



Technical Data Sheet #288

Revised 08/21/08

Wet Ink Tack	Low
After Flash Tack	Low
Printability	Excellent
Surface Appearance	Matte
Opacity/Viscosity	High /Medium
Bleed Resistance	N/A
Gel Point/Flash Time	160°F (71C.) decreases with deposit thickness
Fusion Temperature	320°F (160°C.)
Squeegee Hardness	Medium
Squeegee Blade	Sharp
Squeegee Angle	45°
Squeegee Speed	Fast
Underlay	Not required on 100% Cotton
Emulsion	Direct or Indirect
Mesh Count	86-200 mc in (34-77 mc cm)
Thinner	N/A
Thickener	
Storage	65°F to 95°F(18°C to 35°C) . Avoid direct sun.
Cleanup	Bio-degradable screen washe
MSDS	#1
Color Range	SD0247 SD Natural Base
Substrate Type	Cotton
Substrate Color(s)	Light, Medium, & Dark fabric

Specialty Inks

SD0147 Soft Density Natural Base

Description

Soft Density can be printed through a wide range of mesh counts and thick film emulsions. Soft Density's very short body and mid range viscosity mark it easy to mix, easy to print and easy to create very soft High Density type designs. Extremely precise edge definition is possible, making Soft Density a good choice to reproduce prints that look like they have been die cut.

Features

- Easy to mix and print
- Create thousands of shades by using Color Booster formulas from the M2007 Software (use CB's at no more than 40%).
- Prints through a variety of mesh counts.
- Excellent printability with no viscosity modifications.
- Extremely soft with less hand than most High Density inks.
- Print very thick, die cut type designs.

Application

Print through screen mesh from 86-200 mc in (34-77 mc cm) Soft Density Base will have excellent wash and wear qualities when cured at 320°F (160°C) .

Recommended Printing Techniques

- Examine the flood bar and smooth edges if necessary.
- Adjust the flood bar as close to the screen as possible to fill the mesh with ink.
- Transfer ink to the fabric surface with a light squeegee pass.

Special Recommendations

- **Wash test garment to insure you have good adhesion.**
- Plastisols are THERMOPLASTIC requiring heat for proper curing.
- Wash for a minimum of 5 wash/dry cycles to test for cure.
- Stir plastisols prior to printing.
- Do not dry clean
- Do not use bleach
- Do not iron the printed image.