

Excalibur™

Technologically Superior Ink



550 Series - High Opacity Ink

- Ultra High Opacity When Printing on Dark Colors!
- Print Directly on Dark Fabric with No White Underbase!
- Ideal for use with Machine or Hand Screen Printing

550 Series High Opacity Plastisol Inks are available in a range of popular, ultra high opacity colors for direct screen printing. In most cases, 550 Series High Opacity Plastisol Inks can be screen printed directly onto dark fabrics or garments without using a white underbase! 550 Series Inks have excellent washability and a very soft hand feel when screen printed. These inks are extremely opaque and are designed for screen printing on dark fabric. 550 Series High Opacity Inks are also available in a Phthalate Free version (call for details).

TECHNICAL INFORMATION

Drying: Excalibur Ink will fully heat cure when the entire ink film reaches 310°F (154°C). Light colors may require longer periods to obtain this temperature.

Heat Transfers: See the “Making Cold Peel Heat Transfers” section of our website or our product guide.

Ink Cleanup: Use Enviro Series 2000 Green or Enviro Series TR Blend.

Screen Mesh: For direct printing, a 40-305/inch (16T-122Tcm) mesh may be used. For heat transfers, a 80-125/inch (32T-50Tcm) screen mesh gives the best result.

Ink Modification: For softer hand, limited amounts of 502 Reducer may be used to achieve the desired consistency. Limited amounts of 502 Reducer will duplicate the look and feel of a water based-print. The only minor drawback is that as you increase the amount used, the plastisol loses some stretch and abrasion resistance. Excess amounts may increase curing time. 501 Curable Reducer can be added in any quantity and will soften hand, reduce viscosity and extend ink. Excess amounts may reduce opacity.

Squeegee: Medium Durometer is recommended.

Stencil: All types of stencils may be used for screen printing 550 Series Plastisol Inks.

550 Series Product Information is Continued on Page 2...



INTERNATIONAL ENQUIRIES

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550 SERIES TECHNICAL INFORMATION CONTINUED...

Important Information:

Drying: The amount of time it takes for the ink to reach a curing temperature will depend upon the color and thickness of the ink deposit. Curing is a time and temperature relationship. The longer the time or the higher the temperature or combination of these, the faster the cure. Generally plastisol prints should be cured at temperatures of around 320°F (160°C). Temperature strips are an ideal way of determining the exact temperature of the printed ink film. The absolute test is whether the print will stand repeated washings. An initial test to determine cure is, after curing and cooling, the print should feel dry and firm when rubbed with your thumb. It should be able to stretch and relax without excessive cracking.

Heat Transfers: Prints on heat transfer paper must only be semi-cured, as over-curing may cause adhesion problems in the adhesion step of applying the transfer to the garment or cap. The plastisol ink should be dried so that the transfer may be handled and stacked without removing the ink from the heat transfer paper.

STANDARD COLORS AND BASES

Available Colors and Bases: Lemon Yellow, True Yellow, Light Gold, Gold, Orange, Bright Red, Super Red, Fuschia, Violet, Super Royal, Bright Blue, Light Blue, Turquoise, Bright Dallas Green, Fresh Green, See Excalibur White Inks for a List of 550 Series Whites, 550 Mixing Base



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