



ZODIAC**ECOCENTRIC INKS

PRODUCT INFORMATION BULLETIN

Libra™ High Density Base

RECOMMENDED PARAMETERS



Fabric Types

100% Polyester, Cotton and Poly/ Cotton blended fabrics



Mesh

Counts: 80-160t/in (34-62t/cm) Tension: 18-35n/cm3



Squeegee

Medium: 70 or 60-90-60 Profile: sharp, square

Stroke: x2 stroke, medium speed

Angle: 10-15%



Stencil

Standard Emulsion Off Contact: 1/16" (2mm) Emulsion Over Mesh: 50-200 microns or capillary film up to 400 microns



Flash & Cure

Flash: 300°F(149°C) for 4 seconds (on preheated pallets) Cure: 60 seconds at 270°F(132°C)



Pigment Loading

Libra™ Silicone Pigments Maximum 20%



Libra™ Additives

Libra™ Catalyst: 3-5% Libra™ Retardant: 0.5-3% Libra™ Pigment/Toner: up to 20%



Storage

Store in sealed containers 12 months from manufacture >40F (5C) <77F (25C)



Clean Up

Standard plastisol cleaners



Health & Safety

SDS: www.polyone.com/resources/ safety-data-sheets or contact your local CSR

ed with Libra pigments and toners or special effect additives. Designed to achieve High Density effect while maintaining a super-soft flexible hand.

HIGHLIGHTS

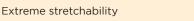
Extreme high density effect

Super-soft hand feel



Libra™ High Density Base consists of a high viscosity translucent base with excellent shear properties to transfer easily from thick emulsion or capillary film. The ink can be pigment-

Matte, translucent finish



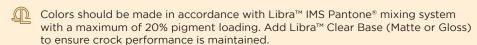


Drag-free, non-tacky hand

PRINTING TIPS



Use 3-5 parts Libra™ Silicone Catalyst and 2-4 parts Libra™ Silicone Retardant to 100 parts Libra™ High Density Base. Libra™ Silicone pigments or special effect powders can be added up to 20 parts. Mix well and print. To prevent wastage only catalyze what is need to print for 4 hours.



Use 86-160t/34-62t mesh screens for best performance.

Print with 1/16" or 2mm off contact.

Print two strokes to ensure the mesh is clear and you have a good ink deposit.

Flash between prints.

Clean the stencil area when stopped to prevent screen blockages.

Prints should be cured at 270°F /132°C for 60 seconds. Check the cure temp at the ink surface.

Test all prints for print durability before starting the production run.

COMPLIANCE



Non-PVC, non-phthalate



Visit www.polyone.com/zodiacinks/libra for more information

PRECAUTIONS



The information above is given in good faith and does not release you from testing inks and fabrics to confirm suitability of substrate and application process to meet your customer standards and specifications

Copyright © 2019, PolyOne Corporation. PolyOne makes no representations, guarantees, or warranties of any kind with respect to the information contained in this document about its accuracy, suitability for particular applications, or the results obtained or obtainable using the information. Some of the information arises from laboratory work with small-scale equipment which may not provide a reliable indication of performance or properties obtained or obtainable on larger-scale equipment. Values responded as "typical" or stated without a range do not state minimum or maximum properties; consult your sales represententiative for properts speciations. Processing conditions can cause material properties to shift from the values stated in the information. PolyOne makes no warranties or guarantees respecting suitability of either PolyOne's products or the information for your process or end-use application. You have the responsibility to conduct full-scale end-product performance testing to determine suitability in your application, and you assessment alread and tability arising from your use of the information and product. POLYONE MAKES NO WARRANTIES, EXPRESS OR IMPLETD, INCLUDING, BUT NOT LIMITED.

TO, IMPLED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, either with respect to the information or products reflected by the information. This literature shall NOT operate as permission, recommendation, or individuement in practice and useful averaging a literature of the partner control of the product procession and the

