Non-Phthalate/PVC Plastisol Inks
Low Bleed (LB)/Poly
I102011LB (Barrier Gray Underlay)

W.M. PLASTICS

Applications	Features
-Direct printing -100% Polyester garments	-Superb Bleed Resistance -Great Stretchability -Easy to print viscosity -Flat, smooth finish for multi-color printing -Improves the feel of the final print

General Info:

Barrier Gray is a high opaque, low bleed ink that was designed to be used as an under base on 100% Polyester substrates. The product has been tested on a number of known substrates known to bleed, including digital camo garments, with great success.

Bleed Resistance: Excellent

Opacity: High

Storage: 70° to 80°F

Mesh: 80-160

Stencil: Any direct emulsion or capillary film.

Wet on Wet Printing: Not recommended

Modifications: Not recommended

Squeegee Hardness & Angle: Medium to hard at a 45 degree angle.

Flashing: 700ºF for 3-5 seconds, just enough for the surface to be tack free.

Squeegee Blade: Sharp.

Fusion/Curing: 260°F/126°C for 1 ½ - 2 minutes. 300°F/148°C for 1 to 1 ½ minutes.

Wash-up: Any plastisol cleaner.

Special Notes: PVC inks are thermoplastic compounds that require heat to fuse or cure. If ink rubs off on a white cloth or cracks, temperature and/or dwell time should be increased. Do not dry clean and always test on fabric to be printed.

Printing Tips

As today's garments become more difficult to print on it becomes increasingly important that printing and curing parameters be monitored to ensure the most success on these substrates. Each type of substrate will have different printing requirements. Below is a quick outline of suggestions to yield a higher success rate for each type.

Please note these are tips for success and in no way a guarantee against bleeding. As the manufacture of the plastisol, we can't stress enough to test before running production

100% Polyester

Curing temperature and deposit thickness will play a big role in whether a printer is successful or not on these substrates. The lower the temperature the substrate is cured at, the less likely dye migration will take place. The suggested method to print this type of substrate is as follows: no more than a 160 mesh screen for the Barrier Gray and the top coat, medium to hard squeegee, flood screen with Barrier Gray, print one pass, one flash, move to top coat, print once, flash move to other colors and print wet-on-wet. Cure at 260°F/126°C for 1 ½ - 2 minutes.

Sublimated Garments

This is where the printing becomes more difficult and monitoring of the printing and curing parameters become important. The suggested method to print this type of substrate is as follows: no more than a 160 mesh screen Barrier Gray and the top coat, medium to hard squeegee, flood screen with Barrier Gray, print, flash, print, flash, flood screen again with Barrier Gray, print, flash, print, flash, move to top coat, flood screen with top coat, print, flash, print, flash, flood screen again with top coat, print, flash, print, flash and move to next colors and print wet-on-wet. Cure at 260°F/126°C for 1 ½ - 2 minutes.

Alternative Method

If you still find your garment is bleeding through with the above procedures, repeat the above procedures but use an 80 mesh screen instead.