

FEATURES

- Produce special 3-D, heavy deposit, smooth matte finish prints.
- Prints through thick stencils.
- Unique flash time will increase production and speed dwell time in the dryer.
- Extremely sharp edges can be produced.

HD DIMENSIONAL LF* COLORS

- 141LF HD Clear 143LF HD White
- 142LF HD Base 144LF HD Black

Colors may be created using Pigment Concentrates or Color Boosters. Standard formulas may need adjusting to create darker colors.

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

Application & Storage Information

RECOMMENDED FABRICS	100% cotton and some cotton/polyester blends. Pre-print and test all fabrics for dye migration, ink adhesion, wash fastness and other desired properties before beginning any production.
INK MODIFIERS	Not Recommended
SCREEN MESH	Ink-deposit thickness will be determined by thread size and stencil thickness. For most heavy-deposit screens use a mesh count in the 60 to 110 t/in or 24 to 43 t/cm range. Follow manufacturer's recommended tension for mesh used.
EMULSION	Direct/indirect capillary films should be used. For best results choose a thickness between 200 and 400 microns. Stencil films purchased at required thickness levels allow for better control of ink deposit. Exposure times should be calculated for best results.
SQUEEGEE	70-80 Durometer
CURE TEMPERATURE	325°F (163°C). The efficiency of the oven and length of heat tunnel will determine oven dwell time. Dwell time should be increased with a thick ink deposit. Failure to fuse ink properly may cause cracking poor adhesion and poor wash fastness.
CLEAN-UP	Mineral Spirits or any environmentally friendly plastisol screen wash.
PRODUCT PACKAGING	1 Gallon, 5 Gallon, or 30 Gallon Containers.
STORAGE OF INK	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.

PRINTING TECHNIQUES

Set up the screens as with any print, making sure there is plenty of free mesh around the design. Choose the proper squeegee length and stroke distance for the design dimensions. Select a squeegee of 70-80 durometer. More control can be achieved using double and triple-ply blades. Angle the squeegee to increase deposit. The floodbar should be adjusted to provide maximum stencil loading. When the screen is flooded properly, it will take less effort for the squeegee to transfer the ink.

Use an off contact or peel setting to release ink from the stencil. Off-contact is a critical adjustment. If it is not high enough, the ink will not release from the screen. Set the print and flood speed to the slowest setting; then increase the speed, as the design permits. Apply minimal squeegee pressure; only enough to transfer the ink. Too much pressure will push the ink into the fabric. The idea is to lay the ink on the surface. For maximum height, flash the print and stack on another layer. Depending on the thickness of the first print, additional prints may require increase in off contact. By layering the print, image results are better controlled.

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HD DIMENSIONAL INK