratching, and water (resistance to wet scratching and scuffing), resistance to the packaging contents and other job specific requirements.

Printing:

The whole printing unit (ink tube, doctor blade axle, pump circulation, etc..) has to be cleaned with detergent before printing. Because slight soiling can interrupt the flow of the screen printing white (pinholes).

Before use, the ink has to be stirred-up well.

Concerning substrates without topcoat, the flow could in some cases be improved by minimal increase of the blade pressure as well as adjustment (mostly increase) of corona treatment.

Elevated temperatures lower the ink viscosity, reducing print definition and film thickness.

Curing:

3265 Series cures when exposed to a UV LED curing unit

- 16 watts/cm²
- 395 nanometers wavelength
- Less than 4mm distance from substrate to cure unit
- Under normal conditions, it is possible to print at a speed of 30 - 60 m/min
- If the ink cure insufficiently, reactivity can be increased with addition of liquid photo initiator solution 3265-6449 (addition 3-5%). However, if the ink deposit is too high or UV energy clearly too low, an addition of photo initiator won't lead to a further curing improvement and inks will tend to build wrinkles and become tacky.

Note: UV LED curing resistance tests shouldn't start before a period of 24-72 hours.



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Thinner & Wash-up:

- For fast running printing machines viscosity of the inks can be adjusted with UV thinner 3265-0064. Viscosity can be reduced (addition 5 – max. 10%).
- Wash-up: Use 4050-001 Screen Wash and Cleaner.

GENERAL INFORMATION

Handling & Storage:

- **Smiley 3265** is formulated free of lead and other heavy metals
- It is recommended to wear suitable protective gear such as glasses and gloves. Take particular care to avoid splashes into the eyes and skin contact. . If the ink comes in contact with skin, wash with soap and plenty of water. If ink comes in contact with eyes, wash with plenty of water and consult with a doctor.
- Comprehensive information on the safety and handling of Smiley 3265 screen inks and thinners is given in the appropriate Smiley Material Safety Data Sheet (MSDS), which are available upon request.
- Store tightly covered at temperatures between (18° - 25°C). Can be stored for 1 year under these conditions.
- Tins should be kept tightly closed when not in use.

Environmental Information:

- Do not contain ozone depleting chemicals.
- UV LED Rotary Screen White 3265 should be disposed properly (see MSDS) and in accordance to local regulations to avoid contamination.

Recommended Stencil

Making Products:

- Screen Preparation
 - Mesh Preparation 6050-300 – for abrasion
 - Mesh Degreaser 6050-200 – for degreasing
- Screen Emulsion
 - 6063-009A One Pot Rotary Screen Emulsion
- Screen Cleaning
 - Ghost Remover 6070-100
 - Stain Remover 6070-001
- Screen Reclaiming
 - Stripping Powder 6070-200

PRODUCT OFFERING

Packaging:

3265 is available in 1 Kilo, 5 Kilos and 20 Kilos containers.

ADDITIONAL INFORMATION

For additional product information, please visit our website at <http://www.smiley.co.th>.
For further information, please contact SPS personnel at medhi@smiley.co.th

Thank you for choosing **SMILEY**.

Smiley Printing Solution Co., Ltd. (SPS), abides by the quality of this product. The information and recommendations that embody this Technical Data Sheet along with the technical advice are based solely on our knowledge and therefore confident to be precise. This product has been specifically formulated for screen printing. SPS cannot guarantee the precision for other possible application for the reason that manufacturing methods and other materials vary. Any liability amalgamated with the use and application of these products, users are the sole bearer of responsibility for choosing appropriate product for end-users' requirement. This Technical Data Sheet is provided for the technical purpose in the usage of this product and users are expected to follow current recommendation.

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