

507PF SOFT HAND EXTENDER BASE

Excalibur's 507PF Soft Hand Extender Base is a balanced additive that is a combination extender, penetrant and flow agent. This additive can be added to any Excalibur Phthalate-Free Plastisol ink to not only extend the ink and soften the hand-feel of the finished print it also reduces the viscosity and improves the flow of the ink thus helping the ink clean completely from the screen mesh. Even though it can be used in any quantity the following precautions should be taken when mixing 507PF into Excalibur plastisols. It is recommended that 507PF be used in combination with the 500PF, 533PF or 550PF Series and only be printed directly onto white or light-coloured backgrounds.

- Always stir any plastisol ink thoroughly prior to adding to the screen in order to break down the false body that builds up during storage. This should always be done prior to adding 507PF Curable Reducer to any ink. If 507PF is added before stirring it could cause the mixed ink to be too thin to produce the desired print.
- If using an ink paddle with a variable speed drill always set drill to turn on a slow speed to not allow any heat from the friction of stirring to build up in the ink. Introducing heat to the ink will begin the gelling process and make the ink more difficult to print.
- Adding 507PF to any high-opacity ink that will be printed directly onto dark backgrounds will diminish opacity and should not be added. For this reason best results are attained by adding no more than 1% of 502PF Viscosity Reducer by weight to any high-opacity ink that is being printed directly onto dark backgrounds.
- Adding too much 507PF will diminish the film strength of the finished print and could possibly cause "fibrillation" where the fiber of the shirt stands up during the washing process and breaks through the ink film causing the print to appear faded. Fibrillation can also look as if the print is undercured. In order to determine if the print has "fibrillated" or is "undercured" simply wet your thumb or rub a wet cloth over the print. If the colors in the print darken and appear stronger or more vibrant the shirt is "fibrillating". If the print looks the same after wetting it is probably undercured and needs to be cured longer in your conveyor oven.
- 507PF Curable Reducer will increase the chances for dye migration on 50/50 poly/cotton blends or 100% polyester fabrics and should not be added to any ink being printed on those type fabrics. 1501PF SportPro Curable Reducer should be used instead.

CAUTION

Always test finished prints for curing, adhesion, bleed-resistance, opacity and desired look prior to beginning full production runs. Lancer Group International cannot guarantee the results or back claims that this mixed ink will test phthalate-free if this product is used with any other plastisol ink other than plastisol inks manufactured by Lancer Group International. Test results by a third-party laboratory verifying that Excalibur plastisol inks are phthalate-free and lead-free are available upon request.

TECHNICAL DATA



IDEAL FABRIC

100% cotton white or light-coloured fabrics.



MESH

83-305/inch (32T-120T/cm)



SQUEEGEE

70/90/70 Triple Durometer
70 Single Durometer



STENCIL

Any emulsion compatible with plastisol inks.



CURING

Consult TDS for particular ink this product is being mixed into.



MIXING

10%-15% by weight.



VISCOSITY REDUCERS

N/A



STORAGE

60°-90° F (15°-32° C) with lids closed tightly.



CLEANING

Enviro Series 2000 Green or Enviro Series TR Blend.



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