

Textile Screen **Inks**

TEXOPAQUE CLASSIC TP

Plastisol Inks for Screen Printing on most Natural & Synthetic Fabrics

Features

- Co-Plus Technology
- Excellent Wet-on-Wet Printability
- No ink build-up
- Improves productivity
- Good Opacity
- Reduced Fibrillation
- Soft Gel
- Soft Hand
- Good Wash Fastness
- Good Rub Fastness
- Suitable for Machine & Manual Printing
- Unlimited Colour Match Capability

Substrate

Most natural and synthetic fabrics, i.e. cotton, cotton-polyester blends and many grades of synthetic fabrics

**TEST INKS ON SUBSTRATES
BEFORE PRODUCTION RUN**

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Thinning

Plastisol Flow Thinner, SS-591, can be used up to a maximum of 5%

Mesh

Monofilament, polyester fabric ranging from 34 thread / cm to 120 thread / cm can be used. For fine details printing, use amber or yellow coloured fabric with a higher thread count of 90 to 120 per cm.

Stencils

Stencils can be best prepared with Sericol's stencil making products:

- Xtend Prep 101 for abrasion of screen
- Xtend Prep 102 for degreasing of screen

Emulsions: Dirasol 125 (single pack), Dirasol 25 (two pack) or Dirasol SuperTex

Curing

In case of direct printing on fabrics, Texopaque Classic TP inks must be heat cured at a minimum of 140 deg.C, preferably in an infra-red dryer with air circulation and heat exhaust systems, to achieve full wash fastness. Differences in film weight, drying equipment and fabric will greatly affect the dwell time required in the dryer to achieve through cure; typical dwell time is 1.5 to 3 minutes. Dark colours will cure faster than light colours. It is important that the entire thickness of the ink film has the time to reach the cure temperature, else fastness properties will not be achieved. Evaluate the cure schedule by testing the print at the wash schedule it will ultimately be expected to pass. Flash Curing: Many factors affect the dwell time required for flash curing. These include the type and wavelength of the equipment used, and the distance between the curing unit and the print. Additional factors such as fabric and ink colour, film weight and coverage are also crucial. Under optimum conditions, dwell times of less than three seconds can be readily achieved.

Coverage

Texopaque Classic TP inks would give a coverage of 15 to 27 sq.m. per kg when printed through a #43 thread per cm monofilament mesh.

Wash Up

Wash up screens with SS-639 Universal Screen Wash. This will ensure long life of stencils made with Dirasol emulsions.

Wash Fastness

Texopaque Classic TP prints have good wash fastness. It should be noted that the combination of high wash temperatures and strong detergents can cause colour changes in some colour matches. This is particularly true when very small additions of a base colour are added. For example, pastel shades can change colour as the trace additions of base colours are affected in harsh wash cycles. For this reason, it is essential that all formulations are proofed prior to production to ensure wash fastness properties are acceptable.

Fibrillation

Fibrillation occurs when fibres from the garment break through the ink film during a wash cycle to give a faded appearance. While fibrillation has the look of poor wash fastness it is not caused by loss of ink, it occurs even with fully cured prints. There are several methods to minimize fibrillation. However, this would result in increased print handle:

- Increase ink film weight
- Use a flash-cure ground coat
- Add 5% EZ444 Nylon Catalyst

As demand for low handle / low film weight print increases, so does the likelihood of fibrillation. The complex relationship of ink, print technique and garment, reinforces the need to wash test prints to customer requirements prior to production.

Pre-Production Test

End-user must determine suitability of this product for the intended use prior to production.

Always test for opacity, curing, rub fastness, wash fastness and other relevant properties before each production run.

Storage

- Keep inks in a cool place, away from direct sunlight.
- Keep the ink can tightly closed when not in use.
- Left over inks should not be returned to the ink can.
- Shelf life is two to three years from the date of manufacture.
- Stir well before use.

Applications

Texopaque Classic plastisol inks can be used for direct printing, and also transfer printing, on T-shirts, sweat shirts, sports and fashion wear, badges, hats & caps, travel bags, footwear and other textile applications.

Transfer Printing

Texopaque Classic TP inks can also be used for production of iron-on transfers.

For production of multi-colour transfers, each colour should be heat set on a transfer paper. Heat setting is done at 100 deg.C for 30 to 60 seconds. It is important that transfers are not over-set, as the adhesion of the transfers to the garment may be impaired. The finished transfer may be applied in a heat transfer machine at approximately 180 deg.C to 190 deg.C for 10 to 15 seconds. Care must be exercised with heat sensitive fabrics. The transfer paper should be allowed to cool down before removal.

Caution: Prints, direct or transfer, may be ironed from the back of the fabrics at a cool setting, with a cloth over the printed area. Prints will not resist dry-cleaning and garments should be marked to this effect.

Colour Range

The Texopaque Classic TP Ink System includes Seritone & line colours, trichromatic (process) colours, phosphorescent & fluorescence colours, expanding base, expanding white and flash cure whites.

SERITONE & LINE COLOURS

TP-001 Texopaque Classic TP Black (P)
TP-021 Texopaque Classic TP White (P)
TP-025 Texopaque Classic TP Super Opaque White
TP-042 Texopaque Classic TP Light Chrome Yellow (P)
TP-043 Texopaque Classic TP Mid Chrome Yellow (P)
TP-101 Texopaque Classic TP Light Orange
TP-124 Texopaque Classic TP Deep Red (P)
TP-134 Texopaque Classic TP Red (P)
TP-162 Texopaque Classic TP Light Red (P)
TP-165 Texopaque Classic TP Magenta (P)
TP-166 Texopaque Classic TP Violet (P)
TP-203 Texopaque Classic TP Mid Blue (P)
TP-206 Texopaque Classic TP Deep Blue (P)
TP-207 Texopaque Classic TP Navy Blue
TP-285 Texopaque Classic TP Deep Green (P)
TP-381 Texopaque Classic TP Extender Base

Trichromatic Colours

TP-004 Texopaque Classic TP Trichromatic Black
TP-052 Texopaque Classic TP Trichromatic Yellow
TP-135 Texopaque Classic TP Trichromatic Magenta
TP-215 Texopaque Classic TP Trichromatic Cyan

Phosphorescent Colour

TP-327 Texopaque Classic TP Phosphorescent Green

Fluorescent Colours

TP-077 Texopaque Classic TP Fluorescent Yellow
TP-119 Texopaque Classic TP Fluorescent Orange
TP-179 Texopaque Classic TP Fluorescent Red
TP-180 Texopaque Classic TP Fluorescent Magenta
TP-294 Texopaque Classic TP Fluorescent Green

Flash Cure Whites

TP-753 Texopaque Classic TP Supernova White
TP-755 Texopaque Classic TP Quasar White

Expanding Plastisols

TP-417 Texopaque Classic TP Expanding Base
TP-517 Texopaque Classic TP Expanding White
(P) stands for Seritone Colours

Super Opaque White & Fluorescent colours do not have the same build up resistance of the line & seritone colours and the trichromatic colours.

Colour Matches

The colour matches can be supplied against specimen prints and / or wet inks.

Transfer Papers

The selection of transfer papers for use with Texopaque TP is a critical element in optimising results. The following is a list of the standard papers available and their recommended use.

TRB08 : T 75 Transfer Paper (CP)-75 GSM. Siliconised paper for use in the production of cold peel and litho printed transfers.
TRC11 Soft Trans Paper (HS)-For use with hot spilt plastisol inks. Soft-trans is not release coated, but has a special sizing incorporated during manufacture to provide holdout for the ink. This allows for a consistent, even split of the ink film when peeled
hot TRQ97 Glicote Transfer paper (CP)-To generate high gloss transfer prints

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The information and recommendations contained in this Product Information sheet, as well as technical advice otherwise given by representatives of our Company, whether verbally or in writing, are based on present knowledge and believed to be accurate. However, no guarantee regarding their accuracy is given as we cannot cover or anticipate every possible application of our products and because manufacturing methods, printing stocks and other materials vary. For the same reason our products are sold without warranty and on condition that users shall make their own tests to satisfy themselves that they will meet fully their particular requirements. Our policy of continuous product improvement might make some of the information contained in this Product Information sheet out of date and users are requested to ensure that they follow current recommendations

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