

Smiley 3094-004 peelable overprint varnish is the medium for transferring the decal from the water slide transfer paper to the substrate to be decorated. It allows obtaining decals having a lower thickness, which assure a better incorporation with the substrate to be decorated.

- Good adhesion

Substrates: Waterslide transfer paper

USER INFORMATION

Mesh: 3094-004 Peelable Overprint Varnish, use 24 mesh/cm.

Coverage: 11-12 M² /Kilo (24 mesh/cm) depending upon ink deposit.

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, overprint varnish, substrate, screen, press, and drying variables/conditions.

Printing:

Printing Process:

After printing with 3094 or 3095 Water Slide Transfer Ink

- Print 3094-004 peelable overprint varnish overlapping the ink using 24/cm mesh. Thinner SPS60006 can be used to dilute.
- Cure @ 60°C for 5 minutes OR at room temperature for 24 hours.

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.
- Cure @ 100-150°C for 30 minutes for glass, ceramic & metal and 60°C for 5 minutes for plastic substrates.
- Peel off the peelable OPV using a thin plastic sheet.
- Slowly pull-off the OPV from the substrate.
- A clear spray varnish can be used to apply on the top if needed.

Thinning and Wash-up: Thinner: SPS60006 must be used to reduce the ink viscosity. Add up to 10-20% by weight.

Wash-up: Use 4050-003 Screen Wash and Cleaner.

GENERAL INFORMATION

Handling & Storage:

- **Smiley 3094-004** 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 3094-004 overprint varnish 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.
- **Peelable OPV 3094-004** should be disposed properly (see MSDS) and in accordance to local regulations to avoid contamination.

PRODUCT OFFERING:

Packaging:

3094-004 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

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.