PRODUCT INFORMATION BULLETIN

ES0137 NPT SPONGE PUFF BASE

Rutland™

Sponge Puff was developed as a soft hand puff product for creating a soft, more durable puff print.

Highlights

- Press ready plastisol for printing on dark 100% cotton and over a low bleed under lay.
- Colors created by using C3 Color Boosters at up to 50%.
- Creamy plastisol for easy printing.
- Low tack formulation for fast shearing action.
- Non-Phthalate formulation to comply with new regulations restricting phthalates.

Compliance

- Internationally compliant
- Non-phthalate
- https://www.avientspecialtyinks.com/services/compliance-support

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.

Printing Tips

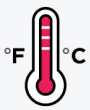
- Print ES0137 on 100% Cotton, as a mixed color, or over a low bleed underlay white for poly/cotton. For best results print NPT Sponge Puff through a 86-160 t/in (34-63 t/cm) mesh count.
- Finer mesh counts may be used when printing on top of other inks, such as High Density, to give a soft puff finish. *Note to 100% Cotton users: 100% Cotton could have a ghost image appear if printed with this ES0137.
- Test the particular color garment prior to printing production run to insure this product will not cause a ghost on your garment. See Test Procedures at https://www.rutlandinc.com/screen/techbulletins.
- Sponge Puff base may be printed on it's own. This is particularly useful for printing tone-on-tone prints or creating alternating profiles.
- Try creating a design that has polka dots, stripes, etc. Print this screen with the Puff base and then a solid color over the puff base.
- Only the areas with the puff base below the ink film will puff. From here you may be inspired to do more technical and interesting effects.
- Under basing your puff colors will prevent "cupping" or reverse pucker. Over printing your puff colors or puff base on it's own will control "mushrooming" and can present a more uniform flat puffing.
- For puff to work, you need time and heat. If you are failing to get "lift" from the Puff base, slow down your belt speed before increasing heat to correct this.

Recommended Parameters



Fabric Types

Cotton



Flash & Cure

Flash: 140-150F on pre-heated pallets
Cure: 320F



Clean Up

Unused ink will need to be disposed of responsibly. Standard plastisol cleaners, press wash, or ink degradant



Mesh

Counts: 86-160
Tension: 18n-25n/cm3



Pigment Loading

C3 Color Boosters at up to 50%.



Health & Safety

Find SDS information here: www.avient.com/resources/safety-data-sheets or contact your local CSR



Squeegee

70
Profile: Square
Stroke: 1+
Angle: 10-20%



Additives

N/A



Stencil

Standard Emulsion
Off Contact: 1/16" (2mm) or greater
Emulsion Over Mesh: 15-20%



Storage

65 -95 F (18 -35 C) Avoid direct sunlight

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