



| Recommendations         |                                       |
|-------------------------|---------------------------------------|
| <b>Product Overview</b> |                                       |
| Product Code            | M32441                                |
| Industry                | Inks                                  |
| Application             | Screen Printing                       |
| Category                | Mixing Inks                           |
| Sub-Category            | M3 Mixing System                      |
| Chemistry               | Plastisol                             |
| Substrate(s)            | Cotton                                |
| Best Used By            | 12 months                             |
| Certification(s)        | ISO9001                               |
| <b>Curing:</b>          |                                       |
| Fusion Temperature      | 320 °F                                |
| Gel Point               | 160 °F                                |
| <b>Performance:</b>     |                                       |
| Viscosity               | Medium                                |
| Coverage                | High Opacity                          |
| Printability            | Great                                 |
| After Flash Tack        | Low                                   |
| Bleed Resistance        | None except M39000 White              |
| <b>Squeegee:</b>        |                                       |
| Squeegee Profile        | Square                                |
| Squeegee Type           | Polyurethane                          |
| Squeegee Speed          | High                                  |
| <b>Screen:</b>          |                                       |
| Mesh                    | 86 to 305                             |
| Screen Tension          | As recommended for mesh               |
| Underlay                | NPT Cotton White for 100% cotton dark |
| Emulsion Type           | Capillary film, Direct                |
| Cleanup                 | Bio-degradable screen wash            |
| <b>Additives:</b>       |                                       |
| Extender                | ES0840 or EH0542                      |
| Thickener               | M00010 Thickener #10 (powder)         |
| Thinner                 | EA0005 Viscosity Reducer              |
| <b>Storage:</b>         |                                       |
| Storage Temperature     | 65°F - 95°F (18°C - 35°C)             |
| Storage Notes           | Avoid direct sun.                     |

Last Change: Nov 2016

## NPT HO BLUE #1 M3

M3 Ink Mixing System is a non-phthalate finished ink mixing system. M3 colors directly replace the M2 and EM ink mixing colors. They are opaque resulting in excellent coverage on dark garments. The tackfree formula allows printing through a range of mesh counts without the need for a viscosity modifier. Use a white underlay when printing on dark fabrics for that extra "pop" in brightness. No build-up formulations ensure the highest print efficiencies without down time for wiping screens. Mix thousands of finished ink colors by choosing Pantone colors from our M2007 Ink Mixing Software or by custom mixing your own colors. NPT Low Bleed White underlay for printing on polyester/cotton blends. NPT Cotton White underlay for printing on 100% cotton. Clairra NPT Barrier Base (Dyno Grey) available for printing on 100% polyester

### Instructions

Printing on White Garments: Mix per formulation or by eye to achieve brilliant colors on 100% cotton whites. For extremely soft-hand prints, mix finished color up to 1:1 with Clairra ES0250 NPT Chino Base. Printing on Dark Garments or over an underlay: When printing on dark garments, mix per formulation or custom blend to achieve brilliant colors over an underlay. Use the NPT Low Bleed White on poly/cotton blends and the ES0266 NPT Barrier Base when printing on 100% polyester Puff designs: Mix 10-15% of Clairra NPT Puff Additive to any formulated Clairra™ Color to create a puff ink. PRODUCTS:

|        |                            |        |                          |
|--------|----------------------------|--------|--------------------------|
| M31037 | NPT OPAQUE FLUOR VIOLET M3 | M36055 | NPT OPAQUE FLUOR PINK M3 |
| M31440 | NPT HO VIOLET M3           | M36056 | NPT OPAQUE FLUOR RED M3  |
| M32065 | NPT OPAQUE FLUOR BLUE M3   | M36446 | NPT HO SCARLET M3        |
| M32441 | NPT HO BLUE #1 M3          | M36447 | NPT HO RED M3            |
| M32442 | NPT HO BLUE #2 M3          | M38394 | NPT HO BLACK M3          |
| M32443 | NPT HO MARINE M3           | M39000 | NPT LB NG RETRO WHITE M3 |
| M33033 | NPT OPAQUE FLUOR GREEN M3  | M39256 | NPT HO WHITE M3          |
| M33443 | NPT HO GREEN M3            | M31018 | NPT FF FLUOR MAGENTA M3  |
| M34037 | NPT OPAQUE FLUOR YELLOW M3 | M31038 | NPT FF FLUOR VIOLET M3   |
| M34041 | NPT OPAQUE FLUOR LEMON M3  | M34042 | NPT FF FLUOR LEMON M3    |
| M34449 | NPT HO YELLOW M3           | M36057 | NPT FF FLUOR RED M3      |
| M35018 | NPT OPAQUE FLUOR ORANGE M3 |        |                          |

### Recommendation

Clairra Colors™, bases, modifiers and additives should be mixed in clean vessels using clean mixer blades and utensils. Any contamination from other ink sources or non-approved additives could make Clairra Colors™ test positive for the restricted phthalates. Do not dry clean, bleach, or iron the printed image. Note to 100% cotton users: With low bleed ink, 100% cotton could produce a ghost image. Clairra M39000 NPT LB NG RETRO WHITE is a low-bleed ink that is formulated to print on cotton or polyester cotton without causing a ghost image. M39000 NPT LB NG RETRO WHITE is not recommended for 100% polyester. Use Clairra Barrier Base for 100% polyester.

### Statement

Rutland Plastic Technologies 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 Clairra High Opacity Non-Phthalate Inks. Rutland Plastic Technologies 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 Rutland 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.