



#### RECOMMENDED PARAMETERS

##### Fabric Types



Cotton

##### Mesh



Count: 110-230T/in  
Tension: 25n/cm3

##### Squeegee



Durometer: 70, 60/90/60  
Profile: Square  
Stroke: 1 to 2  
Angle: 10-15%

##### Stencil



Water Resistant Emulsion  
Off Contact: 1/16" (2mm)  
Emulsion Over Mesh: 15-20%

##### Flash & Cure



Flash: Pre-heated pallet  
Cure: 320°F

##### Pigment Loading



Union Ink Maxopake ink series or  
Mixopake Pantone system

##### Aquarius™ Additives



Aquarius™ Discharge Activator ZF  
4-6%

##### Storage



Store in sealed containers 12  
months from manufacture >40°F  
(5°C) <77°F(25°C)

##### Clean Up



Water & mild detergent

##### Health & Safety



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

Aquarius™ Plasticharge Additive can be used on it's own or tinted 1:1 with Union Ink Maxopake or Mixopake inks to create Plasticharge colors.

#### HIGHLIGHTS

- Plastisol and water base inks may be printed over Plasticharge prints.

#### PRINTING TIPS

- Combine equal parts Aquarius™ Plasticharge Additive and a suitable Union Mixopake or Maxopake plastisol. Stir slowly until completely mixed. Add 4-6% Aquarius Activator ZF just before printing and mix until completely dissolved.
- Your percentage of Aquarius™ Activator ZF powder should be based on the weight of the Aquarius™ Plasticharge Additive only, Not the combined weight of the ink and additive.
- Water base inks can dry in the screen, Aquarius™ Plasticharge Additive is no exception. It is helpful to mist the air above the screen with a spray bottle of distilled water as needed in order to maintain humidity.
- The printer must test any color mixed with Aquarius™ Plasticharge Additive on the garment prior to production to determine if the dyes in that garment will discharge.
- When mixing Plasticharge reds- it is often beneficial to reduce the amount of Activator ZF powder by 1%.
- Union Ink Maxopake and Mixopake inks are Triple opacity inks that can maintain color value when mixed with Aquarius™ Plasticharge Additive.

#### COMPLIANCE

- Water based, non phthalate
- Visit [www.avient.com/products/screen-printing-inks/zodiac-aquarius](http://www.avient.com/products/screen-printing-inks/zodiac-aquarius) 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



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