International Coatings™
Textile Screen Printing Inks

HD DIMENSIONAL PLASTISOL INKS

RECOMMENDED FABRICS
100% Cotton
Some 50/50 Cotton/Polyester Blends

INK APPLICATION
HD Dimensional Inks should be used right from the container without any modifications

ADDITIVES
Not recommended

SCREEN MESH
60-110 t/in (24-43 t/cm) monofilament

EMULSION
Any direct or indirect capillary film in the 200 to 400 micron range

SQUEEGEE
70-80 Durometer
Sharp edge

CURE TEMPERATURES
325ºF (163ºC) for 1 minute dependent on dryer speed and temperature settings

CLEAN-UP
Any eco-friendly plastisol 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

Produce special 3-D, heavy deposit, smooth matte finish prints.

Prints through thick stencils.

Extremely sharp edges can be produced.

Unique flash time will increase production and speed dwell time in the dryer.

COLORS

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

Colors may be created using Color Concentrates using 142 HD Base. Standard UltraMix® formulae may need adjusting to create darker colors.

INK APPLICATION

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

HD Dimensional Inks are not low bleed plastisols and are not recommended for use on poly/cotton or 100% poly fabrics that may be prone to dye migration. Always test print the fabric to be printed before beginning production. Bleeding or dye migration may not occur right away.

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

LEGAL DISCLAIMER

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