



| Recommendations     |                               |
|---------------------|-------------------------------|
| Product Overview    |                               |
| Product Code        | PADE6090                      |
| Industry            | Inks                          |
| Application         | Screen Printing               |
| Category            | Stock Colors                  |
| Chemistry           | Plastisol                     |
| Substrate(s)        | Cotton                        |
| Best Used By        | 12 months                     |
| Certification(s)    | ISO9001                       |
| Performance:        |                               |
| After Flash Tack    | Decreases with increased mesh |
| Squeegee:           |                               |
| Squeegee Profile    | Square                        |
| Squeegee Type       | Polyurethane                  |
| Squeegee Angle      | 10° - 20°                     |
| Storage:            |                               |
| Storage Temperature | 65°F - 95°F (18°C - 35°C)     |

*Last Change: Nov 2016*

## EF MAXOPAKE KELLY GREEN

### Instructions

Dark garments. Direct printing. 100% cotton or cotton/polyester.\* Stencils: Use any direct emulsion or capillary film compatible with plastisol inks. Additives: Maxopake inks are supplied ready to print. If necessary to reduce viscosity, use up to 15% by weight, of Reducer/Detackifier (PLRE-9000). For printing transfers, mix Maxopake with with 5-10% Hot Split Additive (PLUE-9040). Printing Instructions: Multiple strokes may be required when printing by hand. When printing with automatic presses use a slightly rounded squeegee to print a thicker ink layer. A soft pad on the printing pallet will minimize penetration into the garment and improve opacity. Curing Instructions: These inks will fully cure when the entire thickness of the ink deposit reaches 300°F (149°C). Using Low-Bleed Inks: The Maxopake series includes two low-bleed colors: Low-Bleed Medium Yellow (PADE-2060), and Low-Bleed Golden Yellow (PADE-2048). The lowbleed inks are recommended for printing on cotton/polyester garments to control the problem of dyes in the polyester fibers migrating or "bleeding" into the plastisol ink. Low-bleed inks are not recommended for printing on light-colored 100% cotton fabrics. On rare occasions ghost images can appear on contacting surfaces of ink to garment. The use of low-bleed plastisols on these fabrics is not recommended. If low-bleed colors are used, be sure to fully cure, to minimize the possibility of ghost images. Avoid stacking or packing garments printed with low-bleed inks while they are still hot. Always check to see if you are getting ghost images. PRODUCTS: Standard Colors PADE-1001 Basic Cotton White / PADE-2064 Orange / PADE-5015 Columbia Blue PADE-1027 Bright Cotton White / PADE-2102 Fashion Khaki / PADE-5017 University Blue PADE-1030 Premium Brite Cotton / PADE-3006 Bright Red / PADE-5020 Mono Blue PADE-1062 EZ Print White / PADE-3010 Scarlet Red / PADE-5036 Royal Blue PADE-1508 Lite Grey / PADE-3015 Cardinal Red / PADE-5060C Aqua Marine PADE-1525 Dark Grey / PADE-3020C Flag Red / PADE-5085C Opaque Process Blue PADE-2010 Lemon Yellow / PADE-3021 Lo Crock Flag Red / PADE-5108 Peacock Blue PADE-2013 Cream / PADE-3030 Maroon / PADE-6001 Tahiti Green PADE-2017 Vegas Gold / PADE-3113 Cool Pink / PADE-6008 Brite Green PADE-2020 Chrome Yellow / PADE-4014 Magenta / PADE-6016 Lime Green PADE-2044 Golden Yellow / PADE-4020 Deep Purple / PADE-6022 Chrome Green PADE-2046 Rebel Gold / PADE-4101 Fashion Lilac / PADE-6090 Kelly Green PADE-2052 Burnt Orange / PADE-4103 Rose Magenta / PADE-7031 Sienna Brown PADE-2057 University Orange / PADE-5008 Brite Blue / Low-Bleed Colors PADE-2060 Medium Yellow / PADE-2048 Golden Yellow Fluorescent Colors PADE-F211 Orbit Yellow / PADE-F214 Flame Orange / PADE-F402 Purple PADE-F212 Golden Yellow / PADE-F311 Missile Red / PADE-F511 Solar Blue PADE-F213 Inferno Orange / PADE-F312 Aurora Pink / PADE-F611 Traffic Green Additives PLRE-9000 Reducer/Detackifier / MIXE-9090 Extender Base PADE-9090 Extender Base

### Recommendation

Caution: High opacity inks may crock. Red pigmented inks are especially subject to this problem. To control or reduce crocking, add up to 10-15% by weight of Extender Base (PADE / MIXE-9090). Always test this product for curing, adhesion, crocking, opacity, washability and other specific requirements before using in production.

### Statement

Union Ink does not knowingly add plasticizers containing the phthalates listed and outlined in California Bill 1108, CPSIA HR-4040 and Oeko-tex Standard 100. The plasticizers identified may include di-(



processing over which we have no control. Recommendations for use do not constitute a warranty, either express or implied, of the fitness or suitability of the products for a particular purpose.