

**FEATURES**

- Opaque simulations of PANTONE® colors for dark fabric printing.
- Consists of 9 HP (high pigment), RFU (ready for use) primary colors which are LB (low bleed), low fusing and fast flashing.
- No bleaching agents and very low odor.

**800 SERIES OPAQUE LF\* COLORS**

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|-------------------|--------------------|
| 842LF Yellow      | 848LF Process Blue |
| 843LF Warm Red    | 849LF Green        |
| 844LF Rubine      | 851LF Violet       |
| 845LF Rhodamine   | 711LF HP White     |
| 846LF Purple      | 714LF HP White     |
| 847LF Reflex Blue | 716LF Black        |

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

**Application & Storage Information**

<b>RECOMMENDED FABRICS</b>	100% cotton, cotton/polyester blends and some 100% polyester. Always test print for adhesion and possible bleeding or dye migration.
<b>INK APPLICATION</b>	The 800 Series inks should be used right from the container (RFU) without any modifications when printing on dark fabrics. To produce a more matte finish, use 3% to 20% (by volume) of 820LF Flattener Additive. If thinning is required, use 1% to 10% (by volume) of 1099LF Low Bleed Curable Reducer. Using any other reducers or additives may lower the bleed resistance and or opacity of the ink. Adding too much reducer or additive will cause loss of opacity.
<b>SCREEN MESH AND EMULSION</b>	60-305 t/in or 24-120 t/cm Monofilament. Any direct or indirect lacquer proof emulsion. Use 35 to 70 micron capillary film for best results. 160-230 t/in or 63-90 t/cm Monofilament for under printing.
<b>SQUEEGEE</b>	60-90-60 or 70-90-70 Triple Durometer
<b>CURE TEMPERATURES</b>	285°F to 325°F (141°C to 163°C) entire ink film. <b>NOTE:</b> When curing/fusing at lower temperatures, a longer retention time will be required for the entire ink film to reach the prescribed temperature. Wash test product before and during a production run .
<b>CLEAN-UP</b>	Mineral spirits or any environmentally friendly plastisol screen wash.
<b>PRODUCT PACKAGING</b>	1 Gallon, 5 Gallon, or 30 Gallon Containers.
<b>STORAGE OF INK CONTAINERS</b>	Recommend storage at 65°F to 90°F (18°C to 32°C). Avoid storage in direct sunlight and moist, humid air. Always use oldest catalyst first and tightly seal containers after use.
<b>PRODUCT MSDS</b>	Refer to material safety data sheet MSDS8.

**IMPORTANT INFORMATION**

1. Do not attempt to mix the 800 Series inks by the formulas in the PANTONE® Color Formula Guide Book. To mix opaque simulations of PANTONE® colors with the 800 Series inks you *must* use the color formulas provided in the International Coatings Formulation Guide supplied with the 800 System.
2. When printing on light colored fabric, the finished color can be extended with 720LF Clear Base. To maintain best bleed resistance on dark fabrics, use 199LF LB Clear. Colors can be extended with either clear base up to 500/0 depending on the opacity or intensity of color desired. For a softer hand use a combination of 720LF or 199LF Clear and 710LF Softand Additive. The use of 710LF may lower bleed resistance.
3. Though adequate opacity on dark fabrics may be achieved by printing these colors, without modifications, through an 86 to 110 mesh screen, a more satisfactory method for wet-on-wet printing is to first print an underbase of either 714LF White, 711LF White, or 199LF First Coat Clear through a 160 to 305 mesh screen. Flash cure the underbase print and then print the following colors through 160 to 305 mesh screens. This technique helps to insure a softer hand, speeds up production, and allows for greater detail.
4. Use either 711LF White or 714LF white as the mixing white in all formulas calling for white in the International Coatings Formulation Guide.
5. The 800 Series inks will spot dry, with low after flash tack, in 2 to 8 seconds depending on the spot dryer used. In some cases, the heat setting of the spot cure unit may have to be lowered because excessive heat may actually make the ink tacky. Spot drying or flashing should only gel the surface of the ink. The ink should just be dry to the touch, with no color lift off, but not totally fused. Totally fusing any color used as a underbase print may cause inner-coat adhesion problems between printed colors. Final fusing or curing will occur in the dryer.
6. All mixed colors were viewed and approved under cool white fluorescent lighting and may appear metameric (not match well) when viewed under a different light source.

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**800 SERIES OPAQUE COLOR SYSTEM**