



#### RECOMMENDED FABRICS

50/50 Cotton/Polyester Blends  
100 Polyester



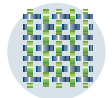
#### INK APPLICATION

Guardian Black™ 1240 must be printed without any modifications in order to maintain the best bleed resistance of the product



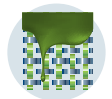
#### ADDITIVES

Not recommended



#### SCREEN MESH

83-160 t/in (32-63 t/cm)  
monofilament



#### EMULSION

Any direct or indirect solvent resistant emulsion or capillary film in the 35 to 70 micron range



#### SQUEEGEE

65-75 Durometer  
Sharp edge



#### CURE TEMPERATURES

285°F-325°F (140°C-163°C) for 1 minute, dependent on dryer speed and temperature settings and topcoat used



#### CLEAN-UP

Any eco-friendly plastisol type 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

AXEON™ Guardian Black™ 1240 blocks dye migration on problem fabrics that contain polyester, including sublimated dyed fabrics.

Guardian Black™ 1240 can take a variety of top coats depending on application; from low cure products to regular temperature curing products.

Guardian Black™ 1240 offers superior bleed resistant properties, but on some problem fabrics it may be possible for bleeding or dye migration to occur.

#### SPOT FLASHING

Guardian Black™ 1240 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 the underprint may cause inter-coat adhesion problems with the inks printed on top. Final fusing or curing should occur in the dryer. Failure to fuse ink properly may cause cracking, poor adhesion and poor wash fastness.

#### NOTE: FOR BEST RESULTS

For best print and blocking results, print two passes of Guardian Black™ 1240 through a 110 mesh screen. Then in sequence, Print-Flash-Print-Top Coat using a low bleed white ink or other type of low bleed performance ink.

#### IMPORTANT INFORMATION

Always test print the fabric to be used before beginning production to see if the desired performance is obtained.

It is very important that Guardian Black™ 1240 be exactly registered with any white or other color that is printed on top of the Guardian Black™ 1240 in order to help insure maximum bleed resistance of the top color. If the color printed on top of Guardian Black™ 1240 overlaps the Guardian Black™ 1240 in any spot, that spot may show bleeding or dye migration.

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

This ink and those in the AXEON™ product line are not formulated with PVC resins or phthalate plasticizers, nor are they intentionally added.

**Care should be taken to not cross-contaminate the AXEON™ products with PVC or phthalate containing products.**

**Do not use standard plastisol curable reducers with this or any of the AXEON™ products.**

#### LEGAL DISCLAIMER

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