

TECHNICAL DATA SHEET**SHORT DESCRIPTION:**

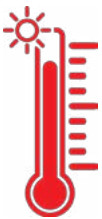
High density printing is difficult. The ink is very thick. The screens take 4 to 5 times longer to expose and to rinse out. Your exposure unit may not be strong enough to expose this sort of screen. All of these problems are solved with the Soft-N-Easy HD Series.

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

This is simply a recommendation based on printing high density prints. Soft-N-Easy will easily print through finer mesh counts when necessary for detailed art work. However, this will effect the total height of the print as thicker prints will look taller.

**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 Saatichem 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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SOFT-N-EASY HD SERIES BENEFITS:

- High density screen printing without the use of special capillary films or thick emulsion.
- Unlike most high density inks, these are very soft and will stretch without cracking.
- Amazing opacity.
- Much creamier viscosity when compared to standard HD inks.

IDEAL CURING GUIDELINES:

Cure the Soft-N-Easy HD Series 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

*Soft-N-Easy HD Series 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.
- Soft-N-Easy HD Series is much different from a regular puff ink. This ink will only rise in the dryer. It will not puff up and out into all directions, leaving a much sharper edge.
- You can print these inks through a thick capillary film just like you would with high density inks. The effect will be huge.

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!