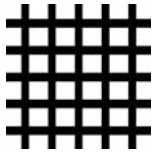


TECHNICAL DATA SHEET**SHORT DESCRIPTION:**

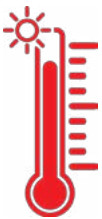
One of the oldest special effect inks in the book, puff inks are fun and useful in many different applications. You can give your logo a bit of height or print the bottom of socks for grip. There are so many different uses for our 680 Series Puff inks.

QUICK SPECIFICATIONS:**MESH COUNT**
86 to 110

This is simply a recommendation based on printing high density prints. 680 Series Puff will easily print through finer mesh counts when necessary for detailed art work. However, this will effect the total puff effect of the print as thicker prints will puff more.

**FLASH CURE**
3/5: Average

The rating of **AVERAGE** implies a flash cure performance similar to most plastisol inks. Due to the great number of variables involved, we cannot specify a specific flash time or temperature. However, this ink should flash dry like most inks you have printed before.

**INK CURING**
320°F to 330°F

Washing and drying your prints to check durability is the ultimate test of ink curing. However, the use of Thermolabels is the most sensible method of testing for your day-to-day operations. This will help you prevent cracking, peeling, and washout.

**SQUEEGEES**
70 Durometer

Squeegees are one of many variables controlling your ink deposit. Softer squeegees are capable of printing thicker while hard squeegees allow for better print resolution. 60 durometer is soft. 70 durometer is medium. 80 durometer is hard.

**CLEAN UP**
PW-4 or IR-26

Many cleaning products will remove plastisol ink. We recommend SaatchiChem PW-4 for cleaning on-press. The IR-26 is ideal when cleaning in a washout booth. Cleaning the ink out of the screen immediately after printing is always recommended.



TECHNICAL DATA SHEET

PUFF BENEFITS:

- Very simply special effect as this prints just like any other plastisol ink.
- Change screen mesh to adjust how much the ink will puff.
- We offer our entire Originals Color Book in puff formulas.
- Print on the bottom of socks for use as “grippers”.

IDEAL CURING GUIDELINES:

Cure Puff inks at the temperatures listed below (measure with a Thermolabel). Curing is a time and temperature process. A lower temperature with a slower belt speed is always the best method.

100% Cotton	Poly/Cotton	Polyester	Nylon/Stretch	100% Nylon	Polypropylene	Rayon
320°F	320°F	X	X	X	X	X

*Puff inks will adhere to 100% polyester fabrics. However, due to dye migration concerns it is not recommended. If you must print 100% polyester, consider a white underbase with one of our universal white inks.

TIPS AND TRICKS:

- The thicker you print this ink, the taller the print will become after it is cured.
- Puff inks are much different from high density inks. High density printing requires special thick capillary film and a very high viscosity ink. Puff inks are like any other plastisol until they are fully cured.
- Great for printing baseball hats as the puff will cover the seam down the middle of the hat.

Always perform a pretest print and test cure conditions on the fabric to be printed to establish the best results. Stir inks vigorously before each use. Viscosity may need adjusting for best results. If there is ever a question about a print job, call us at 800-942-4447. We are always happy to help!