

# PLASTIPUFF PLASTISOL

## *Plastisol Puff Ink*

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### APPLICATION

- **T-SHIRTS**
- **BASEBALL CAPS**
- **SWEATSHIRTS**

### FEATURES

- **UNIFORM PUFF FINISH**
  - **EXTREMELY DURABLE**
  - **VERY OPAQUE**
  - **LOW CURE TEMPERATURE**
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### SPECIFICATIONS: PLPF

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#### GENERAL INFORMATION:

PLASTIPUFF is a plastisol puff ink formulated to cure and expand rapidly. PLASTIPUFF also produces an exceptionally strong, long-lasting ink film with a high uniform finish and excellent abrasion resistance. The inks should be used on T-shirts, sweatshirts and other woven cotton and cotton/polyester garments.

If an extremely durable high-loft puff look is desired, a mixture of PATH Athletic Ink and PUFFS-9111 Super-Puff Additive can be used. See Technical Data for Puff Additives for additional information.

#### PRINTING:

Puff inks will expand in all directions when heated. Because of this it is important to try to lay the ink on top of the garment. This helps the ink puff away from the garment and not into it. Printing on a soft printing surface such as a thin pad of silicone rubber will help leave the ink on the surface of the garment. To get proper coverage it may be necessary to use more than one printing stroke.

#### SPECIAL ARTWORK REQUIREMENTS:

More uniform puffing is achieved when the artwork has similar line thickness. If the design has a mixture of thin lines and heavy block areas, convert the block areas into a 70% halftone screen for more uniform puffing. On multi-color designs leave a small gap between colors to allow them to touch after puffing.

#### OPACITY:

Excellent. When first printed, the print may not look as opaque as it will after it has been cured.

## **CURING:**

PLASTIPUFF Inks will expand to a durable finish if allowed to reach 310°F (155°C). Flash curing multi-color prints at lower temperatures is permissible provided all colors reach 310°F at the final curing stage. For additional information on curing see Union Ink's Plastisol General Information Sheet. PLASTIPUFF will produce beautiful multi-color effects if quickly flash cured between colors. Do not flash long enough to complete the puff process; just gelling the print so as to avoid pressing into the garment when successive colors are printed over it. Puff the ink on the final cure .

## **Important Note on Curing:**

Excellent puffing is achieved at temperatures too low to fully cure the plastisol. It is important to reach the recommended temperature to ensure proper adhesion. If the cured print cracks when folded it is probably not cured.

## **PUFF ADDITIVE:**

Standard plastisol can be turned into plastisol puff by adding PLPF-9111 Puff Additive to regular Plus Series plastisol. (For more durable puffing add Super Puff Additive PUFSS-9111 to PATH Athletic Ink). For fluorescent puff ink, add PLPF-9111 Puff Additive to PLUS Series Fluorescent colors. Add Puff Additive at the rate of 1 part additive to 6 parts plastisol BY VOLUME and follow the directions for PLASTIPUFF.

## **STENCILS:**

Direct emulsion stencils such as UNION INK'S INMARCOL-R or INMARCOL-W are recommended. A thicker than normal stencil helps produce a higher deposit of ink. Capillary direct films that are 4 to 7 mils also produce good stencils.

## **SCREEN FABRIC:**

Monofilament meshes ranging from 33-76T (14-29T metric) may be used. High ink deposits will produce higher expansion .(Best results are obtained by thick stencils to further increase ink deposits).

## **REDUCERS:**

PLASTIPUFF Inks are supplied Ready-For-Use. If necessary use very small amounts of Detackifier/Reducer. Always stir well to break down false body and determine the actual working viscosity prior to adding reducer.

## **WASH-UP:**

Mineral Spirits or biodegradable WASH-9900 Skreen Kleen.

## **STORAGE:**

Keep containers tightly closed Store away from excessive heat or sunlight. Avoid storing above 85F (30C).

## **WASHABILITY:**

Excellent. Do not dry clean. Imprinted areas should not be ironed.

## **CAUTION:**

Always pre-test for curing, adhesion, puff height, wash-resistance, etc. before production.

## **ALWAYS TEST BEFORE USING IN PRODUCTION**

While Union Ink Company believes that the data contained herein are factual and the opinions expressed are those of qualified experts regarding the results of the tests conducted, the data are not to be taken as a warranty or representation for which Union Ink Company assumes legal responsibility. They are offered solely for your consideration, investigation, and verification. Pretest inks on surfaces to be printed.

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## **COLORS:**

PLPF-1000 White  
PLPF-1052 Low Bleed Super White  
PLPF-2000 Primrose Yellow  
PLPF-2042 Golden Yellow  
PLPF-2050 Orange  
PLPF-3010 Scarlet Red  
PLPF-5006 Brite Blue  
PLPF-5036 Royal Blue  
PLPF-5040 Navy Blue  
PLPF-6006 Brite Green  
PLPF-7000 Dark Brown  
PLPF-8000 Black

## **ADDITIVES:**

PLPF-9090 Extender Base  
PLPF-9111 Puff Additive  
PUFS-9111 Super Puff Additive