

Technical Data Sheet #243

Revised 07/18/08

Wet Ink Tack	Low
After Flash Tack	Low
Printability	Excellent, for fast production
Surface Appearance	Thick ink film = gloss; Thin = matte
Opacity/Viscosity	High / Medium
Bleed Resistance	None
Gel Point/Flash Time	160°F (71°C.)
Fusion Temperature	320°F (160°C)
Squeegee Hardness	70-80 durometer
Squeegee Blade	Sharp
Squeegee Angle	45° to screen mesh
Squeegee Speed	Maximum
White Underlay	MH9600 White for 100% cotton dark
Low Bleed Underlay	ML9240 White for poly/cotton
Print Stroke	Maximum speed, light pressure
Emulsion	Direct, Indirect, Capillary film
Screen Tension	As recommended for mesh
Mesh Count	86-305 mc in (34-120 mc cm)
Extender	NA0839 or M20063
Thinner	NA0005 Plastisol Thinner
Thickener	M00010 Thickener #10 (powder)
Storage	65°F to 95°F (18-35°C). Avoid direct sun.
Cleanup	Bio-degradable screen washes
MSDS	#1
Color Range	See Available Colors
Substrate Type	100% Cotton
Substrate Color(s)	Lights and Darks

Ink Mixing Systems

Description

M2 Ink Mixing System colors are opaque resulting in excellent coverage on dark garments. The tack free formula allows printing through a range of mesh counts without the need for a viscosity modifier. Print a white underlay when printing over dark fabrics for that extra "pop" in brightness. **No build-up formulations insure the highest print efficiencies without down time for wiping screens.**

Features

- High performance plastisol color mixing system for 100% cotton dark fabrics.
- Creamy, short body for easy printing.
- Tack free formulation for fast shearing action.
- Increase ink mileage with finer mesh.
- PANTONE® licensed and stock colors formulations are available in the M2007 Formulation Software and as a hard copy.
- Prints without screen build-up.

Application

Print colors straight from the container or mix using the PANTONE formulation provided in the M2007 Ink Management Software. M2 colors are user friendly and may be printed through 86-305 mc in (34-120 mc cm) mesh range without modifying the viscosity. The tack free formulation allows increased coverage. Therefore, finer mesh counts may be used for softer hand while keeping bright colors. Mix colors according to formula for best results.

Recommended Printing Techniques

- Load ink into mesh opening with hard, sharp squeegee.
- Only the image area should be filled with ink.
- Transfer ink to the fabric surface with a light squeegee pass.

Special Recommendations

- Plastisols are THERMOPLASTIC, requiring heat for fusion. Test print area for crock fastness. Should color rub off on white cloth, adjust oven temperatures and/or dwell time until crock test passes (cloth wipes clean).
- Stir plastisols prior to printing.
- Do not dry clean. Do not bleach. Do not iron image area.

Available Colors

Standard M2 Mixing Primaries

M21440 Violet
M22441 Blue #1
M22442 Blue #2
M22443 Marine
M23443 Green
M24449 Yellow
M26446 Scarlet
M26447 Red
M26449 Permanent Red
M28394 Black
M29256 White

Fluorescent M2 Mixing Primaries

M24041 Lemon
M26056 Red
M21017 Magenta
M21037 Violet