

# Technical data sheet

# TEXTIL PHW-HV

## APPLICATIONS

Garment printing with plastisol ink, glitter printing, high-density printing.

## GENERAL CHARACTERISTICS

- Green pure photopolymer emulsion for thick stencil production
- Thanks to its high solids content (51%) and very high viscosity can produce 3000 micron stencil thickness with simple and shorter coating procedure.
- Exposes 10 times faster than diazo or dual-cure emulsions
- Resistant to plastisol inks, water and high humidity
- Optimum elasticity.

## DIRECTIONS FOR USE

Handle under yellow safelight or low wattage tungsten lights. Avoid exposure to daylight, quartz/halogen lamps, cool white fluorescent lamps or discharge lamps.

### Sensitizing and mixing

Emulsion is pre-sensitized during production and does not require mixing.

### Mesh preparation and degreasing

Degrease and abrade new mesh with Direct Prep 1 (abrasive gel) in order to optimize stencil adhesion; dry and store the screen in a dust free, dry environment prior to coating. For further applications, thoroughly degrease the mesh prior to use with Direct Prep 2 (degreaser).

### Coating

Using a high quality scoop coater or coating through, apply one or two coats to the substrate side of the screen, followed by more coats on the squeegee side. For a thicker stencil, apply additional coats to the squeegee side prior to drying. See table nr. 1 for coating thickness guidelines.

### Drying and storage

Thoroughly dry the coated screen at a maximum temperature of 104°F (40°C) in a dust free, dark or yellow light area, with the substrate side facing down to optimize stencil quality. Coated screens should be stored in a dust free, dry, safelight environment.

### Exposing

Ensure that all surfaces (emulsion, film and glass), are free of dust to minimize pinholes. Contact the emulsion side of the positive with the substrate side of the screen and secure in position before placing the screen in a suitable vacuum frame. Many variables, such as lamp type and age, distance from lamp to screen, mesh type and coating thickness, can affect exposure time.

### Developing

Wet both sides of the screen with a strong, finely divided spray of water and continue washing out until all image areas are fully open. For high thickness screens, the use of a high pressure washing system is recommended to help the development, working on print side only. The spray has not to reach the engraved screen.

Rinse both sides of screen and dry thoroughly before use. A properly exposed and developed screen will not have residue on the squeegee side.

### Post exposing

Post expose with daylight or exposure halogen lamp to produce a water-resistant stencil.

### Reclaiming

Remove all ink residues immediately after printing with an appropriate solvent. Remove stencil with Remove ER1, ER2, ER4, ER5 or ER10 and a pressure washer. For stains and ghost images, use Remove HR3 followed by a pressure washer.

**HEALTH AND SAFETY**

Before using, refer to appropriate material safety data sheets.

**PROBLEM SOLVING**

**Poor coating quality**

- Properly clean, degrease and rinse the screen to remove all residues and traces of chemicals
- Properly and evenly tension the fabric
- Clean and ensure the scoop coater does not present any defect edge.

**Poor detail or difficulty washing out image**

- Ensure emulsion and coated screens are handled in safelight conditions only
- Ensure a minimum vacuum of 0.66 bar (500 mmHg or 20 in Hg) on vacuum gauge for optimum contact of the positive
- Optimize exposure time and use only high quality film positives
- Do not store emulsion or coated screen at high temperatures.

**Emulsion falls off, extreme pinholes or severe stencil breakdown during printing**

- Ensure that damp screens are not being exposed
- Only expose screens with an even and consistent coating thickness
- Ensure that stencil has not been severely underexposed
- Ensure emulsion has not been stored at high temperature.

**Difficulty reclaiming screens**

- Not reclaimable once catalyzed
- Optimize exposure time and properly rinse the squeegee side of the screen during developing to remove all residual traces, especially when using higher mesh count dyed fabric.

**STORAGE**

When sealed in the original container and stored at temperature between 20 and 25°C, TEXTIL PHW-HV will maintain original properties for 24 months from the date of production.

**PACKAGING**

Available in 1, 5 and 200 kilogram containers. In North America, available in one, five and fifty US gallon containers.

Table 1. Emulsion over mesh build-up (microns) with various coating methods.

Mesh (threads/cm)	Mesh (threads/in)	2+2	2+3	2+4	2+5	2+6	2+7	2+8	2+10	2+12
43.80 pw	110.80 pw	40	75	100	135	160	185	220	260	300
34.100 pw	86.100 pw	40	80	110	145	180	220	260	290	350
32.70 pw	81.70 pw	70	140	240	300	360				
24.120 pw	61.120 pw	50	95	150	210	250	280	320	390	

**WARRANTY AND LIMITED REMEDY**

The directions, recommendations and specifications contained in this Technical Data Sheet are meant as a guide to the use of the product and shall not bind the company. Product specifications are subject to change without notice.

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The remedies are exclusive. In no case shall Saatichem be liable for any other direct or indirect damage or loss, including without limitation any incidental, special or consequential damages, or any material costs or labor charges incident to the removal or replacement of any mesh, screen, ink, substrate, finished graphic or any other item.

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