

## SCREEN PRINTING THE TFA BOMBER

Screen printing on 100% polyester can be challenging. The key is to find the right ink. An ink that is opaque enough to avoid grin through and is able to be cured at low temperatures. We have found our preferred ink at International Coatings™, we tested it and want to share some printing tips to best decorate the Threadfast Bomber, style 395J.

<p><b>PREFERRED INK</b></p>  <ul style="list-style-type: none"> <li>• <b>All-Pro™ 900 Series Plastisol Ink</b>, from International Coatings™, a fast flashing two-part ink.</li> <li>• Wide color palette including metallics. More: <a href="http://screenprinting.iccink.com">screenprinting.iccink.com</a></li> </ul>	<p><b>CATALYST</b></p>  <ul style="list-style-type: none"> <li>• The All-Pro™ 900 Series Ink needs to be mixed with the <b>All-Pro™ 900 Catalyst</b>.</li> <li>• Catalyst quantity used must be <b>5%</b> of total ink for maximum adhesion.</li> <li>• The Catalyst ensures proper adhesion to the fabric.</li> </ul>	<p><b>SCREEN MESH</b></p>  <ul style="list-style-type: none"> <li>• When preparing screens, use a <b>high-tension mesh with thin thread</b>.</li> <li>• For standard colors, recommended screen mesh is 125-230 t/in.</li> <li>• For metallic colors, 86-110 t/in and for process colors, 200-305 t/in.</li> </ul>
<p><b>ACCESS ZIPPER</b></p>  <ul style="list-style-type: none"> <li>• Zipper provides <b>access</b> behind lining and fill, allowing for easy single-ply loading onto pallet.</li> <li>• Easy to hold <b>registration</b>.</li> <li>• Zipper opens from bottom left chest up and across to the right shoulder, see illustration*.</li> </ul>	<p><b>PRINTING TIPS</b></p>  <ul style="list-style-type: none"> <li>• Recommended <b>squeegee</b>: 70-80 Durometer Sharp edge.</li> <li>• Use <b>off-contact printing</b>, leaving space between the screen and the fabric surface.</li> <li>• Apply ink with a <b>single stroke</b>, enough to achieve good coverage.</li> </ul>	<p><b>CURE TEMPERATURE</b></p>  <ul style="list-style-type: none"> <li>• Recommended temperature is <b>275°F (135°C)</b> entire ink film for 1 minute.</li> <li>• Maximum temperature of 285°F (140°C).</li> <li>• Fusing at lower temperatures may require a longer dryer retention time.</li> </ul>
 <p>Threadfast Apparel has partnered up with International Coatings™ to bring you this information. They are pioneers in the development and production of textile screen printing inks, traffic paints, industrial coatings and specialty compounds.</p>		

### PRINTABLE AREAS



### \*INSIDE ACCESS ZIPPER



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