PLASTIC TECHNOLOGIES
RUTLAND

QS-9000/ISO 9001 Registration #60047

Technical Data Sheet: 227

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Product: LX Athletic Series

FEATURES

Short body and very low wet tack for easy printing.
Fast shearing action means higher press speeds.
Easy to use, no viscosity modifications necessary.
Economical ready-to-use colors that print with a semi-gloss finish with maximum opacity and color brightness. **Clear will have a high gloss finish.**

DESCRIPTION

LX Athletic Series is formulated as a press-ready plastisol for printing on 100% Cotton fabrics or over a low bleed underlay on poly/cotton. This product has excellent opacity (except for the clear) for superior coverage over dark fabrics. Use LX9101 HO FF White as an underlay on 100% Cotton.

APPLICATION

Print LX directly onto substrates or over an underlay. LX inks are normally printed through mesh ranges from 86-110 mc./in. (34-43 mc/cm.) You may print through finer mesh to achieve fine details with less opacity. Recommend 60 Durometer squeegee and medium print speed to create the best print. Cures to a semi-gloss finish, for a gloss look cure at higher temperature and longer times.
Clear can function as an over print clear or be thickened to be used in layering applications. *Note: Clears will cause yellow to migrate from formulations that are being overprinted. Formulate those colors to be overprinted without yellow or with non-migrating pigment if possible.*

RECOMMENDED PRINTING TECHNIQUES

Manual Machine Printing

- ❑ Load ink into mesh opening with soft, sharp squeegee.
- ❑ Only the image area should be filled with ink.
- ❑ Transfer ink to the fabric surface with a light squeegee pass using just enough pressure to clear the mesh.

Automatic Machine Printing

- ❑ Examine the flood bar and smooth edges if necessary.
- ❑ Adjust the flood to just transfer the ink from the front to the back of the screen.
- ❑ Transfer ink to the fabric surface with a light squeegee pass using just enough pressure to clear the mesh.

SPECIAL RECOMMENDATIONS

Plastisols are THERMOPLASTIC, requiring heat for fusion. Test print area for crock fastness. Should color rub off on white cloth, adjust oven temperatures and/or dwell time until crock test passes (cloth wipes clean). Stir plastisols prior to printing. Do not dry clean. Do not use bleach.
Do not iron image area.

TECHNICAL DATA

Wet Ink Tack - *Low*

After Flash Tack - *Medium*

Printability - *Great*

Surface Appearance – *Semi-gloss (Clear is Glossy)*

Opacity/Viscosity – *High/High (Except Clear)*

Bleed Resistance – *N//A*

Gel Point / Flash Time - *160°f. (71° C.)/ decreases with print thickness*

Fusion Temperature - *320° f. (160° C.)*

Squeegee Hardness/ Blade/ Angle – *Soft/ Sharp/ 45°*

Squeegee Speed – *Medium to High*

Underlay – *Use low bleed white for poly/cotton*

Emulsion – *Direct, Indirect emulsion or Capillary Film*

Mesh Count – *86 - 156 mc. In.(34 – 62 mc. Cm.)*

Thickener – *M00333 Thickener #3*

Storage - 65°F to 95°F. (18° *C to 33° C.)* Avoid direct sun

Cleanup - Non-hazardous screen washes

MSDS - *#1*

Substrate Type – Cotton or 50/50 Poly Lights and Darks(with underlay)

LX4202 Gold	**LX2251 Royal Blue**
LX4486 Lemon	**LX2499 Turquoise**
LX5534 Orange	**LX3408 Green**
LX6267 Magenta	**LX3859 Apple Green**
LX6772 Brite Red	**LX1211 Violet**
LX6400 Scarlet	**LX8014 Black**
LX1569 Purple	**LX9555 White**
LX2406 Navy	**LX9101 HO FF White**
LX2768 Bright Blue	**LX0214 Clear**

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