

## FEATURES

- 1199\* Stretch Ink Additive can be easily mixed into Multipurpose, 700 Series or 1100 Series plastisols to produce increased elongation for printing onto Lycra, Spandex and other types of stretch fabrics.
- 1199 is available in a Non-Phthalate (NP) version. To maintain the combined products (ink and additive) as non-phthalate, the 1199 additive should only be mixed into a Non-Phthalate ink.

\*Lead Compliant (Contains less than 90 ppm lead)

## Application & Storage Information

RECOMMENDED FABRICS	Lycra, Spandex and other stretch fabrics. Always test print fabric before a production run for adhesion and possible dye migration.								
INK APPLICATION	<p>Mixing of the 1199 additive into the ink may be done by volume or by weight. When mixing by volume, the ratio is 2 parts ink to 1 part additive. By weight the ratio is 3 parts ink to 1 part additive. <b>For opaque inks, mixing by weight is highly recommended for best results.</b> Sample formula:</p> <table border="0"> <tr> <td>Product</td> <td>Weight</td> </tr> <tr> <td>711 LF LB HP FF White</td> <td>240 Grams</td> </tr> <tr> <td>1199 LF Stretch Additive</td> <td><u>80 Grams</u></td> </tr> <tr> <td></td> <td>TOTAL <u>320 Grams</u></td> </tr> </table> <p>This formula will make ½ pint of opaque white stretch ink. To mix 1 pint of stretch ink, multiply the above formula by 2, for a quart, multiply by 4. Always mix the stretch additive thoroughly into the desired ink. Mixed ink has an indefinite shelf life when stored in a cool area.</p>	Product	Weight	711 LF LB HP FF White	240 Grams	1199 LF Stretch Additive	<u>80 Grams</u>		TOTAL <u>320 Grams</u>
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SCREEN MESH AND EMULSION	80 to 125 t/in or 36 to 56 t/cm Monofilament Any direct or indirect plastisol resistant emulsion. Use a 20 to 50 micron capillary film for best results.								
SQUEEGEE	65 to 70 Durometer: Sharp or beveled edge.								
CURE TEMPERATURES	325°F (163°C). Entire ink film must reach the prescribe temperature to insure proper ink durability. Some types of Lycra and Spandex do not absorb heat as quickly as other types of fabric. Increasing time and/or temperature in the dryer may be needed to achieve proper curing. Test dryer temperatures and wash test printed product before and during a production run.								
CLEAN-UP	Any environmentally friendly plastisol screen wash.								
PRODUCT PACKAGING	1 Gallon, 5 Gallon, or 30 Gallon Containers.								
STORAGE OF INK CONTAINERS	Recommend storage at 65°F to 90°F (18°C to 32°C). Avoid storage in direct sunlight. Keep containers well sealed.								
PRODUCT MSDS	Refer to material safety data sheet MSDS8.								

## IMPORTANT INFORMATION

1. 1199 Stretch Additive has been tested with International Coatings' inks. If the 1199 is used in combination with another manufacturers product, it is very important that proper testing be done to help insure performance and durability of the mixed ink.
2. 1199 is not a low bleed product and bleeding or dye migration may occur. Always test print the fabric to be printed before beginning production. Because bleeding or dye migration may not occur right away, it is best to do long term testing on some fabrics to determine if they are going to bleed.
3. Adding too much of the 1199 Stretch Additive to an ink can cause the mixed ink to be less opaque and less durable. If the ink needs to be thinned, use International Coatings 1110 NP Curable Reducer.

1199 Stretch Ink Additive

