

# 3D Series High Density Plastisol Ink

Outstanding HI-DENSITY PLASTISOL for most textile applications

Raised print effect achievable under low cure temperature

Excellent screenability; reliable print durability

Free of heavy metals, aromaticamines, formaldehyde derivatives

**STOCK, END-USE:** Cotton, 50/50 cotton/polyester blends, and some synthetics.

**DESCRIPTION:** Note: For printing on most textile substrates that require the attractiveness of a three-dimensional (3-D) print effect.

**Note: Pre-test on actual substrate before any full production run, for dye bleeding, adhesion, wash fastness and other desired effects.**

**FINISH:** Durable, soft-hand finish.

**COLORS:** Available in high-opaque and fluorescents. All colors are formulated using non-leaded pigments.

**SCREEN FABRIC:** Mesh counts between 15 and 86T monofilament polyester (6-34T European).

**STENCIL:** It should be made with Thick Capillary Film between 200 Micron and 1000 Micron. \*\*Special Instruction shall be provided by our technical support team.

**CURE/DRYING:** Heat-cure at approximately 320°F (160°C) for 1 to 1½ minutes (infrared heat recommended for use). **Note: Although puffed-up effect is rapidly achieved, highest level of durability is not obtained until the entire print reaches 320°F throughout. For a thorough cure, enough dwell time is needed for prints to reach the required temperature of 320°F (160°C). Excessive heat applied to 3D print will result in cracking of prints or unevenness.**

**Pretest to establish correct cure rate for every print requirement.**

**NOTE: Pre-test on actual substrate before any full production run, for dye bleeding, adhesion, wash fastness and other desired effects.**

**MODIFICATIONS:** 3D Series Plastisol is formulated for Ready To Use. To improve printability and sharp edge, RE703 Reducer can be added up to 5% by weight.

**SPECIAL INSTRUCTIONS:** When printing textiles, use a medium hard (70-75 durometer) squeegee. Printing slightly off-contact improves ink deposit and print quality.

**Plastisols respond to heat. Always store at temperatures below 90°F (32°C). Avoid exposing inks to elevated temperatures before printing.**

**CLEAN UP:** Use T-125 or CRS500 Biodegradable Washup.

**PACKAGING:** 1-gallon (3.78 Liters), 5-gallon (18.9 Liters) containers. Drums available in 30-gallon (113.4 Liters) and 55-gallon (207.9 Liters).

**SAFETY & HANDLING:** Refer to Material Safety Data Sheet (MSDS) for complete information.

**COLOR RANGE:** All colors are formulated using nonleaded pigments.

3D 015 Opaque White  
3D 021 Lemon Yellow  
3D 022 Chrome Yellow  
3D 023 Golden Yellow  
3D 024 Athletic Gold  
3D 026 Burnt Orange  
3D 032 Kelly Green  
3D 040 Lt. Royal Blue  
3D 041 Royal Blue  
3D 045 Navy Blue  
3D 049 Purple  
3D 056 Scarlet Red  
3D 058 Flag Red  
3D 071 Opaque Black

Other colors available upon request.

**MODIFIERS:**  
RE703 Quick Flash Reducer

**SOLVENT**  
T-125 Washup  
CRS500 Biodegradable washup



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