



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: 40 micron



Flash & Cure

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



Pigment Loading

Not recommended



Libra™ Additives

Libra™ Catalyst: 3-6%
Libra™ Retardant: 0.5-3%



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

Libra™ Barrier Black system is a medium viscosity clear Part A base mixed with black Part B pigment to provide an excellent anti-migration underbase. The ink is used at a ratio of 80:20 Clear Part A : Black Part B with excellent adhesive and dye blocking properties while maintaining a super-soft flexible hand.

HIGHLIGHTS



Satin finish



Non-tacky hand



Extreme stretchability



Super-soft hand feel

PRINTING TIPS



Use 3-5 parts Libra™ Silicone Catalyst and 0.5-2 parts Libra™ Silicone Retardant to 100 parts 80:20 base/pigment. Mix well and print. To prevent wastage only catalyze what is need to print for 4 hours.



For improved adhesion on difficult fabric, use 6 parts Libra™ Silicone Catalyst and 0.5 parts Libra™ Silicone Retardant to 100 parts Barrier Clear Part A. Print through 80-110 mesh screen then follow with the standard barrier formula described above.



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