

Long Terms Decals Inks

OPTIMA HD

Waterslide Transfer Screen Inks for Helmet Decals

Features

- Solvent Based
- Matt Finish
- Good Ink Film Flexibility
- PU Lacquer Compatibility for Overprint lacquering
- Long Term Outdoor Durability
- Suitable for Machine & Manual Printing
- Unlimited Colour Matching Metallics

Substrate

Waterslide Transfer Paper, Self
Adhesive Vinyls and Plastics

TEST INKS ON SUBSTRATES
BEFORE PRODUCTION RUN

SERICOL
More than ink...Solutions.
FUJIFILM

Thinning

Maximum of 20% by weight of ink used. Various options for thinning are available. Please refer to section on 'Solvents'.

Mesh

Print the OPTIMA HD inks & metallics through 62/cm to 90/cm, monofilament polyester fabric, depending on the application.

For HD-023 Extra Opaque White, use 77/cm mesh.

For HD 433 Peelable Varnish use 18 to 23/cm mesh

For HD 383 Overprint Varnish use 43/cm to 55/cm mesh.

For fine details & half tone printing, use amber or yellow coloured fabric.

Stencils

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

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

Emulsions: Dirasol 132 single pack or Dirasol 915 two-pack.

Drying

Air dry: up to 20-30 minutes. Do not stack prints immediately. Allow sufficient time for through cure.

Jet dry: 60 degree centigrade, for up to 4 Minutes. Prints must be cooled to ambient temperature before stacking.

For HD 433: Air Dry for 24 hrs before stacking.

No Jet Dry for HD 433

Coverage

Optima HD inks should give coverage of 60 to 70 Sq.m./kg, when printed through a 90/cm mesh. HD 023 When printed through a 43/cm mesh should give a coverage of 15-20 sq.m. /kg. For HD 383 when printed through a 43/cm mesh should give a coverage 25-30 sq.m/kg. For HD 433 when printed through a 43/cm mesh should give a coverage 10-15 sq.m. /kg.

Wash Up

Wash up screens with SS639 Universal Screen wash. This will ensure long life of stencils made with Dirasol emulsions.

Outdoor Use - Line Colours

OPTIMA HD inks have been successfully tested for weathering in a QUV Weatherometer, as per ASTM G53 test specification, using UVA-340 lamps. The inks withstood almost 2000 hours without appreciable colour change or deterioration evident.

Caution: Optima HD inks and metallics must be always be overprinted with HD-383 before testing for weatherability.

Accelerated weathering tests cannot be precisely related to outdoor performance. However, the Optima HD Ink System is expected to have an outdoor exposure durability of five years or more.

Caution: The Optima HD prints must be always overprinted with HD-383

Pre-Production Test

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

Always test for adhesion and other properties before each production run because there can often be significant differences between substrates from different manufacturers and even between different batches.

Storage

- Keep inks in a cool place, away from direct sunlight.
- Keep lids tightly closed when not in use.
- Any unused ink should not be returned to the can; must be stored separately.
- Shelf life is two to three years from the date of manufacture.
- Stir well before every use.

Applications

The OPTIMA HD inks are used for Helmet decals by waterslide transfers application

Colour Range

The OPTIMA HD Transfer Ink system is lead free & silicon free. The system includes Seritone Matching system colours, a ground coat white, a metallic medium, an overprint clear medium and Peelable Varnish

Seritone Colour Matching System

This consists of eleven transparent colours that are suitable for intermixing to produce clean shades.

HD-001	Black
HD-030	Tinting White
HD-064	Seritone Yellow (GS)
HD-066	Seritone Yellow (RS)
HD-114	Seritone Orange
HD-127	Seritone Violet
HD-164	Seritone Red
HD-165	Seritone Magenta
HD-191	Seritone Red (YS)
HD-230	Seritone Blue
HD-325	Seritone Green
HD-023	Extra Opaque White
HD-383	Overprint Varnish
HD-381	Extender Base
HD-382	Metallic Medium
HD-433	Peelable Varnish

Safety and Handling

OPTIMA HD Ink System:
is formulated free from lead, silicon and any toxic (carcinogenic), mutagenic or reprotoxic chemicals
Comprehensive information on the safety and handling of OPTIMA HD screen inks and solvents is given in the Material Safety Data Sheet, which is available on request. HD inks are not routinely tested but are formulated to comply with the EN71-3 1995 Toy Safety Standard

Colour Matches

Colour matches can be supplied against prints and / or wet ink.

Metallic

HD-461	Gold
HD-462	Silver
HD-463	Bright Silver
HD-464	Sparkle Silver

A wide range of metallics can be developed on request.

Solvents

SS-558	Slow Reducer (Retarder)
SS-552	Fast Reducer
SS-639	Universal Screen Wash

The slow reducer will increase the drying time of print, whilst the reducer will not change the drying time of print.

Co-Use with other Sericol Inks

OPTIMA HD Ink System must not be intermixed, overprinted or under-printed with any other Sericol Ink System.

Environmental Information

OPTIMA HD Ink System does not contain ozone-depleting chemicals as described in the Montreal Convention

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 our 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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