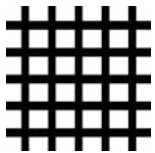


TECHNICAL DATA SHEET**SHORT DESCRIPTION:**

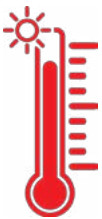
480 FF Series is a general purpose (medium opacity) ink for printing cotton and poly/cotton fabrics. FF stands for “fast flash”. By flash curing your ink faster or with less heat, you help prevent problems such as dye migration, shrinking, scorching, and color-changing.

QUICK SPECIFICATIONS:**MESH COUNT**
86 to 230

This is simply a recommendation as your art work will determine exactly which mesh count is right for you. 480 FF Series will print through finer screen mesh if needed. When opacity is a concern, consider printing with 110 screen mesh.

**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**
320°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 Saatchem 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

480 FF SERIES BENEFITS:

- Less heat leads to less printing problems.
- Creamy viscosity for use on manual and automatic presses.
- Perfect for simulated process printing.
- Huge color selection.
- Matte finish.

IDEAL CURING GUIDELINES:

Cure the 480 FF Series at the temperatures 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
320°F	320°F	X	X	X	X	X

*480 FF White will adhere to 100% polyester. However, superior inks exist for these fabrics. If you decide to print 480 FF Series on 100% polyester, cure the ink to 320°F. Dye migration is our primary concern.

TIPS AND TRICKS:

- If you do not have temperature controls on your flash cure unit, consider raising the height of the unit a couple of inches to remove the possibility of excess heat.
- Consider a white underbase or a high opacity ink when screen printing dark fabrics with lighter colors of 480 FF Series.
- For wet-on-wet screen printing, be sure to print through very fine screen mesh such as 200 or 230 monofilament.

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!