

Excalibur

Technologically Superior Ink



DYE DISCHARGE SYSTEM (DC-2012 and DC-2018)

Excalibur's formaldehyde-free Dye Discharge System yields excellent results when printers want a soft-hand feel on 100% cotton dark garments. When activated with DC-294N Discharge Agent the printed inks sink down into the fabrics destroying the dyes in the garment. The DC-2012 is a clear that can be pigmented with Excalibur's Colortone or PCW Pigments to produce dischargeable colours, can be printed as an underbase for plastisol colours to be printed on top of, or can be used by itself to discharge garments to the original straw colour of the cotton. The DC-2018 is a highly pigmented white to use as a stand-alone white or as an underbase to overprint plastisol colours. Either ink when used as an underbase will produce softer prints when compared to traditional plastisol underbases. Because different garment manufacturers use different dyes and processes to manufacture their garments testing is required to determine how well this process will work on a particular brand and color of garment.

Technical Information

Mixing Colours: To mix custom dischargeable colours either the Colortone Pigments or PCW Pigment Concentrates may be added in increments of 5-20% by weight to DC-2012 Clear. The DC-2012 Clear should be pigmented prior to adding the DC-294 Discharge Agent.

Mixing Activator: The Excalibur Dye Discharge System is a two part system and will not work without the addition of DC-294N Formaldehyde Free Discharge Agent. It is recommended printers add 5% by weight of the powder to either the DC-2012 or DC-2018 and mix until completely dispersed. It is advised printers only mix the amount of final product which can be used within a 24 hour period.

Gel Temperature: Ink will surface gel at 240° F (116° C).

Curing: Excalibur Ink will fully heat cure and discharge dyes from suitable garment when the entire ink film reaches 320°F (160°C). Depending upon the type of dryer, temperature setting and the length of the curing chamber it could possibly take 1 ½--2 minutes to fully complete the discharge process and completely cure the entire ink film.

Ink Cleanup: All Excalibur Dye Discharge inks clean up easily with water.

Screen Mesh: For best results an 86-/156/inch (16T-60Tcm) mesh may be used.

Ink Modification: For ink drying too quickly in the screen up to 10% AQT 2594 Retarder may be added to retard drying. If ink viscosity is too thin it may be thickened by adding .5 -1% of TH 100 Thickener. Mix well and let sit for 10 minutes. If the ink needs to be reduced, small amounts of water may be added.

Squeegee: Medium Durometer (70) or Triple Durometer (90/70/90) is recommended.

Stencil: Water-proof stencils must be used to prevent premature screen breakdown. For long print runs a screen hardener may be necessary. Consult your dealer or emulsion manufacturer for correct stencil system.

Components: DC 1012 Discharge Base, DC 1018 Super Opaque White Discharge Base, DC 294N Discharge Agent, WA 392 Wetting Agent, TH 100 Thickener, AQT 2594 Retarder, Colour Tone Concentrate Pigments and PCW Waterbase Pigment Concentrates.

Caution

Always test finished prints for dischargibility curing, adhesion 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 or formaldehyde free if any additive other than an additive manufactured by Lancer Group International is used to modify this ink. Test results by a third-party laboratory verifying all components used to produce this ink are phthalate-free and lead-free is on file and available upon request.



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