

**FEATURES**

- Simulates PANTONE® colors for light and dark nylon fabrics.
- Fast flashing, 2-part plastisol for printing onto normally hard to print nylon.
- Well suited for fine detail and halftone printing.

**UltraMix® 9000 LF\* COLORS**

9202LF Yellow (GS)	9212LF Violet	9224LF FL. Magenta
9204LF Yellow (RS)	9214LF Blue (RS)	9226LF FL. Violet
9206LF Orange	9216LF Blue (GS)	9228LF FL. Green
9208LF Red (BS)	9218LF Green	9201LF White
9210LF Purple	9220LF Brown	9222LF Black

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

**Application & Storage Information**

<b>RECOMMENDED FABRICS</b>	Nylon, cotton and some polyester or cotton/polyester blends. Always test print for adhesion and possible bleeding or dye migration.
<b>INK APPLICATION</b>	Color system must be mixed with 900LF Catalyst (available in 2 oz. And 8 oz. containers) for best adhesion to nylon. Ink may be used immediately after mixing. Pot life of catalyzed ink is 4 to 8 hours. It should be hand stirred in the following proportions: By Volume: 16 Parts Ink to 1 Part 900LF Catalyst By Weight: 20 Parts Ink to 1 Part 900LF Catalyst
<b>SCREEN MESH AND EMULSION</b>	110 to 305 t/in or 43 to 120 t/cm Monofilament Any direct or indirect lacquer resistant emulsion. Use 20 to 30 micron capillary film and retensionable frames at 20 to 40 Newtons.
<b>SQUEEGEE</b>	65-70 Durometer: Sharp Edge 60-90-60 or 70-90-70 Triple Durometer: Sharp Edge
<b>CURE TEMPERATURES</b>	285°F to 325°F (141°C to 163°C). <u>NOTE:</u> 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>	Quart, 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.

**MODIFYING INK**

If necessary, ink may be thinned, by volume, with 1% to 3% Mineral Spirits or 1% to 5% 1110LF Curable Reducer. It is important not to use reducers that are 100% plasticizer, because they may create adhesion problems and make the finished ink film less durable.

**SPOT FLASHING**

For multi-color printing on nylon, especially shell nylon, it is important to pre-heat the nylon fabric in order to help control fabric shrinkage. On most nylon fabrics, spot flashing between colors is critical. The 9000 Series inks will spot dry, with 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 and the fabric to shrink too much. 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 9000 UltraMix® Nylon Color System, the specified primary colors for the system must be used. Using other than the specified primaries will produce inaccurate matching results. All of the 9000 Series primary colors may be printed as is, with 900LF Catalyst, or inter-mixed as necessary.
2. The 9000 UltraMix® inks are not low 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.
3. 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 print performance, screen life and squeegee durability.
4. Adding too much reducer or other additives to the 9000 UltraMix® inks may cause curing/fusing, adhesion or increased dye migration problems.

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**UltraMix® 9000 NYLON COLOR SYSTEM**