



Recommendations	
Product Overview	
Product Code	ATHP3021
Industry	Inks
Application	Screen Printing
Category	Stock Colors
Chemistry	Plastisol
Substrate(s)	Poly
Best Used By	12 months
Certification(s)	ISO9001
Performance:	
Coverage	High Opacity
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 POLY LO CROCK FLAG RED

Instructions

Direct print low-bleed series for controlling dye migration on 100% polyester fabrics. Athletic uniforms or any other fabrics prone to dye migration Stencils: Any direct emulsion or capillary film compatible with plastisol inks. Additives: Polyester low-bleed plastisols are supplied ready to print. Since plastisol inks will settle as they sit in the container you should always stir the ink well to determine the actual printing viscosity before adding any reducer. The viscosity of Polyester low-bleed plastisol has been carefully formulated to sit on top of the fabric when printed. Reducing will cause the ink to penetrate into the fabric affecting coverage. Any chemical modification will also diminish the inks bleed resistance. Care should be taken if modification is deemed necessary. Very small amounts .5-1% by weight of PLRE-9100 Concentrated Plastisol Reducer should be adequate. Never add mineral spirits to any plastisol ink. Printing Instructions: For the best coverage, bleed resistance and brightest prints, adjust the off-contact distance and squeegee pressure to print the ink layer on top of the printed fabric rather than pushing the ink entirely through it. Also be sure to follow recommended emulsion coating techniques as well as exposure settings. Curing Instructions: Plastisol inks will not air dry and must be heat cured. Polyester low-bleed plastisols will fully cure and withstand repeated washings when the entire thickness of the ink deposit reaches 300°F (149°C). Be careful ink film temperatures do not exceed 330°F (166°C) as this temperature may facilitate dye migration. PRODUCTS: Available Colors ATHP-1070 Premium Low Bleed White / ATHP-3006 Brite Red / ATHP-5020 Mono Blue ATHP-1500 Grey / ATHP-3011 Scarlet Red / ATHP-5035 Royal Blue ATHP-1508 Dark Grey / ATHP-3015 Cardinal Red / ATHP-5040 Navy Blue ATHP-2010 Lemon Yellow / ATHP-3021 Low Crock Flag Red / ATHP-5060 Aqua Marine ATHP-2013 Cream / ATHP-3033 Maroon / ATHP-5075 Columbia Blue ATHP-2017 Vegas Gold / ATHP-3213 Cool Pink / ATHP-5108 Peacock Blue ATHP-2020 Chrome Yellow / ATHP-4010 Magenta / ATHP-5148 Light Navy ATHP-2040 Golden Yellow / ATHP-4020 Deep Purple / ATHP-6001 Tahiti Green ATHP-2045 Blazer Gold / ATHP-4101 Fashion Lilac / ATHP-6008 Brite Green ATHP-2046 Rebel Gold / ATHP-4103 Rose Magenta / ATHP-6016 Lime Green ATHP-2050 Burnt Orange / ATHP-5002 Aqua / ATHP-6020 Kelly Green ATHP-2057 University Orange / ATHP-5008 Brite Blue / ATHP-6022 Chrome Green ATHP-2064 Orange / ATHP-5015 Collegiate Blue / ATHP-7031 Sienna Brown ATHP-2102 Khaki / ATHP-5017 University Blue / Barrier Inks PLHE-9040 Barrier Clear / PLHE-1500 Barrier Grey Additives PLRE-9100 Concentrated Reduce

Recommendation

Caution: Always test this product for curing, adhesion, crocking, opacity, bleed resistance, washability and other specific requirements before using in production. Because of the thick ink deposits required by athletic printers, Polyester Low-Bleed plastisols may require higher dryer temperatures or slower belt speeds for the ink deposit to reach the recommended curing temperature. For 100% polyester fabrics prone to extreme dye migration consider using Union's Barrier Clear PLHE-9040 or Barrier Grey PLHE-1500 as an under base especially when light or white overprint colors are required.

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.