

## UV LED Waterslide Transfer Ink 3275

### Technical Data Sheet

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**Smiley 3275** has been formulated to cure with a LED curing system with wavelength emission of 395 nanometers and minimum output of 16 watts. The ink is designed for many different types of substrates such as bicycle body, golf shaft, badminton racket, helmet, surfboard etc.

- Excellent adhesion on coated and un-coated metal substrates
- Low-odor
- Semi-gloss finish
- Good ink flexibility
- Good adhesion with PU lacquer for overspray

**Substrates:** Waterslide transfer paper

### USER INFORMATION

**Mesh:** Print the 3275 inks through 90-120 mesh/cm, monofilament polyester fabric, depending on the application. For 3275-800 UV LED Adhesive, use 77 mesh/cm.

**Stencil:** Solvent resistant emulsions  
Recommended:  
6060-223B Dual Cure Graphic Emulsion

**Squeegee:** 85-90 durometer hardness polyurethane squeegees.

**Pre-Production Test:** Always pretest adhesion and application before each production run, as there can often be significant differences between substrates from different manufacturers and even between different batches of substrates. Pretest to determine optimum printing performance for a particular set of ink, substrate, screen, press, and drying variables/conditions.

**Printing:** Maintain ink temperature at 65°-90°F (18°-32°C) for optimum print drying performance. Lower temperatures increase the ink viscosity, impairing both flow and drying. Elevated temperatures lower the ink viscosity, reducing print definition and film thickness.

Printing Process:

- Mix Dilute 3275-20064 = 5-10% to reduce the viscosity if needed
- Print 3275 waterslide transfer ink onto waterslide transfer paper using mesh no. 90-120 mesh/cm.
- 3275 Series cures when exposed to UV LED curing unit
- Cure @ 16 watts/cm<sup>2</sup> or higher watts, wavelength emission of 395 nanometers
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- Print 3275-800 UV LED Adhesive overlapping the ink using 77/cm mesh. 3275-20064 can be used to dilute the adhesive.
- Cure @ 16 watts/cm<sup>2</sup> or higher watts, wavelength emission of 395 nanometers
- 3275-4964 can be used to increase the curing speed, Add up to 5-10% by weight

Transferring onto the Substrate/Decals Realization:

- Soak the ready-made decal in water for 3-5 minutes so as to separate the decal from paper support on which it has been printed.
- Put or slide the printed image from water slide transfer paper onto the substrates.
- Use a small squeegee to release the air bubble and make a smooth ink film surface.
- Final cure @ 90°C for 30 minutes for glass, ceramic, metal substrates.
- A clear spray varnish can be used to apply on the top if needed.

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**Thinning and Wash-up:** **Dilute:** 3275-20064 can be used to reduce the ink viscosity. Add up to 5-10% by weight.  
**Wash-up:** Use 4050-003 Screen Wash and Cleaner.

### GENERAL INFORMATION

#### Handling & Storage:

- **Smiley 3275** is formulated free of lead and other heavy metals.
- It is recommended to wear suitable protective gear such as glasses and gloves. Take particular care to avoid splashes into the eyes and skin contact. If the ink comes in contact with skin, wash with soap and plenty of water. If ink comes in contact with eyes, wash with plenty of water and consult with a doctor.
- Comprehensive information on the safety and handling of Smiley 3275 screen inks and thinners is given in the appropriate Smiley Material Safety Data Sheet (MSDS), which are available upon request.
- Store tightly covered at temperatures between (18° - 25°C). Can be stored for 1 year under these conditions.
- Tins should be kept tightly closed when not in use.

#### Environmental Information:

- Do not contain ozone depleting chemicals.
- **UV LED Waterslide Transfer Ink 3275** should be disposed properly (see MSDS) and in accordance to local regulations to avoid contamination.

#### Recommended Stencil Making Products:

- Screen Preparation
  - Mesh Preparation 6050-300 – for abrasion
  - Mesh Degreaser 6050-200 – for degreasing
- Screen Emulsion
  - Dual Cure Graphic Emulsion 6060-223B
- Screen Cleaning
  - Ghost Remover 6070-100
  - Stain Remover 6070-001
- Screen Reclaiming
  - Stripping Powder 6070-200

### PRODUCT OFFERING:

**Packaging:** 3275 is available in 1 Kilo, 5 Kilos and 20 Kilos containers.

### ADDITIONAL INFORMATION

For additional product information, please visit our website at <http://www.smiley.co.th>. For further information, please contact SPS personnel at [medhi@smiley.co.th](mailto:medhi@smiley.co.th).

Thank you for choosing **SMILEY**.

Smiley Printing Solution Co., Ltd. (SPS), abides by the quality of this product. The information and recommendations that embody this Technical Data Sheet along with the technical advice are based solely on our knowledge and therefore confident to be precise. This product has been specifically formulated for screen printing. SPS cannot guarantee the precision for other possible application for the reason that manufacturing methods and other materials vary. Any liability amalgamated with the use and application of these products, users are the sole bearer of responsibility for choosing appropriate product for end-users' requirement. This Technical Data Sheet is provided for the technical purpose in the usage of this product and users are expected to follow current recommendation.