



## TECHNICAL DATA SHEET: SB25 SERIES

### INK DESCRIPTION

SB25 is a soy-based, PVC free, non-phthalate ink for use on a variety of fabrics. This ink has the final say in “eco friendly” screen printing. Unlike other PVC free options, the SB25 will not require special emulsion and does not have a short shelf life. The finished product is soft, stretchy, and bleed resistant. The SB25 Gray Underbase is required to prevent dye migration when decorating 100% polyester.

### CURE TEMPERATURE

#### 320°F

Measure cure temperature with a set #5 Thermolabel. Curing involves both time and temperature. A fast belt speed with high heat is not recommended.

### SQUEEGEE BLADES

#### 70 & 80 Durometer

70 durometer is best for coverage on dark fabrics. However, the SB25 Gray Underbase is best printed with an 80 durometer squeegee blade.

### SCREEN MESH

#### 110 to 230 count

Choose mesh count based on artwork and coverage needs. SB25 Gray Underbase requires a 110 count mesh for best dye-blocking ability.

### FLASH CURE

#### 240°F (220°F Gray Underbase)

This is an estimation of the surface temperature required to dry SB25 to the touch. Preheat the platens to ensure this temperature is reached during production.

### SQUEEGEE SETTINGS

#### 15° angle, medium pressure

SB25 is production friendly and easy to print. Printing with one stroke and medium to fast squeegee speed is recommended. Slow down when using the Gray Underbase.

### CLEAN UP

#### Color Change & Bean-e-doo

Color Change is a safe and effective on press ink remover. Bean-e-doo is a soy based ink remover for use in a washout booth using a hose or pressure washer and scrub pad.

### TIPS & TRICKS

- SB25 is an excellent transfer ink when used with PET or cold peel paper. If you require a low temperature process with a soy-based ink, screen printing transfers can get you there. Application as low as 225°F is possible.
- One print of Gray Underbase with 110 count mesh and one print of white with a 158 count mesh provides excellent coverage and bleed resistance for poly/cotton and 100% polyester.
- Special effect inks can be mixed in the SB25 formula. Glitters, metallic, color-changing, and more are available! These inks may have different screen mesh recommendations.
- For the smoothest prints, we always recommend using a roller squeegee immediately after flash curing the gray underbase or white.

### TESTING DISCLAIMER

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!