

## Huizhou Yirun Silicone Co.,Ltd.

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### TDS of transfer silicone XG-360W-2 printing

#### Silicone ink PET films:

Two types: one is glossy coating film which will be glossy after heating press on fabric, another one is matte finish effect after heating press on fabric.

**Mesh number:** 120-200, Mesh (screen film) thickness 0.1-0.2MM, it depends on printing Artworks.

Squeegee: 65-80 degree.

#### Printing tips:

**1. For transfer silicone printing we have two types of transfer silicone, one is XG-360W-2, catalyst 360B mixing ratio 10% flash by temp 100 degree, another one is XG-866A-2Y, catalyst XG-866B-2 mixing ratio 2-3% flash by temp 200 degree:**

**A 1st** solution, color transfer silicone layer print 4 + layers:

Transfer silicone	XG-360W-2	100G	
Silicone Pigments		10-20G	(10-20% white&fluorescent 15-20% other colors 10%)
Silicone catalyst	XG-360B-2	10G	10%
Silicone thinner	XG-128AH	10-20G	10-20%

**Flash by 100 degree. If need high density then print more layers**

**B 2<sup>nd</sup>** solution, color transfer silicone layer print 4 + layers

Transfer silicone	XG-866A-2Y	100G	
Silicone Pigments		10-20G	(10-20% white&fluorescent 15-20% other colors 10%)
Silicone catalyst	XG-866B-2	2-3G	2-3%

Silicone thinner              XG-128AH              10-20G              10-20%

**Flash by 120 degree. If need high density then print more layers**

2. Crossing linker print for 2 layers:

Crossing linker              XG-360Z-3X              50G

Crossing linker catalyst              XG-866B-2              2.5 G              5%

**Flash by 100 degree.**

3. Hot melt glue XG-360R-2 print for 4-6 layers.

To use **cyclohexanone** to liquid the glue, mixing ratio 10%, if glue to be thick and choke the mesh screen

Flash by room temp or by 80-100 degree.

4. After finish, put into the oven to bake by 100 degree for 30 minutes.

5. Heat press the sticker on the heat transfer press machine by the temp of 160-170 degree for 10-16 seconds under pressure of 4KG.

**TIPS:Kindly doing test before productions every time.**

If any questions kindly contact with Belinda +86 18319607489 whatsapp&wechat the same number.