

## TECHNICAL DATA SHEET

### SHORT DESCRIPTION:

How about a suede ink? This is possible with Velvet Series inks. These plastisol colors will puff up in the dryer and give you the suede/velvet look and feel. You will get many different looks and feels as every screen mesh seems to change its effect.

### QUICK SPECIFICATIONS:



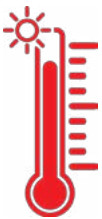
**MESH COUNT**  
86 to 180

This is simply a recommendation as each screen mesh will slightly change the effect of this ink. Coarse screen mesh will give it the texture of a leather football or basketball. Fine screen mesh will give you the suede/velvet feel. 158 count mesh is a great start.



**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.



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**VELVET SERIES BENEFITS:**

- Soft, fuzzy feel.
- Velvet Leather and Round Ball Orange will give you the ability to match the look and feel for a football or basketball.
- Numerous effects controlled by ink deposit.
- Adds life to regular prints.

**IDEAL CURING GUIDELINES:**

Cure the Velvet 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

\*Velvet Series ink is not very bleed resistant. A white underbase is recommended when printing light colors such as yellow or gold on top of dark poly/cotton tees. Velvet Series will adhere to 100% polyester. However, dye migration is a big concern.

**TIPS AND TRICKS:**

- Start with a 158 count screen for a suede look and feel.
- Print through an 86 count screen for the football or basketball dimple look and feel.
- If you cure the ink too hot, much of the fuzz may flake off.
- If you cure the ink too cool, the print may look patchy or not fuzzy.
- Ink deposit is everything with Velvet Series. Try numerous screens. Print-flash-print. Experiment to see for your self.

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!