



## Suggested Uses:

The T-255 is a 100% solids UV curable screen printing ink that, when processed properly, exhibits a super matte finish with excellent surface durability, water resistance, chemical resistance and superior flexibility for die cutting and embossing. **It is the responsibility of the end user to pretest all substrates with Norcote® products prior to use in production.**

## Printing Recommendations:

The T-255 is formulated to print from the container without the use of additives to increase flow and print consistency. Prior to printing, the T-255 should be well mixed. Best results when printing flood areas are acquired by keeping ample amounts of ink in the screen, unlike gloss graphic inks. When using high speed presses, best results are obtained when printing no more than 800 impressions an hour.

## Mesh:

200-305 plain weave meshes are recommended. Mesh count selected will affect gloss values.

## Stencil:

Direct emulsions or capillary films that are UV ink compatible.

## Squeegee:

Sharp 70-90 durometer polyurethane blade or multi-durometer blades can be used. For optimal ink lay down, a sharp 80 durometer blade is recommended.

## Coverage:

2,000-3,000 square feet per gallon, depending upon ink deposit.

## Thinner:

The T-255 is supplied in a print ready condition. Due to the surface of the printed ink, thinners are not recommended to reduce the viscosity. If the viscosity of the product needs to be adjusted, the use of 049 Clear is recommended. Contact the Technical Service Department for additional information on the use of clears in the T-255.

## Screen Cleaning:

Most conventional solvent cleaners work well. Alcohol based solutions must be avoided as they break down the emulsion. Norcote recommends Press Wash 110 (flash point 113° F), 140 (flash point 140° F) or NSW-824 (flash point 150° F). These products are used for cleaning ink off screens during on press color changes or before storing the screen. They work well when removing ink from squeegees, flood bars and other equipment. Contact us for packaging options.

## Packaging:

The T-255 is available in one (1) gallon, three (3) gallon and five (5) gallon containers. Contact Norcote for more information on large volume packaging.

## Cure & Adhesion:

The T-255 Textured Clear is formulated to cure under 200 watt medium pressure mercury vapor lamps (focused) and requires a minimum of 189 mJ/cm<sup>2</sup> and 1.4 watts per inch (2 @ 200 approximately 155 feet per minute) to ensure adhesion to most polycarbonate and polyester substrates.

Adhesion is determined by the use of a cross hatch / tape test (ASTM D-3359) on a printed part that is cooled to room temperature, applying 3M #600 tape.

## Precautions:

Avoid direct contact of ink with skin and clothing. If contact occurs, wash affected area with warm soapy water and dry thoroughly. If eye contact occurs, irrigate the area with water for 15 minutes and consult a physician. For more specific information, refer to the relevant Material Safety Data Sheet.



## Storage & Available Warranties

All UV T-255 ink should be stored in tightly closed, black polyethylene container in an area with the temperature not to exceed 90° F (32.2° C). Avoid direct sunlight and indirect white light. Excess ink from print runs should be stored in separate containers to avoid contamination and is not covered under any warranty. When stored under these conditions, Norcote warrants the Products shall be free from defects in material and manufacture for a period of one (1) year from the date of sale for the T-255 inks, with no additives, and for a period of one (1) month from the date of sale for any custom color containing Day Glo® JZB or T-Powder. **Norcote will not warrant any custom colors containing metallic pastes or any inks intermixed with competitor products.** Any warranties provided will be limited to the price paid for the actual products used which give rise to the warranty claim.

This Technical Bulletin is intended to be used for informational purposes only, and is in no way intended to create any warranties or other obligations on behalf of Norcote. All warranties, terms and/or conditions for a particular product will be specified on the applicable invoice and are only valid upon the creation of a legally-binding contract.

## Testing

Due to the inability of Norcote to anticipate or control the conditions under which the Products and information relating thereto will be used and/or stored, Norcote cannot guarantee the results obtained from using the Products. Any Suggested Uses are merely representative, and because the final product will depend on a number of specific factors, the end user should pretest all substrates with the Products prior to use in production.

## \*PVC Plastics:

Decoration can aggravate embrittlement properties of PVC plastics which can lead to cracking and failure of the plastic. It is strongly recommended that the end user contact the polymer manufacturer to obtain information on the suitability for decorating with a UV ink as well as recommendations for molding / processing to reduce this potential. As every situation can not be tested for in a laboratory environment, it is the responsibility of the end user to determine the suitability of the products chosen for an end application.

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