



## XOLB-805 MEDIUM BROWN

Recommendations	
<b>Product Overview</b>	
Product Code	XOL805
Industry	Inks
Application	Screen Printing
Category	Stock Colors
Chemistry	Plastisol
Substrate(s)	Blends
Best Used By	12 months
Certification(s)	ISO9001
<b>Curing:</b>	
Fusion Temperature	320 °F
<b>Performance:</b>	
After Flash Tack	Decreases with increased mesh
<b>Squeegee:</b>	
Squeegee Profile	Square
Squeegee Type	Polyurethane
Squeegee Angle	10° - 20°
<b>Storage:</b>	
Storage Temperature	65°F - 95°F (18°C - 35°C)
Storage Notes	Store in a cool and dry environment. Keep container tightly closed to prevent from drying and/or contamination.

*Last Change: May 2020*

### Instructions

Printing: XOLB inks print well through screen meshes in the range of 83-305 TPI (32-120 TPcm). Screens stretched to a minimum of 25 newtons are recommended. If using lower tension screens, adjust off contact accordingly. Use just enough squeegee pressure to deposit the ink on the surface of the shirt. This will enhance the opacity and also ensure a better cure. Try not to drive the ink into the fabric. A 70 - 80 durometer sharp squeegee is recommended. Stencil: Use any direct emulsion or capillary film. Flashing: Parameters vary between all flash units. Flash for 2-3 seconds with the ink deposit reaching 150-250ZF (65-121ŽC). Ink should be dry and without tack. Warning: Over flashing can cure the ink and prevent adhesion between coats of ink. Cleanup: Use any of the commercially available products for the cleanup of plastisol inks. Environmentally Friendly: QCM Plastisol Ink contains no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.

### Statement

QCM Textile Inks 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 Non-Phthalate Inks. QCM 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 QCM products are available in every country. Please check with your local representative for availability. The data presented 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.