

**PRODUCT DESCRIPTION:**

HI-DENSITY INK, when printed correctly, will produce a thick ink layer print that retains sharp edges and crisp, highly detailed definition even after curing. This is not a puff ink, and must be used in combination with a correctly prepared screen, stencil film, and a carefully adjusted printing technique.

**RECOMMENDED MESH/EMULSION:** 86-110T Mesh with thick film 250-400 micron Capillary Film Stencil. Thicker films can be used, but multiple ink layering is easier. It is possible to recoat direct emulsion multiple times to create a thick stencil, but intercoat drying 10-20 times is slow. Fast film mounting procedure:

- remove primary cover sheet and place thick film emulsion-side up on a board smaller than frame I.D. Place clean screen on top of the film.
- apply a bead of "C" laminate emulsion inside screen above a leading edge of the film resting below the mesh.
- use a squeegee to draw the emulsion across the screen, pushing it through the mesh "gluing" the cap film to the screen. Use several passes.
- when fully dry, apply one more coating of liquid emulsion inside the screen with a scoop coater, dry, and remove cover sheet for exposure.
- exposure: 3 minutes at 40" per 5KW of light intensity for 250 micron.

(See detail step-by-step instructions for preparing a thick film capillary stencil)

**ADDITIVES:**

Use of additives is not recommended with this ink. Occasionally, in order to obtain a sharper print, 1-2% of Reducer by weight (PLUS-9000) may be added.

**PRINT TECHNIQUES:** Use a sharp 75-80 durometer squeegee. The squeegee angle and pressure must be adjusted so the ink prints a clean, sharp image but is not pushed into the fabric being printed on. Use a slow speed both on the flood and print strokes. The off-contact distance should be as small as possible. Adjust the speed and angle of screen lift so that the screen peels away from the print immediately behind the squeegee on the print stroke. High mesh tension is important. Hi-density layers should always be last in print order.

**CURING:** Plastisol inks will not air dry. These inks will fully cure and withstand repeated washings when the entire ink deposit reaches 300°-320°F. Curing can best be accomplished with the use of a conveyer dryer with this ink.

**Important Note on Curing:**

Proper curing is EXTREMELY IMPORTANT. Poor wash-resistance of the print can generally be traced back to improper curing! It is important to understand how to set your dryer and check the temperature you are achieving using an accurate measurement device like a Temperature Gun.

**WASH-UP:** CCI Press Washes or Ink Degradents. (Petroleum Solvents work too.)

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