

## Waterslide Transfer Ink 3095 Solvent-based Ink

### Technical Data Sheet

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**Smiley 3095** is designed for many different types of substrates such as bicycle body, golf shaft, badminton racket, surfboard etc. It is a solvent based ink suitable for machine and manual printing.

- 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 3095 inks through 90-120 mesh/cm, monofilament polyester fabric, depending on the application. For 3094-004 Peelable Overprint Varnish, use 24 mesh/cm.

**Stencil:** Solvent resistant emulsions  
Recommended:  
6060-216 Dual Cure Graphic Emulsion

**Squeegee:** 70-75 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 Thinner SPS60025 = 10-20%
- Print 3095 waterslide transfer ink onto waterslide transfer paper using mesh no. 90-120 mesh/cm.
- Cure @ 60°C for 15 minutes OR at room temperature for 2-3 hours.
- Cure after each layer of ink printed onto the other with the same temperature and time
- Print 3094-004 peelable overprint varnish overlapping the ink using 24/cm mesh. 4030-0624 Thinner for Peelable OPV can be used to dilute.
- Cure @ 60°C for 15 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 @ 60°C for 15 minutes
- Peel off the peelable OPV using a thin plastic sheet. Slowly pull-off the OPV from the substrate.
- Final cure @ 150°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:** Thinner: SPS60025 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 3095** 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 3095 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.
- **Waterslide Transfer Ink 3095** 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 6060-216
- Screen Cleaning
  - Ghost Remover 6070-100
  - Stain Remover 6070-001
- Screen Reclaiming
  - Stripping Powder 6070-200

### PRODUCT OFFERING:

**Packaging:** 3095 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.