



# CFX HIGH DENSITY INKS

## 3 Dimensional Special effect inks

### Technical Data Sheet

REV. 20240314

#### Key Features

A range of Phthalate Free plastisol inks formulated for printing on both Manual and Automatic equipment. We offer CFX High Density Ink in two colors, Black and White and a Base Which can be colored using CFX Carnival Inks. When correctly printed the images should have sharp edges and the surface will be smooth with a semi matt appearance. Print thicknesses of up to 1000 microns can be achieved using a print flash print technique.

#### Wash Resistance

CFX High Density Inks will pass a minimum of 5 x 60°C wash Cycles when correctly cured. CFX High Density Inks should not be dry cleaned.

#### Compliance

All CFX Plastisol Inks are formulated to be Phthalate Free, meet Oekotex standards and do not contain any Substances of Very High Concern. Currently, we, the manufacturer, do not test for compliance and should the user require certification we recommend they use an independent test house for verification.

#### Storage

Avoid direct sunlight and store at a temperature between 16°C / 60°F and 30°C / 95°F.

#### Health and Safety

Please refer to the appropriate MSDS sheet

#### Application Recommendations

##### Fabric Types

Cotton and Cotton Polyester Blends, and Polyester if a suitable Under base is used to provide bleed resistance.

##### Mesh

From 34 to 62 threads per cm

##### Stencil

High Build Solvent Resistant Dual Cure Emulsion or High Micron count Capillary Film. (100 microns to 400 microns)

##### Squeegee

Square Profile. 60 – 90 Shore. Single or triple blend durometer.

##### Additives

CFX High Density inks are supplied ready for use and should not need to be modified. The supplied viscosity is high but this is required to get the print effect desired. When using the High Density base to produce colored high density inks we recommend a mix of 80 – 85% Base with 15- 20% CFX Carnival color.

##### Printing

Printing thick films requires a high build stencil and the correct off contact. The flood stroke should be slow and fill the image area with ink, the print stroke similarly slows to allow the transfer of ink to the substrate and a clean peel to maintain the sharp edges to the print. Flash and repeat as necessary

##### Flash Temperature / Gel Point

Typically, 65°C / 150°F on preheated pallets.

##### Cure Temperature

160°C / 320°F for 60 to 90 seconds. However thick films may require a longer dwell time to ensure complete cure.

##### Clean Up

For equipment use a Biodegradable Screen Wash. Clean up spills with a suitable absorbent material. Dispose of unused ink responsibly in accordance with local regulations

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