



W.M. PLASTICS

## Athletic Inks

A super tough ink formulated to provide gloss finish, opaque prints with high ink deposits and excellent elasticity. The Athletic inks are available in any Pantone color.

### *Features*

- Extremely Durable
- Glossy Finish
- Very Opaque
- Pantone Colors

### *Printing Instructions*

- When flooding one should use minimal pressure.
- Use proper pressure and angle of squeegee when pulling constant squeegee speed.
- Adding more strokes of the squeegee can increase deposit
- Heavy deposits can increase dot gain and smuggles

## Technical Information

<i>Substrates</i>	Cotton, Poly/Cotton Blends, and Acrylics
<i>Bleed Resistance</i>	N/A
<i>Opacity</i>	Very Opacity
<i>Mesh</i>	86 to 200
<i>Screen Tension</i>	Good/High
<i>Stencil</i>	Direct, Indirect & Capillary
<i>Squeegee Type</i>	70, 70/90, 70/90/70
<i>Squeegee Blade</i>	Sharp
<i>Squeegee Angle</i>	45 angle
<i>Squeegee Speed</i>	Normal
<i>Flashing</i>	Fast. (700 F for 4 seconds). Mesh will effect the flash times.
<i>Gel Temp</i>	160 to 185 F
<i>Cure Temp</i>	1 to 1 ½ minutes at 325 F
<i>Reducer</i>	10-9906 Curable Reducer
<i>Caution</i>	Always test this product for curing, adhesion, crocking, opacity, wash ability, and other requirements in your specific application before using in production.
<i>Storage</i>	Ideally at 80 F. Keep out of direct sunlight and heat.
<i>Wash-up</i>	Any Plastisol Screen wash or Mineral Sprits
<i>MSDS</i>	Sheet Number: 1

## Printing Tips

<i>Lack of Coverage</i>	<i>Not Clearing</i>	<i>Not Curing</i>
Contact too Close	Stroke Speed too Fast	Slow Belt Speed
Mesh Count too High	Squ. Pressure too Low	Increase Oven Temp
Stroke too High	Squ. Angle too High	Pigment Loading
Check for Bleeding	Squ. Rubber too Soft	
Squ. Pressure too High	Ink too Thick	