

FEATURES

- Formulated to provide simulations of the PANTONE® Color Standards for light colored textile fabrics.
- High Performance, Low Bleed (LB) plastisol formulated for Ultra High speed automatic printing.
- Very creamy and short bodied, with low tack and for ease of printing, a greatly improved shear.
- Well suited for high definition and resolution, fine detail and halftone printing.
- Faster production speeds with less pressure, and can be printed through finer mesh counts.

UltraMix® 7400 LF* COLORS

- | | |
|--------------------|--------------------|
| 7402LF Yellow (GS) | 7418LF Green |
| 7404LF Yellow (RS) | 7420LF Brown |
| 7406LF Orange | 7424LF FL. Magenta |
| 7408LF Red (BS) | 7426LF FL. Violet |
| 7410LF Purple | 7428LF FL. Green |
| 7412LF Violet | 7401LF White |
| 7414LF Blue (RS) | 7422LF Black |
| 7416LF Blue (GS) | |

*LF (Lead Free) Contains less than 0.025% lead.

Application & Storage Information	
RECOMMENDED FABRICS	Light colored 100% cotton or cotton/polyester blends. Use an underbase for printing dark fabrics.
INK APPLICATION	Colors should be printed without any modifications. If thinning is required, use 1099LF LB Lo-Bleed Reducer (1% to 5% by volume).
SCREEN MESH AND EMULSION	110 to 305 t/in 43 to 120 t/cm Monofilament Any direct or indirect lacquer resistant emulsion. Use 35 to 70 micron capillary film for best results.
SQUEEGEE	60-70 Durometer: Sharp Edge 60-90-60 or 70-90-70 Triple Durometer: Sharp Edge
CURE TEMPERATURE	325° (163°C) Entire ink film. Test dryer temperatures and wash test printed product before and during a production run.
CLEAN-UP	Mineral Spirits or any environmentally friendly plastisol screen wash.
PRODUCT PACKAGING	1 Gallon, 5 Gallon, or 30 Gallon Containers.
STORAGE OF INK CONTAINERS	Recommend storage at 65°F to 90°F (18°C to 32°C). Avoid storage in direct sunlight. Keep containers well sealed.
PRODUCT MSDS	Refer to material safety data sheet MSDS8.

SPOT FLASHING

The UltraMix® 7400 inks will spot dry, with very low after flash tack, in 3 to 8 seconds depending on the spot dryer used. Too much heat / time may cause the ink to become sticky after flashing. Adjust flash unit accordingly. When spot drying, the ink should be just dry to the touch, with no lift off, but not totally fused. Totally fusing any of the flashed colors may cause inter-coat adhesion problems with the inks printed on top of the flashed ink. Final curing / fusing will occur in the dryer.

IMPORTANT INFORMATION

1. In order to achieve the best color matching results using the UltraMix® 7400 Color System, the specified system primaries must be used. Using colors other than the specified primaries will produce inaccurate matching results.
2. Use 7401LF Mixing White in all formulas calling for white. Use 7422LF Black as the mixing black in all formulas calling for black. Using any other white or black will produce inaccurate results.
3. Use an underbase print when printing UltraMix® 7400 inks onto dark fabrics. Use 771LF, 774LF, 7031LF or 7034LF white as an underbase ink. To achieve a softer hand and faster production speeds, print underbase ink through finer mesh counts 230 to 305 t/in or 90 to 120 t/cm.
4. The UltraMix® 7400 inks are low bleed inks, not non-bleed inks. On some types of fabric, bleeding or dye migration may occur. Always test print the fabric to be printed before beginning production. Bleeding or dye migration may not occur right away.
5. Excessive squeegee pressure will drive the UltraMix® 7400 inks through the fabric being printed. Adjust squeegee pressure, angle and off-contact to insure proper shear and lay down of printed ink. Proper settings of squeegee, flood bar and off-contact will improve performance, improve screen life and squeegee durability.
6. Adding too much reducer or other additives to the UltraMix® 7400 inks may cause curing/fusing or increased dye migration problems.
7. UltraMix® 7400 inks are easy to print when compared to other inks and can be printed through finer mesh counts. This means less ink usage and faster production times, a real money saver. Using finer mesh counts also means a softer hand of the finished product.

Recommendations and statements made are based on International Coatings' research and experience. Since International Coatings does not have any control over the conditions of use or storage of the product sold, International Coatings cannot guarantee the results obtained through use of its products. All products are sold and samples given without any representation of warranty, expressed or implied, of fitness for any particular purpose or otherwise, and upon condition that the buyer shall determine the suitability of the product for its own purpose. This applies also where rights of third parties are involved. It does not release the user from the obligation to test the suitability of the product for the intended purpose and application. All trademarks noted herein are either the property of International Coatings, Pantone, Inc. or their respective companies. REV090904

UltraMix® 7400 COLOR SYSTEM