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**TECHNICAL DATA  
SHEET**

# Ultrasoft Plastisol (PLUS/PLUE)

A versatile, easy-printing, direct-print and transfer ink.

## Applications

- Light and medium-colored shirts.
- Hot-split and cold-peel transfers.
- 100% Cotton fabrics only

**General Information:** Ultrasoft inks are versatile, lead-free, plastisol inks formulated for direct printing and heat transfer manufacturing. They have good coverage on light and medium-colored garments. When printing on dark fabrics, a white underbase is recommended. Ultrasoft's new formulation helps eliminate press stoppages due to build-up on the backs of screens.

**Opacity:** Ultrasoft is a medium-opacity ink.

**Mesh:** For direct printing, monofilament polyester meshes from 86 to 305 threads per inch (34-120 threads per centimeter). Meshes over 180 (71 metric) will produce very soft-hand prints but will reduce opacity. For best results with neon colors do not use meshes over 160 (62 metric). For hot-split transfers use 83-110 mesh (34-43 metric). For overprint colors use 140-230 mesh (55-91).

**Stencils:** Use direct emulsion or capillary film.

## Features

- A versatile, easy printing ink.
- Over 50 standard colors.
- Soft hand prints.

**Additives:** If reducing the ink is necessary, add 3-5% Viscosity Reducer (PLRE-9000) by weight. Do not add any additives when using Ultrasoft for plastisol transfer production.

**Curing Direct Prints:** Ultrasoft inks will fully cure when the entire ink deposit reaches 300° F (149° C). Do not use metallic colors for heat transfer production.

**Curing Heat Transfers:** Ultrasoft ink will semi-cure or gel when it reaches 250° F (121° C). For more information on transfers, see the general information Technical Data Sheets. For more information on the additives listed below, see the Plastisol Ink Additives Technical Data Sheets

**Caution:** Always test this product for curing, adhesion, crocking, opacity, washability and other specific requirements before using in production.

### Standard Colors

PLUS/PLUE-1020 Opaque White  
PLUS/PLUE-1035 Backup White  
PLUS/PLUE-1500 Gray  
PLUS/PLUE-2001 Primrose Yellow  
PLUS/PLUE-2011 Lemon Yellow  
PLUS/PLUE-2021 Chrome Yellow  
PLUS/PLUE-2041 Golden Yellow  
PLUS/PLUE-2051 Orange  
PLUS/PLUE-3001 Vermillion Red  
PLUS/PLUE-3006 Bright Red  
PLUS/PLUE-3011 Scarlet Red  
PLUS/PLUE-3015 Cardinal Red  
PLUS/PLUE-3030 Maroon  
PLUS/PLUE-4010 Magenta  
PLUS/PLUE-4025 Deep Purple  
PLUS/PLUE-5005 Bright Blue  
PLUS/PLUE-5015 Columbia Blue  
PLUS/PLUE-5020 Mono Blue

### Standard Colors Cont.

PLUS/PLUE-5030 Ultramarine Blue  
PLUS/PLUE-5035 Royal Blue  
PLUS/PLUE-5040 Navy Blue  
PLUS/PLUE-6001 Tahiti Green  
PLUS/PLUE-6006 Bright Green  
PLUS/PLUE-6021 Dark Chrome Green  
PLUS/PLUE-6091 Kelly Green  
PLUS/PLUE-7001 Dark Brown  
PLUS/PLUE-7031 Sienna Brown  
PLUS/PLUE-8000 Black

### Fashion Colors

PLUS/PLUE-1504 Flesh  
PLUS/PLUE-2102 Khaki  
PLUS/PLUE-3106 Fuschia  
PLUS/PLUE-3113 Cool Pink  
PLUS/PLUE-4101 Lilac  
PLUS/PLUE-4103 Rose Magenta

### Fashion Colors Cont.

PLUS/PLUE-4104 Violet  
PLUS/PLUE-5105 Turquoise  
PLUS/PLUE-5107 Powder Blue  
PLUS/PLUE-5108 Peacock Blue

### Fluorescents

PLUS/PLUE-F211 Orbit Yellow  
PLUS/PLUE-F212 Golden Yellow  
PLUS/PLUE-F213 Inferno Orange  
PLUS/PLUE-F214 Flame Orange  
PLUS/PLUE-F311 Missile Red  
PLUS/PLUE-F312 Aurora Pink  
PLUS/PLUE-F511 Solar Blue  
PLUS/PLUE-F611 Traffic Green  
PLUS/PLUE-F666 Phosphorescent Green

### Metallics

PLUS/PLUE-M100 Copper  
PLUS/PLUE-M120 Silver  
PLUS/PLUE-M128 Washable Silver  
PLUS/PLUE-M220 Pale Gold  
PLUS/PLUE-M222 Rich Gold  
PLUS/PLUE-M224 Mirror Gold

### Additives

PLRE-9000 Reducer/Detackifier  
PLUS/PLUE-9020 Build-Up Buster  
PLUS/PLUE-9030 Clear For Metallics  
PLUS/PLUE-9034 Easy Split Transfer Clear  
PLUS/PLUE-9040 Hot-Split Additive  
PLUS/PLUE-9090 Extender Base  
PLUS/PLUE-9100 Conc. Viscosity Reducer  
PLUS/PLUE-9114 Thickener  
NYBE-9120 Nylon Bonding Agent  
PLPF/PLPE-9111 Plastipuff Additive  
TOPL/PFTR-Concentrated Toners