

## FEATURES

- 3804 Non-Phthalate (NP) Additive lowers the curing or fusion temperatures of most plastisol based inks to less than 300°F (149° C).
- Use the 3804 NP Low Cure Additive when printing onto temperature sensitive fabrics such as 100% polyester or non-woven polypropylene bags.
- For use on 100% cotton, poly/cotton blends and 100% polyester.
- Will lower the flash times for most plastisol based inks.

Lead Compliant (Contains less than 90 ppm lead)

## Application & Storage Information

<b>RECOMMENDED FABRICS</b>	100% cotton, cotton/polyester blends, and 100% polyester. Always test print and check for wash fastness and possible bleeding or dye migration.
<b>INK APPLICATION</b>	3804 Low Cure Additive can be mixed into most standard plastisols (5% to 6% by weight maximum) to lower cure or fusion temperature.
<b>SCREEN MESH AND EMULSION</b>	Screen mesh to be determined by ink used with additive. Any direct or indirect lacquer resistant emulsion.
<b>SQUEEGEE</b>	65-70 Durometer: Sharp Edge 60-90-60 or 70-90-70 Triple Durometer: Sharp Edge
<b>CURE TEMPERATURES</b>	300°F (149°C) or lower with use of 3804 Low Cure Additive. Lower cure or fusion temperatures may be achieved when this additive is used with certain plastisol inks (down to 275°F (135°C)). Test dryer temperatures and wash test printed product before and during a production run.
<b>CLEAN-UP</b>	Any environmentally friendly plastisol screen wash.
<b>PRODUCT PACKAGING</b>	Quart, 1 Gallon and 5 Gallon Containers.
<b>STORAGE OF INK CONTAINERS</b>	Recommend storage at 65°F to 90°F (18°C to 32°C). Avoid storage in direct sunlight. Keep containers well sealed.
<b>PRODUCT MSDS</b>	Refer to Material Safety Data Sheet 3804MSDS8

## MODIFYING INK

Modifying 3804 Low Cure Additive is not recommended.

## SPOT FLASHING

3804 Low Cure Additive will improve the flash times of most plastisol based inks if needed. Flash time and temperature will vary depending on which ink the 3804 is added to. Too much heat / time may cause the mixed ink to become sticky after flashing. Adjust flash unit accordingly. When spot drying, the ink should be just dry to the touch, with no lift off, but not totally fused. Final curing / fusing should occur in the dryer.

## IMPORTANT INFORMATION

1. Do not exceed the recommended addition (5% to 6% by weight) of the 3804 Low Cure Additive to ink. If too much additive is used the mixed ink may lose opacity, gain in viscosity very quickly, and print poorly.
2. To obtain the optimum performance of the 3804 Low Cure Additive, the additive must be thoroughly dispersed into the ink being modified. The use of a mechanical mixer is highly recommended. Additive not completely dispersed may cause uneven curing or fusing of the mixed ink.
3. Due to the performance difference in inks that the 3804 Low Cure Additive may be added to, it is highly recommended that prior testing be completed before beginning production to help insure proper performance of the combined products.
4. The 3804 Low Cure Additive is not a bleed resistant product and should be tested in the mixed ink when used on fabrics where bleeding or dye migration may occur. Bleeding or dye migration may not occur right away.
5. Always stir the 3804 Low Cure Additive before each use and mix thoroughly into other inks before using (maximum 5% to 6%) by weight.
6. Do not use 3804 Low Cure Additive as is. The additive must be mixed into another ink before use.

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**3804 NP Low Cure Additive**