



Recommendations	
Product Overview	
Product Code	PADE7031
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 SIENNA BROWN

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-(2-ethylhexyl) phthalate (DEHP), dibutyl phthalate (DBP), benzyl butyl phthalate (BBP), diisononyl phthalate (DINP), diisodecyl phthalate (DIDP), di-n-octyl phthalate (DnOP), (DIBP) Di-iso-butyl, and (DMP) Dimethylphthalate, including esters of ortho-phthalic acid and are not direct ingredients in the manufacture of our Non-Phthalate Inks. Union Ink does not test the final product for amounts of the aforementioned phthalate plasticizers and esters and encourages all users to conduct testing for their intended use.

Disclaimer:

Not all Union products are available in every country. Please check with your local representative for availability. The data presented in this leaflet are in accordance with the present state of our knowledge, but do not absolve the user from carefully checking all supplies immediately on receipt. We reserve the right to alter product constants within the scope of technical progress or new developments. The recommendations made in this leaflet should be checked by preliminary trials because of conditions during



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.