



# 6100 SUPER OPAQUE SERIES PLASTISOL INKS



## RECOMMENDED FABRICS

100% Cotton  
50/50 Cotton/Polyester Blends



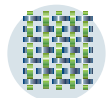
## INK APPLICATION

6100 Series Colors should be printed without any modifications



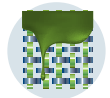
## ADDITIVES

If modification is necessary, use 1% to 3% by weight of 1110 Curable Reducer or 1099 Low Bleed Curable Reducer for 50/50 garments



## SCREEN MESH

61-230 t/in (24-90 t/cm) monofilament



## EMULSION

Any direct or indirect emulsion or capillary film in the 35 to 70 micron range, depending on the opacity desired



## SQUEEGEE

65-70 Durometer  
Sharp edge



## CURE TEMPERATURES

325°F (163°C) entire ink film



## CLEAN-UP

Any eco-friendly plastisol screen wash



## PRODUCT PACKAGING

Quart, 1 gallon, 5 gallon, 30 gallon or 50 gallon containers



## STORAGE OF INK CONTAINERS

65° to 90°F (18°C to 32°C)  
Avoid storage in direct sunlight  
Keep containers well sealed



## SDS

Refer to SDS prior to use

## FEATURES

6100 Super Opaque Series Direct Print Plastisol Inks come in 18 colors and contain a high loading of pigments for maximum coverage on dark garments, thus eliminating the need for under-basing.

The 6100 Series can also be printed on light colored garments at higher mesh counts or reduced to obtain soft-hand, opaque prints.

The 6100 Series is well suited for automated equipment although excellent results can be achieved in almost any printing operation.

## COLORS

6103 Lemon Yellow	6119 Bright Blue	6135 Light Gray
6107 Golden Yellow	6121 Royal Blue	6137 Maroon
6109 Orange	6123 Aqua Marine (Teal)	6141 Brown
6113 Scarlet Red	6129 Lime Green	6143 Dark Gray
6115 Flag Red	6131 Kelly Green	6145 Pink
6117 Magenta (Purple)	6133 Navy Blue	6147 Hot Pink

## SOFT-HAND PRINTS

For softer feeling prints on light colored fabrics, use 20% to 25% by volume of 720 Softand Clear Base. Reducing the viscosity of the ink using 1110 Curable Reducer and printing through finer mesh counts can also greatly improve the softness (hand) of the finished print.

## SPOT FLASHING

The 6100 Series inks will spot dry, with a very low after flash tack. Dwell time is dependent on the spot dryer used. In some cases, you may have to lower the heat of the spot cure unit because too much heat may actually make the ink tacky. When you spot dry, you are only partially fusing or gelling the surface of the ink. The ink should be just dry to the touch, with no lift-off, but not totally fused. Totally fusing any flashed color may cause inter-coat adhesion problems with the inks printed on top of the flashed ink. Final fusing or curing should occur in the dryer.

## IMPORTANT INFORMATION

The 6100 Series inks are low-build inks; however this does not mean that build-up will not occur. 6100 Series inks may require flashing after 3 or 4 colors if printing a wet-on-wet design.

Adding too much reducer or other additives to the 6100 Series inks may cause problems with curing/fusing or increased dye migration.

Test dryer temperatures and wash test printed product before and during a production run.

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