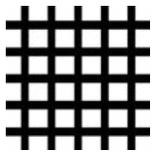


TECHNICAL DATA SHEET**SHORT DESCRIPTION:**

Smart Series is a universal ink for screen printing virtually any fabric. If you are screen printing mixed runs of cotton, poly/cotton, and 100% polyester, this ink is a must-have. No more ink changes, prevent dye migration, and get great coverage with Smart Series inks.

QUICK SPECIFICATIONS:**MESH COUNT**
86 to 158

This is simply a recommendation based on printing difficult fabrics such as 100% polyester. Preventing dye migration requires a generous ink deposit. However, Smart Series inks will print through finer mesh with ease.

**FLASH CURE**
4/5: Quick

The rating of **QUICK** implies a flash cure performance faster than most plastisol inks. Due to the great number of variables involved, we cannot specify a specific flash time or temperature. However, this ink should flash dry much quicker than general purpose ink.

**INK CURING**
280°F to 330°F

Washing and drying your prints to check durability is the ultimate test of ink curing. However, the use of Thermolabels is the most sensible method of testing for your day-to-day operations. This will help you prevent cracking, peeling, and washout.

**SQUEEGEES**
70 Durometer

Squeegees are one of many variables controlling your ink deposit. Softer squeegees are capable of printing thicker while hard squeegees allow for better print resolution. 60 durometer is soft. 70 durometer is medium. 80 durometer is hard.

**CLEAN UP**
PW-4 or IR-26

Many cleaning products will remove plastisol ink. We recommend SaatchiChem PW-4 for cleaning on-press. The IR-26 is ideal when cleaning in a washout booth. Cleaning the ink out of the screen immediately after printing is always recommended.



TECHNICAL DATA SHEET

SMART SERIES BENEFITS:

- Excellent coverage on dark fabrics without a lot of puff.
- Perfect for a printer wanting only one ink in their shop for all printing.
- Excellent bleed resistance on 100% polyester.
- Special ink formula to help prevent some ghosting problems.
- Creamy ink viscosity for manual and automatic screen printing equipment.

IDEAL CURING GUIDELINES:

Cure the Smart Series in the temperature range listed below (measure with a Thermolabel). Curing is a time and temperature process. A lower temperature with a slower belt speed is always the best method.

100% Cotton	Poly/Cotton	Polyester	Nylon/Stretch	100% Nylon	Polypropylene	Rayon
280°F to 320°F	X	X				

*Smart Series inks are very stretchy. However, when printing some spandex or lycra blends, adding S-Additive may be necessary. 10% S-Additive to 90% ink is the recommended mixing ratio. Never exceed 15% S-Additive into any ink.

TIPS AND TRICKS:

- Smart Series white and colors have amazing opacity and bleed resistance. If you ever want to improve upon this, consider a high solids emulsion or simply more coats of emulsion to create a thicker stencil.
- On sublimated polyester such as digital camo, always print the ELT Digital Black Underbase first to prevent dye migration.
- Smart Series colors can be printed directly on dark fabrics without a white underbase. Simply print-flash-print the color to get amazing opacity.
- Smart Series is a special formula of ink for preventing ghosting problems. If this ink does ghost, it is very likely a temperature issue. Consider curing at the lowest temperature in the cure range.

Always perform a pretest print and test cure conditions on the fabric to be printed to establish the best results. Stir inks vigorously before each use. Viscosity may need adjusting for best results. If there is ever a question about a print job, call us at 800-942-4447. We are always happy to help!