

TECHNICAL DATA SHEET**SHORT DESCRIPTION:**

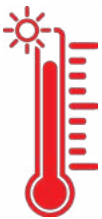
Production Series is a universal ink for printing virtually any fabric. The biggest benefit is the extremely quick flash cure time. The little heat needed for flashing will help prevent a long list of heat-related fabric problems. Production covers great and prevents dye migration.

QUICK SPECIFICATIONS:**MESH COUNT**
86 to 158

This is simply a recommendation based on printing opaque prints on dark fabric. Production Series will easily print through finer mesh counts when necessary for detailed art work. This is a great plastisol ink for printing simulated process as well.

**FLASH CURE**
5/5: **Exceptional**

The rating of **EXCEPTIONAL** implies a flash cure speed of approximately half that of any standard plastisol ink. Due to the great number of variables involved, we cannot specify a specific flash time or temperature.

**INK CURING**
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 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.



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FAST FLASH BENEFITS:

Faster flashing inks help prevent numerous fabric/printing problems which have become such a nuisance. These problems include:

Dye Migration

Excessive flash cure times and temperatures may cause “bleeding” or dye migration of the fabric color into your ink. Fast flash inks allow you to heat quickly and get the print away from the heat, protecting the fabric and the ink.

Shrinking

If your fabric shrinks under the heat of a flash unit, the other colors will no longer register properly. Flash curing faster or at a lower temperature is your only effective option.

Scorching/Melting

Fabrics will burn, leaving dark or even charred burn marks on your apparel. This can happen while flash curing or fully curing in the conveyor dryer. Excessive heat is the culprit. However, items such as polypropylene and nylon may scorch at significantly lower temperatures when compared to cotton and poly/cotton.

Color-Changing

Fluorescent cotton and poly/cotton fabrics have a tendency of darkening when over-heated. This is not always easy to see as the color change is often slight. It most commonly occurs on safety yellow, fluorescent green, and fluorescent orange tees. If you can flash cure quickly or at a significantly lower temperature, the fabric can be saved.

PRODUCTION SERIES BENEFITS

- Flash cures in an instant.
- Universal ink for printing virtually any fabric.
- High viscosity ink. Perfect for automatic screen printing presses.
- Opaque white and colors. No white underbase needed on dark fabric.
- Great simulated process ink due to the quick flash cure time.
- Excellent bleed resistance on 100% polyester.



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IDEAL CURING GUIDELINES:

Cure the Production Series 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 | 320°F | 320°F* | 320°F | X | X |

*Production Series has good flexibility. However, when printing any spandex or lycra blend, adding S-Additive is highly recommended. 10% S-Additive to 90% ink is the recommended mixing ratio. Never exceed 15% S-Additive into any ink.

TIPS AND TRICKS:

- If you are a manual printer with multiple printing stations on your press, you may think that flash time does not affect you. The fabric is under the flash cure unit for the same amount of time regardless of how fast the ink flash dries. Consider raising your flash unit or turning down the heat. The lower temperature will protect your fabric and the ink will be dry.
- Production Series really excels on automatic screen printing presses. This is not a thin ink which will sink into the fabric once the platens and ink warms up.
- Any color found on the Signature color book will have great opacity. Print-flash-print these colors on dark fabric without a white underbase and the color will still look true.
- If you require an upgrade to the Production White, consider our Production Plus White as we have boosted both the opacity and bleed resistance for use on the worst 100% polyester fabrics.

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!