



# COOL SPORT™ COLORS (6100 SERIES)



## RECOMMENDED FABRICS

100% Cotton  
50/50 Cotton/Polyester Blends  
Nonwoven Polypropylene Bags (NPB)



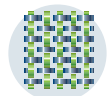
## INK APPLICATION

Cool Sport™ Colors should be printed without any modifications



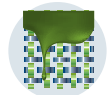
## ADDITIVES

If viscosity adjustment is necessary, use 1% to 3% by weight 1110 Curable Reducer or 1099 Low Bleed Curable Reducer for 50/50 garments



## SCREEN MESH

61-230 t/in (24-90 t/cm) monofilament



## EMULSION

Any direct or indirect emulsion or capillary film in the 35 to 70 micron range, depending on the opacity desired



## SQUEEGEE

65-70 Durometer  
Sharp edge



## CURE TEMPERATURES

275°F to 325°F (135°C to 163°C) entire ink film. Fusing at lower temperatures may require longer dryer retention times



## CLEAN-UP

Any eco-friendly plastisol screen wash



## PRODUCT PACKAGING

Quart, 1 gallon, 5 gallon, 30 gallon or 50 gallon containers



## STORAGE OF INK CONTAINERS

65° to 90°F (18°C to 32°C)  
Avoid storage in direct sunlight  
Keep containers well sealed



## SDS

Refer to SDS prior to use

## FEATURES

Cool Sport™ Color (6100 Series) direct print plastisol inks are newly reformulated using our proprietary CoolTech™ technology. The series features 13 bright, ready-for-use team-related colors.

CoolTech™ uses the same chemistry found in our popular Cool White™ (7022). CoolTech™ adds strength, elongation, and elasticity to inks, and the resulting ink is smooth, creamy and even in consistency. It prints beautifully on automatic and manual printers and enables Cool Sport™ inks to be printed on multiple substrates.

Cool Sport™ Colors are part of our expanding line of FlexCure™ screen printing inks. FlexCure™ offers a 'flexible' curing range - from a low 275°F/135°C to the standard 325°F/163°C.

## COOL SPORT™ COLOR INKS:

Contain a high pigment load for maximum coverage on dark garments, thus eliminating the need for under-basing.

Are suitable for printing on a variety of substrates including 100% cotton, 50/50 blends, non-woven polypropylene and some polyesters.

Can print through higher mesh counts on light-colored garments or can be reduced to obtain soft-hand, opaque prints.

## COLORS (IC SKU# | PMS EQUIVALENT)

<b>Yellow</b> 6153   102 C	<b>Red</b> 6161   199 C	<b>Athletic Gold</b> 6155   123 C
<b>Hot Pink</b> 6165   225 C	<b>Scarlet</b> 6159   485 C	<b>Burgundy</b> 6163   202 C
<b>Orange</b> 6157   021 C	<b>Purple</b> 6167   268 C	<b>Reflex Blue</b> 6173   Reflex Blue C
<b>Teal</b> 6169   327 C	<b>Navy Blue</b> 6175   282 C	<b>Process Blue</b> 6171   Reflex Blue C
<b>Black</b> 6177   Black 6 C		

## SPOT FLASHING

Cool Sport™ Colors will spot dry, with a very low after-flash tack. Dwell time is dependent on the spot dryer used. In some cases, you may have to lower the heat of the spot cure unit. Too much heat may make the ink tacky. When you spot dry, you are only partially fusing or gelling the surface of the ink. The ink should be just dry to the touch, with no lift-off, but not totally fused. Totally fusing any flashed color may cause inter-coat adhesion problems with inks printed on top of the flashed ink. Final fusing or curing should occur in the dryer.

## IMPORTANT INFORMATION

Cool Sport™ Color inks are NOT low-build inks; however, this does not mean that build-up will occur. 6100 Series inks may require flashing after 3 or 4 colors if printing a wet-on-wet design. Adding too much reducer or other additives to Cool Sport™ inks may cause problems with curing/fusing or increased dye migration.

Adding any reducers or additives can lower the bleed resistance, opacity, or increase cure times of ink. STIR the ink prior to printing on press and after adding reducers or additives.

Test dryer temperatures and wash-test printed product before and during a production run.

## LEGAL STUFF

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