



**RECOMMENDED FABRICS**

100% Cotton  
Cotton-Polyester Blends  
Some polyester



**INK APPLICATION**

Stealth Black™ 1246 should be used right from the container without any modifications. Stir well prior to each use.



**ADDITIVES**

Not recommended



**SCREEN MESH**

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



**EMULSION**

Any direct or indirect solvent resistant emulsion or capillary film in the 35 to 70 micron range



**SQUEEGEE**

60-70 Durometer  
Sharp edge.



**CURE TEMPERATURES**

325°F (163°C) for 1 minute.  
Dependent on dryer speed and temperature settings



**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**

AXEON™ Stealth Black™ 1246 is a non-PVC, non-phthalate, high pigment, fast flashing, low tack, high performance acrysol screen printing ink.

Stealth Black™ 1246 provides a deep black color that is very creamy, short bodied and is easy to print on automatic or manual presses.

Stealth Black™ 1246 achieves excellent penetration into fabrics when printing through fine mesh counts.

**SPOT FLASHING**

Stealth Black™ 1246 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.

**IMPORTANT INFORMATION**

Stealth Black™ 1246 is not a color-mixing black ink.

Stealth Black™ 1246 prints so easily that a finer screen mesh can be used to achieve the same opacity as what you would expect from other opaque black inks at lower mesh counts.

Fibrillation can occur when printing on some cotton fabrics, especially when printing through finer mesh counts.

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

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

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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