

TECHNICAL DATA SHEET**SHORT DESCRIPTION:**

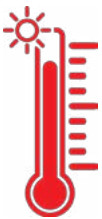
Sparkle Series is a custom line of inks for you to play with. We offer regular Sparkle (sparkle in a clear base) and Sparkle Super (sparkle in a pigmented base). Both options have their place. Check our Tips & Tricks section at the end of page 2.

QUICK SPECIFICATIONS:**MESH COUNT**
38 to 61

This is simply a recommendation as Sparkle Series can screen print through 86 count mesh. However, this may cause build-up problems as the sparkle flake is large. Sparkle inks will not provide great detail due to the coarse 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**
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**
60 Durometer

Soft squeegees tend to do a better job printing glitter inks. 60 and 70 durometer will give you great prints. 80 durometer and triple durometer squeegee rubber may be too hard, causing the glitter flake to get caught up in the screen.

**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.



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SPARKLE SERIES BENEFITS:

- The smaller glitter flake (compared to Glitter Series) provides better print detail.
- Super Sparkles give you a whole new dimension of bling as the pigment in the base will compliment the glitter color.
- Easy to print on both manual and automatic equipment.
- You get two completely different looks with one print compared to a print-flash-print.

IDEAL CURING GUIDELINES:

Cure Sparkle 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*	X	X	X	X

*Dye migration on 100% polyester fabric is a concern. Screen Printing white polyester is not going to be a problem. However, if you would like to print polyester colors, please pre-test to see how the ink will react. Consider an underbase.

TIPS AND TRICKS:

- Fine detail with a 38 to 61 count screen is impossible. If you require detailed art work, print an underbase color through finer screen mesh and then print Sparkle Series (not Super Sparkle) on top. This will give the appearance of better detail.
- Do not use excessive pressure when printing any glitter ink.
- Flood the screen with plenty of ink. 38 count mesh is very coarse and requires much more ink during the flood stroke to be successful.
- Consider color combinations such as Sparkle Blue on top of navy blue ink or Sparkle Red on top of cardinal ink.

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!