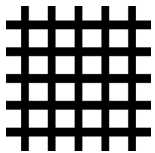


**TECHNICAL DATA SHEET****SHORT DESCRIPTION:**

For those of you with PVC free requirements, we finally have a PVC free option which prints easily, covers well on dark fabric, and doesn't have a short shelf life. Unlike high solids acrylic options, this is not water-based so you don't need special emulsion and equipment.

**QUICK SPECIFICATIONS:****MESH COUNT**  
86 to 230

This is simply a recommendation based on printing dark fabrics. Preventing coverage and dye migration problems may require a generous ink deposit. PVC Free can print through finer mesh counts easily. PVC Free Black Underbase requires 86 or 110 mesh.

**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**  
300°F to 320°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 Saatchem 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.



**PVC FREE**

**TECHNICAL DATA SHEET**

**PVC FREE BENEFITS:**

- PVC free plastisol ink.
- Will not harden in the bucket after only a few weeks (common with other PVC free ink).
- Very opaque and bleed resistant white ink for use on most fabrics.
- Special black underbase ink for printing difficult 100% polyester will stop dye migration.
- No special emulsion and won't dry in the screen.

**IDEAL CURING GUIDELINES:**

Cure the PVC Free 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
300°F	300°F	300°F*	300°F	300°F	X	X

\*Screen printing white or light colors on 100% polyester requires the PVC Free Black Underbase for success. This special ink will give the PVC Free white and colors the bleed resistance they need to stay bright.

**TIPS AND TRICKS:**

- When screen printing stretchy fabrics, avoid a thin ink deposit. The ink must be thicker to allow awesome stretch without cracking.
- PVC Free inks are not recommended for printing sublimated polyester. Consider our ELT Series with ELT Digital Black Underbase with ELT-X Series inks printed on top. These options are sure to keep your customers happy.
- Screen printed transfers is an easy way to apply PVC free decorations for all fabrics. Call us for recommendations.

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!