

## Technical Data Sheet #308

3/17/2009

<b>Wet Ink Tack</b>	High tack
<b>After Flash Tack</b>	High
<b>Printability</b>	Excellent, for fast production
<b>Surface Appearance</b>	Glossy
<b>Opacity/Viscosity</b>	Clear / Medium
<b>Bleed Resistance</b>	N/A
<b>Gel Point</b>	160°F (71°C.)
<b>Fusion Temperature</b>	320°F (160° C.)
<b>Squeegee Hardness</b>	70-80 durometer
<b>Squeegee Blade</b>	Sharp
<b>Squeegee Angle</b>	45° to screen mesh
<b>Squeegee Speed</b>	Medium to High
<b>Flood Stroke</b>	Load ink into mesh opening
<b>Print Stroke</b>	Medium speed, light pressure
<b>Emulsion</b>	Direct, Indirect, Capillary film
<b>Mesh Count</b>	86 mc in (34 mc cm) - 230 mc in (90 mc cm)
<b>Extender</b>	Use only non-phthalate
<b>Thinner</b>	Use only non-phthalate
<b>Thickener</b>	M00010 Thickener #10
<b>Storage</b>	65°F to 95°F (18°C to 35°) Avoid direct sun.
<b>Cleanup</b>	Non-phthalate screen wash
<b>MSDS</b>	#ES0026
<b>Color Range</b>	Clear, (others with EB Color Concentrates)
<b>Substrate Type</b>	100% Cotton and polyester/cotton w/LB underlay
<b>Substrate Color(s)</b>	Light and Dark fabrics

## Claira™ NPT Non-Phthalate Specialty Inks

### ES0026 NPT ThermoLine Clear

#### Description

**ES0026 NPT ThermoLine Clear** is a non-phthalate plastisol used for adhesive type applications and as a clear base for Metallic powders and flakes.

#### Application

C3 Color Boosters may be added to the NPT ThermoLine Clear for custom colors at a maximum of 30% by weight. The thicker the ink film deposit, the less pigment needed to maintain color intensity.

**As a Flock Adhesive:** ES0026 is also used as an adhesive for applying flock to textile fabric. We suggest adding up to 5% NPT Fiberbond for maximum adhesion to flock fibers and print through 200-micron stencil for this application. Note: The mixture with FiberBond will have maximum 8 hours shelf life.

#### Creating a thick stencil:

Creating a thick stencil (200 micron) will offer maximum ink deposit. The thickness of the stencil will determine the thickness of the ink deposit. Thicker stencils will require an increase in exposure time. Contact emulsion supplier for more detail information.

#### Special Recommendations

Claira Colors™, bases, modifiers and additives should be mixed in clean vessels using clean mixer blades and utensils. Any contamination from other ink sources or non approved additives could make Claira Colors™ test positive for the restricted phthalates.

- Do not dry clean, bleach, or iron the printed image.**

Rutland Plastic Technologies does not knowingly add plasticizers containing the phthalates listed and outlined in California Bill 1108, CPSC 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 Claira™ High Opacity Non-Phthalate Mixing System Inks and Claira™ Non-Phthalate Concentrate Mixing System Inks nor any of the Claira Specialty inks. Rutland Plastic Technologies 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.

ANY APPLICATION NOT REFERENCED IN THIS TECHNICAL DATA SHOULD BE PRE-TESTED OR CONSULTATION SOUGHT WITH RUTLAND'S APPLICATIONS LABORATORY PRIOR TO PRINTING. CALL 704-553-0046 EXT. 151 FOR MORE INFORMATION.

