



NoriCard

Screen Printing Ink for Lamination of ID and Credit Cards

Area of Application and General Characteristics

NoriCard is a solvent-based screen printing ink suitable for printing on PVC, ABS and PETG core films used in card manufacturing.

NoriCard has excellent laminating properties with uncoated PVC and PETG overlay films at a temperature of 140 °C (285 °F) and good peel strength.

Range of Colors

The NoriCard metallic ink system includes four standard silver colors of different pigment particle sizes (from fine, middle-coarse and coarse). The transparent and satin gloss color shades serve to mix a wide spectrum of gold, copper and other metallic colors.

Standard Silver Colors	771 Silver Fine	Mesh 100-40 th/cm (255-40 th/inch)
	776 Silver Medium Coarse	Mesh 77-48 th/cm (195-48 th/inch)
	781 Silver Coarse	Mesh 77-48 th/cm (195-48 th/inch)
	786 Silver Coarse	Mesh 61-64 th/cm (156-64 th/inch)

Color Shades	093 Colorless
	172 Yellow Transparent Satin Gloss
	370 Red Transparent Satin Gloss
	467 Pink Transparent Satin Gloss
	567 Blue Transparent Satin Gloss
	667 Green Transparent Satin Gloss
	945 White
948 Black Satin Gloss	

Effect Pigment Colors Further Effect Pigment Colors are available on request. Please ask for our latest Color Information.

Overprinting with Offset Inks

To improve the adhesion of offset inks when using NoriCard metallic colors it may be necessary to add 5 – 15 % of Offsetprimer "NoriCard 078 Colorless Turbid" to the formulation.

Offsetprimer

Screen printable NoriCard 078 can be used to enhance offset printability of plastic films. The Offset Primer provides a paper-like, absorbing surface.

NoriCard 078 Colorless Turbid Mesh 100-40 threads/cm (255-40 threads/inch)

Thinning

Thinner M 213
Thinner M 217
Addition: 10 – 20 %

Defoamer

If necessary, **Defoamer L71697** can be added to the ink mixture before printing begins. This must be stirred in well to ensure good levelling of the printing film.

Addition: 0,3 % Defoamer L71697

Stencil

Solvent resistant emulsions must be used. Excellent results during long production runs are achieved by using Pröll Diazo-UV-Polymer Emulsion Norikop 10 HQ.

Drying

NoriCard is physically drying by evaporation of the solvents. After tunnel drying at 50 °C (120 °F) further rack drying at 50 °C (120 °F) is recommended. The period of drying depends on fabric and ink thickness. The block resistance has to be tested under respective drying conditions, in particular on PETG core films.

Cleaning Screens and Utensils

UNI-CLEANER FP61 or UNI-REIN A III

Shelf Life

The shelf life stated on the label assures the ink's quality and refers to unopened original cans stored in a dry place at temperatures between 5 °C (40 °F) and 25 °C (75 °F).

Important

Allow the ink as well as all the auxiliaries to be added to adjust to ambient temperature in the closed container before use.

Printing results, to a large extent, depend on the substrate as well as the printing and application conditions. We recommend checking your printing materials under your conditions of use prior to any production runs. Materials that are supposed to be identical may vary from manufacturer to manufacturer and even from batch to batch. Some substrates may have been treated with or can contain sliding agents, antistatics or other additives which will impair the adhesion of the inks.

In general please refer to our technical leaflet "General Information on Screen Printing Inks" which may be downloaded from our website www.proell.de, click Downloads ⇒ Solvent-Based Screen Printing Inks.

Before starting a production run, it is necessary to test samples of each newly designed part systematically with regard to the specifications for the intended use (e.g. climatic chamber, resistance, etc.).

The information contained in the technical information/instruction sheets or other product information sheets is based on product testing conducted by Pröll. Because printing and environmental factors critically affect each individual ink application, the above mentioned information and instructions represent only general recommendations concerning product characteristics and directions for use and should not be construed as representing express warranties regarding the product. The information and instructions in no way release the purchaser from his obligation to verify and test the inks and their application for the specific request, regarding: product characteristics, weather resistance, mixing proportions, gloss, thinning, special mixtures, printability, drying speed, cleaning, effects on or of other materials to be contacted and safety precautions. All details contained in the instruction sheet "General Information on Screen Printing Inks" are to be considered. The further manufacture and use of products containing our inks by the purchaser takes place beyond our control, and the responsibility for further application and use of our product resides solely with the purchaser. Pröll disclaims any warranties, express or implied.

This information supersedes all previous technical information.