STI Silicone Heat Transfer Ink System

EVOLUTION

LANCER GROUP INTERNATIONAL

STI7950 SILICONE HIGH OPACITY MIXING BASE

Lancer Group's STI7950 Silicone High Opacity Mixing Base is an opaque base that when mixed with Evolution Pigment Concentrates produces Pantone, STI7933 colours or custom colours. Even though this ink is opaque (except Glow-in-the-Dark) and bleed-resistant on many fabrics, for sub-dye polyester and other fabrics known for dye migration, it may be necessary to back this with STI7911 Defender Black Dye Blocker. Multiple coatings of direct emulsion, capillary films or a print/flash/print technique during printing may be needed to achieve desired effect.

STI7950 is part of the STI Silicone Heat Transfer System. Other components in this system that are necessary to produce silicone heat transfers are PET Film, STI7960 White, STI7940 Stretch Clear, STI7933 Colours, STI7941 Stretch Underbase, and T-1 Adhesive Powder**. Note: All components except T-1 Powder must be catalyzed prior to printing.**

Technical Information

Mixing Catalyst
STI7160 and STI7161—3 ½-5% by weight

A mixed colour made with STI7950 should only be catalyzed after the desired colour has been mixed.

NOTE—Amounts less than the minimum amount will result in a finished ink that may not cure properly. The amounts of catalyst mixed into the inks should be carefully weighed using a digital gram scale. STI7160 is a liquid that must be shaken vigorously before adding as contents may settle during storage. It is recommended that only the amount of ink that can be used in a four to six-hour period be mixed at any one time. Higher amounts of catalyst will diminish the pot life of ink more rapidly. Do not test for stretch and adhesion to fabric prior to 72 hours after transferring.

Printing Instructions

1. Print STI7940 Stretch Clear on PET Film. Completely Dry.
2. Print STI7950 mixed colour. Completely Dry.
3. Print STI7941 Stretch Underbase over entire design.
4. Sprinkle T-1 Powder over wet Stretch Underbase. Completely Dry.

Application to Substrate

Normal Fabrics
350°-375°F (175°-185°C) for 20 seconds or 325°F for 30 seconds.
Delicate Fabrics or 100% Polyester Fabrics
275°-280°F (140°C) for 30 to 60 seconds.

CAUTION

Always test finished prints for color accuracy, curing, adhesion, opacity, crocking, stretch and desired look prior to beginning full production runs. Lancer Group International cannot guarantee the results or back claims that this ink will test PVC-free or phthalate-free if any pigment or additive other than an Evolution Pigment Concentrate or STI component that has been manufactured by Lancer Group International is used in this ink. Contamination can also occur from mixing tools, mixing buckets, spatulas, squeegees, or flood bars that have had prior contact with inks containing PVC's or phthalates and these tools must be thoroughly cleaned before using with the STI Silicone Ink System.

TECHNICAL DATA

IDEAL FABRIC
100% POLYESTER PERFORMANCE WEAR FABRICS.

MESH
83-160/inch (32T-640T cm).

SQUEEGEE
70 durometer or 70/90/70 Triple Durometer.

STENCIL
Any PVC-free or phthalate-free emulsion compatible with plastisol inks.

CURING
250°-290° F (125°-147° C) for 1 ½ to 2 minutes after proper amount of catalyst has been mixed. See Technical Information.

PIGMENT LOADING
15% pigment load by weight is recommended and amounts over 20% will lead to curing problems.

ADDITIVES
STI7902 Viscosity Reducer in increments of 3-4% by weight maximum.

STORAGE
30°C/84°F in tightly closed containers.

CLEANING
Enviro Series TR Blend or Mineral Spirits.

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