

# Huizhou Yirun Silicone Co.,Ltd.

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### TDS of puff foaming silicone

#### Preparation:

- 1.Mesh&Squeegee: **120(48T)** Mesh number; **65-75** degree Squeegee.
- 2.Pigments added ratio: **For white and fluorescent color 20%,other color 10%**
- 3.Catalyst mixing ratio: **2%** slow dry XG-866B-1 and fast dry XG-866B-2 can mix together for using.
- 4.Thinner XG-128A adding ratio: **0-20%** thinner is not necessary for hand printing
- 5.Flash cure temp: **100°C- 120°C for 6-10 seconds**

#### Silicone ink printing tips:

##### 1. HD silicone XG-866A/866AH for under coating printing for 2-3 times :

HD silicone/soft silicone	XG-866AH/XG-866AR	60G		
Fast dry catalyst	XG-866B-2	1.2G	2%	If machine printing to use slow dry catalyst.
Silicone thinner	XG-128AH	6G	10%	(XG-866AH better to mix with 10% thinner)

Cure by temp of 120°C 6-10 seconds.

##### 2. Foaming Puff silicone printing for 3-4 times

Puff silicone XG-866ARP	60 G			
Fast dry catalyst XG-866B-2	1.2G	2%		
Color pigment		6G	10%	10%

Flash temp 100-120degree After finish to heat by 160-170 degree for 2-3 minutes or heat press by heat press machine 165-170degree for 12-16 seconds