

# ATP INKS



The ATP (Athletic Team Plastisol) series athletic inks are designed for high abrasion garments.

## Highlights

- ATP inks are designed specifically for athletic uniforms, athletic bag printing, and difficult to print-on fabrics.
- The ATP inks have excellent adhesion and will produce a long print life on loosely woven nylon substrates.
- ATP inks were not formulated for printing on closed weave nylon jackets/shells without the use of MF-66 Nylon Bonding Additive.
- ATP has excellent, low bleed characteristics and is recommended for use on nylon, polyester, including mesh, dazzle cloth, Cardura and other difficult fabrics.
- This ink may be printed thick for athletic lettering and transfers.

## Printing Tips

- It is best practice to "pre-shear" ink before introduction to the screen. Do this by "Slicing and folding" the ink with an ink knife. Do not mix with power drill, friction heat from mechanical mixers other than a "Turn about" style mixer will thicken up the ink body.
- For best results use a flood/print method using a 70 to 80 durometer, squeegee. A print, flash, print is recommended for polyester. 60-110 TPI (23-43 TPcm) screens tightened to 25 newtons are recommended.
- Coarse meshes are recommended for a thicker ink deposit
- Closed or tight weave nylon shell fabrics (used in jackets) will still require MF-66 Nylon Bonding Agent.
- For best results use a flood/print method using a 60 to 70 durometer, squeegee. A print, flash, print is recommended for polyester. 60-110 TPI (23-43 TPcm). Screens stretched to a minimum of 25 newtons are recommended. Coarse meshes are recommended for a thicker ink deposit. The ATP inks have excellent adhesion and will produce a long print life on loosely woven nylon substrates. Closed or tight weave nylon shell fabrics (used in jackets) will still require MF-66 Nylon Bonding Agent. Warning: Some jackets are waterproofed and may prevent MF-66 from bonding. A solvent wipe of the fabric may be required.
- Depending on your flash unit, ATP Inks will flash in 3 seconds (10 watts per sq. in/heating area) or 4-5 seconds (6-7 watts per sq. in. / heating area).











## 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.

## Recommended Parameters

 <p><b>Fabric Types</b> Nylon</p>	 <p><b>Flash &amp; Cure</b> Flash: 140-150°F on pre-heated pallets Cure: 60 seconds at 300°F(148°C)</p>	 <p><b>Clean Up</b> Standard plastisol cleaners, press wash, or ink degradant</p>
 <p><b>Mesh</b> Counts: 86-110 Tension: 25n/cm3</p>	 <p><b>Pigment Loading</b> Not recommended</p>	 <p><b>Health &amp; Safety</b> Find SDS information here: <a href="http://www.avient.com/resources/safety-data-sheets">www.avient.com/resources/safety-data-sheets</a> or contact your local CSR</p>
 <p><b>Squeegee</b> 70 Profile: Square Stroke: x2 stroke, slower speed Angle: 10-20%</p>	 <p><b>Additives</b> See print tips above.</p>	<p>2021, Avient Corporation. Avient makes no representations, guarantees, or warranties of any kind with respect to the information contained in this document about its accuracy, suitability for particular applications, or the results obtained or obtainable using the information. Some of the information arises from laboratory work with small-scale equipment which may not provide a reliable indication of performance or properties obtained or obtainable on larger-scale equipment. Values reported as "typical" or stated without a range do not state minimum or maximum properties; consult your sales representative for property ranges and min/max specifications. Processing conditions can cause material properties to shift from the values stated in the information. Avient makes no warranties or guarantees respecting suitability of either Avient's products or the information for your process or end-use application. You have the responsibility to conduct full-scale end-product performance testing to determine suitability in your application, and you assume all risk and liability arising from your use of the information and/or use or handling of any product. AVIENT MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, either with respect to the information or products reflected by the information. This literature shall NOT operate as permission, recommendation, or inducement to practice any patented invention without permission of the patent owner.</p>
 <p><b>Stencil</b> Standard Emulsion Off Contact: 1/16" (2mm) or greater Emulsion Over Mesh: 15-20%</p>	 <p><b>Storage</b> 65 -95° F (18 -35° C) Avoid direct sunlight</p>	