



# HIGH DENSITY (HD) INKS



## RECOMMENDED FABRICS

100% Cotton  
Cotton/Polyester Blends  
Some polyester



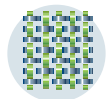
## INK APPLICATION

HD Base and HD White should be used right from the container without any modifications



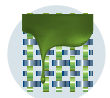
## ADDITIVES

Not recommended



## SCREEN MESH

60-110 t/in (24-43t/cm) 110-230 t/in (43-90 t/cm) monofilament recommended



## EMULSION

Any direct or indirect capillary film between 200 to 400 microns. Thicker stencils allow for better control of ink deposit.



## SQUEEGEE

70-80 Durometer  
Soft edge



## CURE TEMPERATURES

325°F (163°C). The efficiency of the oven and length of heat tunnel will determine dwell time. Dwell time should increase with a thick deposit.



## CLEAN-UP

Any eco-friendly plastisol type screen wash



## PRODUCT PACKAGING

Quart, 1 gallon, 5 gallon, 30 gallon or 50 gallon containers



## STORAGE OF INK CONTAINERS

65° to 90°F (18°C to 32°C). Avoid storage in direct sunlight. Keep containers well sealed



## SDS

Refer to SDS prior to use

## FEATURES

- **High Density (HD) Base 1841**
- **High Density (HD) White 1843**

AXEON™ HD Base 1841 and HD White 1843 produce special 3-D, heavy deposit, smooth finished prints. The ink is designed to produce extremely sharp edges and prints through thick stencils to create dimensional effects.

## SPOT FLASHING

This product will spot dry, with a very low after flash tack. Dwell time is dependent 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 may cause inter-coat adhesion problems with the inks printed on top. Final fusing or curing will occur in the dryer. Failure to fuse ink properly may cause cracking, poor adhesion and poor wash fastness.

## 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.

## IMPORTANT INFORMATION

Always test print the fabric to be used before beginning production to see if the desired performance is obtained.

Test dryer temperatures and wash test printed product before and during a production run.

This ink and those in the AXEON™ product line are not formulated with PVC resins or phthalate plasticizers, nor are they intentionally added.

**Care should be taken to not cross contaminate the AXEON™ products with PVC or phthalate containing products.**

**Do not use standard plastisol curable reducers with this or any of the AXEON™ products.**

## LEGAL DISCLAIMER

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