



### 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/cm<sup>3</sup>



##### 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](http://www.polyone.com/resources/safety-data-sheets)  
or contact your local CSR

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 pigmented 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
- Extreme stretchability
- Super-soft hand feel
- 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.
- Colors should be made in accordance with Libra™ IMS Pantone® mixing system with a maximum of 20% pigment loading. Add Libra™ Clear Base (Matte or Gloss) to ensure crock performance is maintained.
- 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](http://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