

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

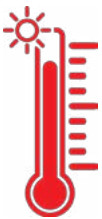
If you are looking for an environmentally friendly ink, Soymax is definitely for you. Soymax is a soy-based plastisol ink for printing cotton, poly/cotton, and 100% nylon. You don't have to change the way you print to use soy-based inks. Simply print and cure like any plastisol.

**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. Soymax Series will print through finer screen mesh if needed. When opacity is a concern, consider printing with 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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**SOYMAX SERIES BENEFITS:**

- Soy-based screen printing ink.
- Very soft feel on cotton and poly/cotton fabric.
- Extremely stretchy for cotton/stretch blends.
- Standard and opaque white ink and colors available.
- Change nothing from your current plastisol ink printing and curing process.

**IDEAL CURING GUIDELINES:**

Cure the Soymax 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

\*Soymax Series will adhere to 100% polyester fabrics. However, due to dye migration concerns we do not recommend Soymax Series for use on 100% polyester. If the polyester fabric is white, print and cure the Soymax Series inks to 320°F.

**TIPS AND TRICKS:**

- Always stir before use. Soy-based inks look and feel like regular plastisol inks but they may be a little sticky before you stir them.
- If you want to print colors such as gold or scarlet on black fabric without a white underbase, order the Soymax HO colors. Print-flash-print on black fabric and have a bright, vivid print.
- Waterproof and water resistant nylon will require nylon catalyst. Add 1 part nylon catalyst to 9 parts ink. Measure by weight.

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!