

**TECHNICAL DATA SHEET****SHORT DESCRIPTION:**

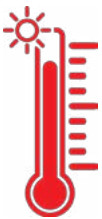
Ribbed nylon football uniforms are extremely difficult to print as ink often will crack. When you need the most stretchy ink we can offer, Nylostretch Series is there for you. This ink will stretch like a rubber band once fully cured.

**QUICK SPECIFICATIONS:****MESH COUNT**  
86 to 125

This is simply a recommendation as your art work will determine exactly which mesh count is right for you. Nylostretch Series will print through finer screen mesh if needed. When cracking is a concern, consider printing with 86 or 110 screen mesh.

**FLASH CURE**  
3/5: Average

The rating of **AVERAGE** implies a flash cure performance similar to 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 like most inks you have printed before.

**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 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.



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### NYLOSTRETCH SERIES BENEFITS:

- Our most elastic plastisol ink.
- Extremely durable on any nylon fabric.
- Great athletic color shades.
- Soft hand feel.
- No catalyst needed to untreated nylon fabric.

### IDEAL CURING GUIDELINES:

Cure the Nylostretch 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	320°F	320°F	X	X

\*Nylostretch Series is formulated for use as a nylon ink. However, it will also be an effective ink on cotton and poly/cotton. Please keep in mind it may have dye migration problems on dark poly/cotton as this is not its primary purpose.

### TIPS AND TRICKS:

- Is your print glossy? If it is not, the ink is probably not cured. Test with a Thermolabel to be sure.
- Drip water on the nylon fabric to see if it will bead up. If it does, the nylon is treated with some sort of waterproof coating.
- Always add 10% catalyst to the Nylostretch Series on waterproof or water resistant nylon.
- It is best to mix nylon catalyst into every ink color, not just the underbase. Otherwise, you could have adhesion problems.
- Stretchy nylon blends require thicker ink deposits to prevent cracking.

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!