

**FEATURES**

- 3818\* PF Senti Curable Reducer can be used as a viscosity modifier or as a soft-hand additive.
- Offers much improved hand over other viscosity-modifying products.
- Extends the yield when used as an additive which may reduce production costs.
- 3818 Senti Reducer is a phthalate free (PF) product.

\*Lead Compliant (Contains less than 90 ppm lead)

**Application & Storage Information**

RECOMMENDED FABRICS	100% cotton and some light colored cotton/polyester blends and 100% polyester. Always check for possible dye migration when printing fabrics that contain polyester fibers. Always test print fabric before beginning a production run.
INK APPLICATION	3818 is a curable reducer and can be added to 700 Series, Multipurpose, 1100 Series, 7400 Series, 7400CC, 7500 Series, 7600 Series and 800 Series inks as a viscosity modifier or a soft hand additive. Mix with opaque colors to reduce cost and opacity.
SCREEN MESH AND EMULSION	60-230 t/in or 24-90 t/cm Monofilament Any direct or indirect solvent resistant emulsion.
SQUEEGEE	65-70 Durometer: Sharp Edge 60-90-60 or 70-90-70 Triple Durometer: Sharp Edge
CURE TEMPERATURES	325°F (163°C) entire ink film. Fusion temperature may vary, depending into which inks 3818 Senti Reducer is mixed. Since plastisols do not air dry, they must be fused with an appropriate heat source in order to achieve durability. The optimum time/temperature cycle will vary with the amount of ink deposited, fabric and the type of heat source used. Test dryer temperatures and wash test printed product before and during a production run.
CLEAN-UP	Environmentally friendly plastisol screen wash or mineral spirits.
PRODUCT PACKAGING	5 Gallon Pails, 30 or 50 Gallon Fiber Drums
STORAGE OF INK CONTAINERS	Keep inks indoors and store in a cool area. Recommend storage at 65° F to 90°F (18°C to 32°C). Avoid storage in direct sunlight or under extreme temperature conditions
PRODUCT MSDS	Refer to material safety data sheet 3818-MSDS8.

**SPOT FLASHING**

This product will spot dry with a very low after flash tack in 2 to 8 seconds depending on the spot dryer used. In some cases, you may have to lower the heat of the spot cure unit because too much heat may actually make the ink tacky. When you spot dry, you are only partially fusing or gelling the surface of the ink. The ink should be just dry to the touch, with no lift off, but not totally fused. Totally fusing the underprint white may cause inter-coat adhesion problems with the inks printed on top of the white ink. Final fusing or curing should occur in the dryer.

**IMPORTANT INFORMATION**

1. For a softer hand add approximately 10% to 20%, by weight, of 3818 Senti Reducer. More may be added if necessary, without affecting the cure of the mixed ink.
2. The use of 3818 Senti Reducer may make the mixed ink less opaque or lighten the color depending on the amount of 3818 used.
3. 3818 Senti Reducer is not a low bleed plastisol and is not recommended for use on poly/cotton or 100% poly fabrics that may be prone to dye migration.

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3818 PF SENTRI REDUCER