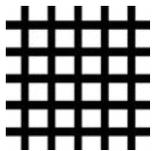


**TECHNICAL DATA SHEET****SHORT DESCRIPTION:**

180 Series is our special effect ink series. We have an amazing selection of metallic inks available for screen printing cotton and poly/cotton fabric. Far easier to print than a glitter ink, metallic inks generally give you great coverage with very little difficulty printing.

**QUICK SPECIFICATIONS:****MESH COUNT**  
86 to 110

This is a recommendation only. Numerous metallic inks we manufacture will print through much finer screen mesh. You can recognize these colors as they are both bright/fluorescent and metallic.

**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.



## TECHNICAL DATA SHEET

### METALLIC BENEFITS:

- Great bling effect without having to use the coarse mesh required by glitter inks.
- Most metallic colors provide excellent coverage on dark fabric.
- Perfect viscosity for both manual and automatic equipment.
- The finished print does not have the rough texture common with glitter inks.

### IDEAL CURING GUIDELINES:

Cure the Metallic inks 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

\*Short dryer dwell times are not recommended with Metallic inks. Be sure to slow your dryer belt down to give the print more time to reach 320°F. Also, Metallic inks will adhere to 100% polyester. However, dye migration is a concern.

### TIPS AND TRICKS:

- If you are curing with an electric dryer, it is not recommended to white underbase metallic inks as this may be difficult to cure.
- Consider a cold peel transfer as this will give the metallic inks an ultra-glossy appearance.
- Metallic inks will tarnish (some more than others) over time and after washing. Metallic Silver (chrome-look) is by far the worst offender.
- 180 Metallic Liquid Silver and Gold do not tarnish in the wash. They will be as shiny today as months down the road. Extremely durable.

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!