

TRI  **ANGLE**
INK Co., Inc.

GENERAL DESCRIPTION:

Tri-Flex 1100 series plastisol, is formulated for direct wet-on-wet printing of athletic and leisure garments and can also be used for the limited manufacture of plastisol transfers. This Series comprises our most extensive range of standard colors, Non-fluorescent and Fluorescent, Metallics, Glitters and other effects.

STOCK:

For direct prints, knit and woven T-shirts, sweatshirts, jerseys, fleece goods, and bandanna stock may all be used. All popular types of transfer release papers may be used to produce cold peel transfers.

STENCILS:

All types of solvent resistant emulsions are suitable.

SCREEN MESH:

A 110T monofilament is the popular choice: direct printing may also employ the use of mesh sizes 60T to 280T monofilament or equivalent.

CURING:

315°F TO 330°F depending on ink deposit, fabric type, ink color and dryer efficiency. Failure to properly cure is the primary reason for ink adhesion failure. Thick ink deposits do require more energy (longer dwell time) to cure, similarly a 100% cotton fabric because of its high moisture content will reduce curing efficiency compared to a 50/50 cotton polyester mix. Dark colors absorb heat and cure faster than light colors. Colors, which reflect heat- metallics, glitters and shimmers, also require more energy to properly cure. Finally the use of a Forced Air Dryer is far more efficient for thorough curing than the use of a Radiant Heat Unit.

WASH-UP:

Tri-sol 25 or equivalent (Mineral Spirits).

STORAGE PROCEDURE:

Store at room temperature. Keep away from heat.

WARNING: FOR INDUSTRIAL USE ONLY KEEP AWAY FROM CHILDREN

NOTE: Please note that all colors are made without the use of lead or heavy metal pigments. The information on this data sheet is based on laboratory tests and production experience. Directions and procedures for use of Triangle-Ink products must be considered as recommendations only. The printer is solely responsible for determining suitability of any Triangle product for a specific application. We recommend that all products be pre-tested prior to production. No warranties are implied or expressed.

(1/05)

Standard Pigment Colors

1101	S.O. White
1102	White
1109	Backing White
1112	Old Gold
1113	Chrome Yellow
1114	Lakers Gold
1115	Gold
1116	Lemon Yellow
1117	Gold Yellow
1118	Dolphin Orange
1121	Light Red
1122	Scarlet
1123	Triangle Red
1124	Deep Red
1125	Bright Red
1126	Flag Red
1127	Burgundy
1128	Cardinal
1129	Maroon
1135	Gray
1142	Kelly Green
1143	Op. Bright Green
1144	Dallas Green
1149	Navy
1150	Light Navy
1151	Light Blue
1152	Op. Reflex Blue
1153	Ultra Blue
1154	Navy Blue
1155	Brite Blue
1156	Columbia Blue
1157	Royal Blue
1158	Turquoise
1159	Purple
1160	Tan
1164	Med. Brown
1166	Dark Brown
1170	Black
1172	Black Silk
1173	Batman Black
1192	Fuschia
1194	Violet

Process Colors

110	Process Yellow
120	Process Rubine Red
122	Process Magenta
150	Process Blue
152	Process Reflex Blue
153	Process Cyan
170	Process Black

Fluorescent Colors

310	Fluorescent Yellow
318	Fluorescent Orange
320	Fluorescent Red
330	Fluorescent Pink
340	Fluorescent Green
350	Fluorescent Blue
359	Fluorescent Violet
390	Fluorescent Magenta

Specialty Colors

1100-322	Crystalina
1100-331	Phosphorescent
1190-1-88	Silver Glitter
1190-3-88	Gold Glitter

Metallic Colors

1179	Silver
1187	OP. Rich G/S Gold
1188	OP. Pale R/S Gold

Shimmer Sparkle Colors

1190-25	Ruby Red
1190-40	Emerald Green
1190-51	Aquamarine Blue
1190-53	Ultra Blue
1190-57	Royal Blue
1190-59	Amethyst Purple
1190-70	Gunmetal Black
1190-76	Carat Gold
1190-77	Rich Gold
1190-78	Pale Gold
1190-79	Bright Silver
1190-799	Super Silver
1190-200	Sparkle Bright Coat

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Prices subject to change without notice.

GENERAL DESCRIPTION 1300:

Tri-Puff 1300 series plastisol is formulated for direct printing of athletic and leisure garments to give a raised tri-dimensional effect when cured.

GENERAL DESCRIPTION 1600:

Tri-Suede 1600 series plastisol is formulated for direct printing of athletic and leisure garments to give a raised tri-dimensional effect with a distinctive "suede-like texture" when cured. The final effect is softer than traditional puff effects, and greater elasticity.

STOCK:

For direct prints, knit and woven T-shirts, sweatshirts, jerseys, fleece goods, and bandanna stock may all be used. These inks are also suitable for use on cap printing.

STENCILS:

All types of solvent resistant emulsions are suitable.

SCREEN MESH:

Selection here very much determines the finished 3-D effect or loft achieved on curing. A good ink deposit is necessary, and the popular choice is a 60T mesh, while cap printers prefer an 86T.

CURING:

315° F TO 330° F depending on ink deposit, color and dryer efficiency. Please note that it is necessary to fully cure these inks to achieve maximum durability and abrasion resistance. Since the expanding agent becomes active at 265° F, it is possible to have a nicely expanded effect with little or no strength. This will crack and abrade easily, which is totally undesirable.

WASH-UP:

Tri-sol 25 or equivalent (Mineral Spirits).

MIXING PROCEDURES:

This system is designed to be used as supplied without other additions. The base may be used to reduce color concentration or to make up colors using our Color Concentrates. The Puff Concentrate may be used in other plastisol inks up to fifteen percent (15%) to give raised effects, but care must be taken to check carefully for film strength and abrading.

STORAGE PROCEDURE:

Store at room temperature. Keep away from heat.

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TRI-PUFF

Series 1300/1600

Foam Expanding Plastisol Inks

Tri-Puff: 1300 Series

Standard Pigment Colors

1301 White
1370 Black

Bases & Additives

1300-100 Puff Concentrate
1300-200 Puff Ink Base

Tri-Suede: 1600 Series

Standard Pigment Colors

1601 White
1670 Black

Bases & Additives

1600-100 Suede Puff Concentrate
1600-200 Suede Puff Ink Base

Note: The Puff Bases will accommodate up to 25% of the Plastisol Pigment Concentrates. The Puff Concentrates are used by adding 10-15% by weight for ready-to-use inks. This addition WILL cause the color of the ink to change, and the more used, the more effect it will have on the color. Special colors can be made in five gallon minimum lots at no extra charge for color matching.

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GENERAL DESCRIPTION:

Series 1400 Thermo-Peel plastisol is formulated for the manufacture of hot-peel transfers. This series can be directly printed on suitable stock as well. Transfers can be made for use on dark garments using the standard colors or the 1400-1300 puff opaque base under the Process colors.

STOCK:

Papers specifically designed for hot-splitting give optimum results, but all types can be used successfully. Uncoated papers can be made to give the "total" transferability of the coated types by utilizing our 1400-200 Transfer Clear Base as a first coat before all other colors are applied.

For direct prints, knit and woven T-shirts, sweatshirts, jerseys, fleece goods, and bandanna stock may all be used.

STENCILS:

All types of solvent resistant emulsions are suitable.

SCREEN MESH:

For Transfer Printing, 196T monofilament is used for the Clear Base, 110T to 196T for the standard colors. Process colors are printed using 305T monofilament mesh. Puff Clear base used for highlighting and opaque transfers are printed using 110T mesh, and 25T mesh used for Glitter effects.

TRANSFER PRINTING:

For best results, transfers should not be overcured at the partial curing stage, nor excessive heat used during transfer. The ink films should be 'set' at 200°F for most transfer papers, and the conditions of transfer at a temperature of 350°F, dwell time 10 seconds at 40 PSI.

The use of Pneumatic Transfer Machines are recommended for pressure adjustment where puff effects are utilized, or the use of a 'soft' transfer bed, using several layers of fabric.

It is essential to understand that transfers must be printed in reverse for both text and color effects. For example the 4-color transfer with puff highlights is made in the following print sequence:

1. Clear transfer coat directly on the paper stock
2. Process colors in reverse order - cyan, magenta, then yellow.
3. Black for highlights, followed by puff opaque base.

continued...

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The production of Opaque Transfers can be effected by the addition of a puff base or white basecoat to a standard transfer, and if this is done using a coated transfer paper (either pre-coated or printed with the 1400-200 clear coat), the opacity will be further enhanced. The Standard and Pastel colors are all opaque colors, but even the transparent colors have been used successfully here, since the last coat on the transfer is used to provide the opacifier - in the case of the puff basecoats - the transfer actually lifts from the dark background. Where such a base coat is undesirable, the opaque colors will need to be printed with 110T mesh at the very least. Very heavy deposits using meshes as coarse as 33T, will give a suede-like finish when hot split on stock similar to 55# Soft Trans paper.

Please note the following hints for Hot-Split results:

- a. PEEL IMMEDIATELY upon lifting the platen of machine.
- b. DO NOT DRAG transfer paper across garment, but pull in one direction in a fast, even motion.
- c. DO NOT TOUCH or rub before removing transfer paper. This will cause cooling and can cause holes or blemishes in the transfer.
- d. Hot Splitting evenly depends on the ink coating retaining heat while being pulled. Dwell time must be sufficient to allow time to peel the transfer, but platen pressure as well as dwell time should not be so excessive as to drive the ink too much into the fabric. Pressure should be sufficient only to ensure good contact for adhesion.
- e. Where a coated paper or our Clear coat 1400-200 is used, this coating splits, allowing total transfer of subsequent colors. Image design with glitter effects must allow the glitter coating to be printed directly on the clear coats or transparent colors (Process) only.

CURING:

These inks are designed for adequate cure during a transfer cycle of 350° to 375°F for 7 to 10 seconds. When used as direct printing inks, 315°F to 330°F depending on ink deposit, color and dryer efficiency.

WASH-UP:

Tri-sol 25 or equivalent (Mineral Spirits).

STORAGE:

Store at room temperature. Do not allow to be heated above 85°F.

Color Availability:

This series is available in limited colors as indicated on the following chart. Special colors can be made to a five-gallon minimum order. There are no extra charges incurred in this service.

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Standard Pigment Colors

1400-03	White
1400-13	Chrome Yellow
1400-16	Lemon Yellow
1400-17	Gold Yellow
1400-18	Dolphin Orange
1400-22	Scarlet
1400-25	Bright Red
1400-28	Cardinal
1400-42	Kelly Green
1400-53	Ultra Blue
1400-54	Navy Blue
1400-57	Royal Blue
1400-59	Purple
1400-60	Tan
1400-66	Dark Brown
1400-70	Black
1400-92	Fuschia

Process Colors

1400-110	Process Yellow
1400-120	Process Rubine
1400-122	Process Magenta
1400-150	Process Blue
1400-152	Process Reflex Blue
1400-170	Process Black

Glitter Colors

1400-1-48	Silver
1400-3-48	Gold

Metallic Colors

1400-77	Rich Gold
1400-78	Pale Gold
1400-79	Silver

Bases & Additives

1400-103	Opaque Ink Base
1400-200	Trans. Clear Base
1400-1300	Trans. Puff Clear Base
1400-1301	White Puff
1400-1320	Ploy-A Transfer Paste

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FIRE RETARDANT PLASTISOL INKS

Series FRP

GENERAL DESCRIPTION:

FRP Fire Retardant Plastisols contain active efficient fire retardant additives for the printing and decorating of fabrics treated for fire retardance.

STOCK:

These MUST be Fire/flame retardant fabrics usually employed in the production of sleepwear.

STENCILS:

All types of solvent resistant emulsions are suitable.

SCREEN MESH:

A 110T monofilament is the popular choice, but finer meshes up to 196T monofilament or equivalent may be used.

CURING:

315°F TO 330°F depending on ink deposit, color and dryer efficiency.

WASH-UP:

Tri-sol 25 or equivalent (Mineral Spirits).

CAUTION:

Due to the lack of a single standard test, all fabrics must be pre-tested for retention of fire-retardancy properties after printing and complete curing of ink film, in compliance with your Fire/Flame Retardance Specification. If used on fabrics not treated for fire/flame retardance, the ink properties will be adversely affected.

STORAGE PROCEDURE:

Store at room temperature. Keep away from heat.

COLOR AVAILABILITY:

This Series is stocked in White, Black and Clear Base. Standard colors (1100 Series range) are available in one-gallon minimum. Color matches are available in five-gallon minimum per color. Please call for availability and prices.

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GENERAL DESCRIPTION:

Sta-True 1700 series plastisol is formulated for printing on polyester and 50/50 polyester/cotton blends for minimal bleed where normal plastisol films would be discolored due to the fabric dyes bleeding into the screen printed film.

STOCK:

Polyester and 50/50 polyester/cotton blends.

STENCILS:

All types of solvent resistant emulsions are suitable.

SCREEN MESH:

110T monofilament is the popular choice, printers may also employ the use of mesh sizes 60T to 160T monofilament or equivalent.

CURING:

315°F to 330°F depending on ink deposit, color and dryer efficiency.

WASH-UP:

Tri-sol 25 or equivalent (Mineral Spirits).

MIXING PROCEDURES:

Stir well before using. For best results, do not add any reducers or additives to these inks.

CAUTION:

It is necessary to pre-test all fabrics prior to production, due to the various dye application methods. Ink films must be cured properly to give good wash resistance and in some cases to prevent 'post-bleed' due to dye solubility. There is a tendency to under cure ink films to prevent dye migration due to heat, but this will only result in other problems. Some fabrics may need to be pre-heated to "set" the dyes—this is not altogether desirable, but will produce a more thorough cure due to moisture removal as well.

STORAGE PROCEDURE:

Store at room temperature. Keep away from heat.

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Standard Pigment Colors

1701	Phoenix White
1702	Blizzard White
1705	Glacier White
1706	Excel White
1708	Economy White
1713	L.B. Chrome Yellow
1716	L.B. Lemon Yellow
1717	L.B. Gold
1718	L.B. Dolphin Orange
1722	L.B. Scarlet
1726	L.B. Flag Red
1751	L.B. Light Blue
1757	L.B. Royal
1758	L.B. Turquoise
1700-50	Reducer/Concentrate

Note: Special colors can be made in this series to a five-gallon per color order at no extra color matching charge.

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General Description:

Series 900 plastisol inks are formulated to provide in-house color blending to popular color references. These inks are intermixable and are completely curable. Where matches to fabric colors, or to bright and intense color swatches are required, Fluorescent colors are provided for intermixing. The Color range consists of two systems which are indicated on the accompanying chart. The 900-2 system formulas give superb opacity and hold-out properties.

Stock:

Direct prints, knit and woven T-shirts, sweatshirts, jerseys, fleece goods, and bandanna stock.

Stencils:

All types of solvent resistant emulsions are suitable.

Screen Mesh:

Monofilament fabrics are recommended. The 900-2 series is intended for mesh sizes 86T to 196T. The 900-3 Soft Touch version is intended for mesh sizes up to 305T. Our 1180-51 Reducer/Detackifier can be used to modify consistency as needed.

Curing:

315°F TO 330°F depending on ink deposit, color and dryer efficiency.

Wash-Up:

Tri-sol 25 or equivalent (Mineral Spirits).

Color Formulas:

Starting formulas to color references or supplied samples (wet or dry), may be obtained from our Technical Service by telephone or telefax. A Color Formula Guide is also provided.

Colors outside of the Formulation guide are subject to predictions which will be based on our in-house Color Computer Matching system, especially where it is necessary to have an immediate starting formula.

Storage:

These inks must be stored under the same precautions of standard plastisol inks. Exposure to heat above 80°F will be detrimental to ink consistency.

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TRIANGLE MATCHING SYSTEM

Series 900

Color Mixing Ink System

Standard Colors

900-201	White
900-210	Yellow
900-222	Scarlet
900-225	Red
900-240	Green
900-251	Blue #1 G/S
900-252	Blue #2 R/S
900-253	Marine
900-259	Violet
900-270	Black

Soft-Touch 3 Colors

900-301	White
900-310	Yellow
900-322	Scarlet
900-325	Red
900-340	Green
900-351	Blue #1 G/S
900-352	Blue #2 R/S
900-353	Marine
900-359	Violet
900-370	Black

Fluorescent Color*

900-3310	Fluorescent Lemon
900-3316	Fluorescent Yellow
900-3318	Fluorescent Orange
900-3320	Fluorescent Red
900-3330	Fluorescent Pink
900-3340	Fluorescent Green
900-3350	Fluorescent Blue
900-3390	Fluorescent Magenta
900-3394	Fluorescent Purple

*Fluorescent colors are interchangeable between the 900-2 and 900-3 Systems.

Note: These colors are ready-for-use. They can be printed directly on fabrics, or intermixed to achieve various PMS colors. Please refer to the TMS Guide for mixing instruction.

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Please note that all colors are free of lead/heavy metal pigments.
Volume Discounts are available, as well as Custom Matching Services.
Prices subject to change without notice.

E.O.B. Wallington, N.J.

GENERAL DESCRIPTION:

These Color Concentrates have been formulated to provide suitable color dispersions compatible with all of our Plastisol Ink Series. They can be utilized to alter the shades of existing colors, or to create new colors from scratch when incorporated into any of our extensive ink bases.

Color Matching Hints:

In general, it is preferable to work with a "let-down" version of the concentrates to give greater control over color changes. Standard pigment colors marked with an asterisk will give a fairly close match to the PMS basic colors when a five (5%) percent mixture is made using a clear base (e.g. 1100-106) and printed on to white grounds using a 325T mesh.

It is important to recognize that our color perception is influenced by the background color as well as the absorption of the fabric. This often makes it mandatory that the actual fabric grounds be used for the color match and the mesh size to be taken into account. Small amounts of fluorescent colors are often necessary to brighten colors matched to fabric samples.

In most cases, colors are achieved using far less than the maximum amount of concentrate, ten percent (10%) on ink total. Characteristically weak colors such as Ultra Blue however, may need to exceed the recommended concentration and some curing properties have been built into the toner. It is necessary in any case, where the total percentage of color concentrates exceeds the recommended maximum percentage, to check for thorough curing and lack of color rub-off (crock-fastness.)

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Standard Pigment Color Concentrates for Plastisol

DW 838	Extra White
DW 839	White
DH 658	Buff Opaque Base
DY 817	Yellow R/S
DY 836	Yellow G/S
DY 843	Process Yellow
DO 835	Orange Y/S
DO 837	Perm. Orange R/S
DR 820	Perm. Red Y/S
DR 821	Perm. Red B/S
DR 832	Scarlet
DR 840	Perm. Rhodamine
DR 844	Rubine Red
DR 845	Red B/S
DM 829	Maroon
DP 841	Violet
DG 825	Green
DB 826	Phthalo Blue G/S
DB 827	Milori Blue
DB 828	Ultra Blue
DB 831	Phthalo Blue R/S
DN 824	Black

Fluorescent Color Concentrates for Plastisol

FDY 205	Fluorescent Yellow
FDO 206	Fluorescent Orange Y/S
FDO 207	Fluorescent Orange R/S
FDR 208	Fluorescent Orange-Red
FDR 209	Fluorescent Red
FDP 199	Fluorescent Pink B/S
FDP 213	Fluorescent Pink Y/S
FDR 210	Fluorescent Rose
FDM 200	Fluorescent Magenta Y/S
FDM 203	Fluorescent Magenta B/S
FDV 214	Fluorescent Deep Violet
FDB 198	Fluorescent Blue
FDG 211	Fluorescent Green

Bases & Additives

1100-046	OP Base
1100-106	Soft Touch Base
1180-325	Soft Hand Base
1180-51	Reducer/Detack
1180-200	Glitter/Metallic Base

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Crystalina Iridescent Colors:

Similar in characteristics to Metallic Glitter colors, these products utilize iridescent flakes. these products are available in red, blue and fluorescent varieties as well as the standard green shade.

Glow-in-the-Dark/Phosphorescent Colors:

These products absorb light energy and glow when the light source is removed. Popular standard is a light yellow/green(1100-331) also available in standard fluorescent colors.

Foil Adhesive Bases:

The 1100-797 facilitates the transfer of foil films to most fabrics. This provides durable means of foil and metallic enhancement to printed garments.

Flock Adhesive Bases:

Our 1100-4090 Product is offered for use with flock transfer papers.

High Elongation Inks:

Our STRC products offer high stretch properties for use with Lycra™ and similar fabrics. When properly cured the white ink can be used as a stretch base for use with standard plastisol products.

Standard products are White, Black and Base for use with Color Concentrates.

High Density Matte Inks:

These products provide high definition coats in use with thick stencils.

Rapid curing with a matte effect is used to provide the contrast necessary for this definitive effect. Offered in White, Black and Base for use with Color Concentrates.

Nylon Mesh Inks:

These are high adhesion products offered for use on Nylon mesh fabrics.

Formulation characteristics facilitate reduced after-tack and ease of printing, yet excellent bonding properties. Offered in White, Black and Base as well as Metallic Silver and Gold.

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Vinyl Beads/Glitter Adhesive Base:

This product (1100-706) is utilized to create the popular "Caviar Bead" effect. It is applied in a liberal coat and dusted with vinyl beads and/or glitter flakes, spangles etc. Cures to a high degree of bonding with both flakes and garment for durable wear.

Outdoor Banner Inks:

These products have been formulated for extreme weather resistance properties when used to produce decorative or informative banners. The use of high performance Pigment selection and low migratory coating and formulation expects to achieve quite extensive outdoor durability with recommended curing. Color availability on request, many popular standard colors in series.

Shimmer Sparkle Colors:

These are metallic colors formulated to give brilliant sparkle effects using conventional mesh sizes. Although an undercoat must be used, the use of the Sparkle Brite coat is highly recommended, to achieve the best effect. When used on 100% cotton goods as an undercoat for standard plastisol colors, the Sparkle Brite Coat reduces the defective washed out effect (lining.)

Glitter Colors:

In addition to the Silver and Gold Standard colors, these are offered in many popular color variations. Color requests are available with a five-gallon minimum. Prices do vary and will be quoted by order.

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N-Series Nylon Mesh Inks:

N-1001 White
N-1070 Black
N-10873 Gold
N-10877 Silver
N-1000-100 Base

H-D Series High Density Matte Finish:

HD-601 White
HD-670 Black
HD-600-200 Base

STRC Series High Elongation Inks:

STRC-001 White
STRC-070 Black
STRC-100 Base

NOTE: Special colors can be made in any of these Ink Series to five-gallon minimum per color order at no extra charge.

Miscellaneous Products:

1100-797 Foil Adhesive Base
1100-813 Coning Adhesive Base
1100-4090 Flock Transfer Adhesive Base
1100-706 Bead (Caviar) Adhesive Base
1100-809 High Clarity Clear Coat

WARNING: FOR INDUSTRIAL USE ONLY KEEP AWAY FROM CHILDREN

NOTE: Please note that all colors are made without the use of lead or heavy metal pigments. The information on this data sheet is based on laboratory tests and production experience. Directions and procedures for use of Triangle-Ink products must be considered as recommendations only. The printer is solely responsible for determining suitability of any Triangle product for a specific application. We recommend that all products be pre-tested prior to production. No warranties are implied or expressed.



TRI-BOND

Series 1180-66

Plastisol Additive

General Description:

1180-66 Tri-Bond Plastisol Additive is used as an additive to Tri-Flex Plastisol inks for printing on nylon shell.

Stock:

All nylon shell fabrics. Since manufacturers use various sizing and water repellent treatments, it is recommended that the fabric is pre-tested with this system prior to production.

Screen Mesh:

110T monofilament or equivalent.

Mixing Procedures:

Add 10-15% (by weight) of 1180-66 Tri-Bond Plastisol Additive to unmodified Tri-Flex Plastisol inks.

MIX THOROUGHLY.

Pot life for mixtures of Tri-Bond Plastisol Additive and Tri-Flex Plastisol Inks is only 4-6 hours, therefore, mix only sufficient quantity for this printing time. The mixed plastisol will gel overnight, but can not be re-used.

Under high humidity conditions, pot life will be reduced.

Keep unused Tri-Bond Plastisol Additive in tightly sealed containers.

Curing:

1 1/2 to 2 minutes at 315°F to 330°F, depending on efficiency of curing unit.

Wash-Up:

Clean screen with Tri-sol 25 or equivalent (Mineral Spirits).

Caution:

Use with adequate ventilation, protective clothing, gloves, and eye goggles. Avoid contact with skin and eyes.

See Material Safety Data Sheet for detailed information.

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