

Long Term Decals

Vehicle Graphics (Buried/Unburied)

Inks

SUPER DECAL SD

Screen Inks for Long-Term 'buried & Unburied Decals)

Features

- Solvent Based
- Gloss/Satin Finish
- PU/TSA lacquer compatible ink system
- Long-Term Outdoor Durability
- Excellent Screen Stability & Self Solvency
- Suitable for Machine & manual printing
- Good flexibility
- Good Stretchability
- Excellent Resistance to a range of solvents
- Seritone colours & process colours
- Unlimited colour matching capability
- Range of Metallics

Substrate

Self Adhesive Vinyl

**TEST INKS ON SUBSTRATES
BEFORE PRODUCTION RUN**

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Thinning

Maximum of 15% by weight of ink used. Various options for thinning are available. Please refer to the section on 'Solvents'. However actual percentage of thinning required is to be studied by customer based on the Job and suitability has to be tested before production run.

Mesh

Print the Super Decal SD inks & Metallic colours through 62/cm to 90/cm, monofilament polyester fabric, depending on the application.

For SD-025 Ground Coat White: 77/cm to 90/cm mesh. For SD-425 Overprint Clear: 77/cm mesh. For fine details printing, use amber or yellow coloured fabric

Stencils

Stencils can best be prepared with Sericol's stencil making products:

Xtend Prep 101: for abrasion of Screen

Xtend Prep 102: for degreasing of Screen

Emulsion: Dirasol 132 single Pack or Dirasol 915/916 two pack.

Drying

Air Dry: up to 20 minutes. Do not stack prints immediately. Allow sufficient time for through cure.

Jet Dry: 60 degree centigrade, for maximum 4 minutes.

Prints must be cooled to ambient temperature before stacking. This has to be studied by customer based on the Job before production run.

Coverage

Super Decal SD inks should give a coverage of 60 to 70 sq.m./kg when printed through a 90/cm mesh.

Metallics & SD-425 should give a coverage of 40 to 45 sq.m./kg when printed through a 77/cm mesh

The above information is based on our knowledge however it is advised customer to evaluate the millage for the type of Job.

Wash Up

Wash up screens with SS-639 Universal Screen Wash. This will ensure long life of stencils made with Dirasol emulsions.

Outdoor Use

Super Decal SD/SF ink print panels overprinted with SD-425 has been successfully tested for weathering in a QUV Weather-ometer, as per ASTM G53 test specification, using UVB-313 lamps. The inks have withstood more than 1000 hours without appreciable colour change or deterioration. SD/SF ink print panels overprinted with SD-425 have been also tested for weathering in Q-Sun Xe 3HS weather-ometer with extended UV filters according to SAE J 2527 and observed no appreciable colour change withstood more than 1000 Hrs.

The colour change is assessed by grey scale as per BS EN 20105-A02:1995/ISO 105-A02:1993.

Uvigloss UD-433 UV overprint varnish has also been tested independently in Q-Sun Xe 3HS weather-ometer and observed no appreciable colour change and withstood more than 1000 Hrs.

Important: Super Decal SD/SF inks must always be overprinted with SD-425 overprint clear for both 'buried' and 'unburied' applications.

In case of metallic colours to be printed on metallized PVC Vinyls or directly opaque Vinyl, it is advised to use SD-481 as a base coat as well as mixing clear and also overcoat on metallic shade before printing overprint clear SD-425.

Uvigloss UD-433 UV Overprint varnish is recommended to be used as overprint on unburied decals.

Pre-Production Test

End-user must determine suitability of this product for the intended use prior to production. Always test for adhesion, lacquer (PU/TSA) compatibility, weathering, inter-coat adhesion and other relevant properties before each production run.

Storage

- Keep inks in a cool place, away from direct sunlight.
- Keep the ink can tightly closed when not in use; left over inks should not be returned to the ink can.
- Shelf life is Maximum three years from the date of manufacture.
- Stir well before use.

Applications

Super Decal SD/SF inks are used for long-term decal applications - both 'buried' & 'unburied', e.g., in vehicle striping, dome label etc.

Product Resistance

Super Decal SD/SF inks & metallics, overprinted with SD-425 overprint clear medium, have excellent resistance to a wide range of solvents including xylene, petrol and alcohol.

Colour Range

The Super Decal SD Ink System is lead free and silicon free. The system includes Seritone Matching System colours, trichromatic (process) colours, a Mixing Clear and a Two pack overprint clear

Seritone Colour Range

- SD-001 Super Decal SD Black
- SD-025 Super Decal SD Ground Coat White
- SD-064 Super Decal SD Seritone Yellow GS
- SD-066 Super Decal SD Seritone Yellow RS
- SD-114 Super Decal SD Seritone Orange
- SD-127 Super Decal SD Seritone Violet
- SD-164 Super Decal SD Seritone Red BS
- SD-165 Super Decal SD Seritone Magenta
- SD-191 Super Decal SD Seritone Red YS
- SD-230 Super Decal SD Seritone Blue
- SD-325 Super Decal SD Seritone Green
- SD-481 Super Decal SD Mixing Clear/Base Coat /Metallic Overcoat used before SD-425
- SD-425 Super Decal SD Overprint Clear
- SD-386 Super Decal Hardener for SD 425
- SD-426 Thinner for SD-425

Trichromatic Colours

- SD-004 Super Decal Trichromatic Black
- SD-052 Super Decal Trichromatic Yellow
- SD-135 Super Decal Trichromatic Magenta
- SD-215 Super Decal Trichromatic Cyan

Super Decal SF Satin Finish Seritone & Line Colours

- SF-001 Super Decal SF Satin Black
- SF-127 Super Decal SF Satin Violet
- SF-165 Super Decal SF Satin Magenta
- SF-230 Super Decal SF Satin Blue
- SF-325 Super Decal SF Satin Green
- SF-802 Super Decal SF Satin Orange
- SF-821 Super Decal SF Satin Red (Y/S)
- SF-841 Super Decal SF Satin Yellow (G/S)
- SF-843 Super Decal SF Satin Yellow (R/S)
- SF-864 Super Decal SF Satin Red (B/S)

Two Pack, Solvent-based PU Overcoat SD-425 Clear

Mix SD Overcoat in the following way

1. SD-425 100 Phr
2. SD-386 (Catalyst) 10 Phr
3. SD-426 (Thinner) 10 Phr

Mix the above ingredient well, wait for minimum 10 minutes, and then apply the overcoat. Do not use high speed

Mesh: 77T

Drying: IR dry for 5 minutes@60°C,

Bake it for 80°C for 1 hr

Squeegee: Medium

Substrate:PVC

Pot Life: Max. 6Hrs from mixing

Mixing Instructions: Mix the colours or Metallic mediums or for preparation of SD-425 overprint clear with catalyst & solvent; use stirrer/mixer with low speed to avoid air bubble entrapment and leave for minimum for 20 minutes for degasing. This will avoid the pin holes/ air entrapment in the print and gives flat and smooth print finish.

Result: Cross Hatch Tape test and other relevant tests should be done with the gap of 72 Hrs after print has been baked.

Note: Do not put the remaining material left on screen in the SD-425 overcoat Tin.
Keep remaining material separately in other Can

UV EL Overprint Varnish UD 433

Mesh: 140T to 160T

Curing: 300 watts/15 meters and minimum dose/energy required is 200 m² for curing.

For more information on UD 433 please check the technical literature of UD 433.

Note: This should not be used for buried applications. Customer should the suitability of UD-433 before production run.

Colour Matches

The colour matches can be supplied against specimen prints and / or wet inks.

Metallic

A wide range of metallics can be developed on request.

Solvents:

SS-557 Reducer

SS-565 HD Reducer

SS-558 Slow Reducer (retarder)

SS-639 Universal Screen Cleaner

SD-426 Thinner for SD-425

The slow reducer will increase the drying time, whilst fast reducer will decrease the drying time of the print.

Co-Use with Other Sericol Inks

Super Decal SD/SF Ink System must not be intermixed, overprinted or under-printed with any other Sericol Ink System. Super Decal SD/SF inks are free of silicon. Hence all precautions must be taken to avoid silicon contamination during printing

Safety and handling

Super Decal SD/SF Ink System is formulated free from lead and any toxic (carcinogenic), mutagenic or reprotoxic chemicals.

SD/SF ink system is formulated to comply ROHS.

Comprehensive information on the safety and handling of Super Decal inks and solvents is given in the Material Safety Data Sheet, which is available on request.

Environmental Information

Super Decal Ink System does not contain ozone - depleting chemicals as described in the Montreal Convention.

Important Note to Printers:

Responsibility for ensuring that the goods processed with our product meet the requirements of OEM/brands/agencies/ rests solely with the processors.

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The information and recommendations contained in this Product Information sheet, as well as technical advice otherwise given by representatives of our Company, whether verbally or in writing, are based on present knowledge and believed to be accurate. However, no guarantee regarding their accuracy is given as we cannot cover or anticipate every possible application of our products and because manufacturing methods, printing stocks and other materials vary. For the same reason our products are sold without warranty and on condition that users shall make their own tests to satisfy themselves that they will meet fully their particular requirements. Our policy of continuous product improvement might make some of the information contained in this Product Information sheet out of date and users are requested to ensure that they follow current recommendations

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