



Texopaque Classic OP Plastisol Inks

PART OF THE TEXOPAQUE SERIES OF INKS

Texopaque Classic OP is part of the Texopaque Series of direct printing, maximum opacity, plastisol inks designed for printing most natural and synthetic fabrics. The series incorporates Fujifilm's unique 'Co-Plus' Technology that eliminates build-up. Texopaque Classic OP are conventional plastisol inks. The Texopaque Series also includes a phthalate compliant option – Advantage ON and Pioneer Ultra YC, a PVC free and phthalate compliant plastisol (see the respective product information sheets for details).

Curing Information

Texopaque Classic OP inks must be heat cured at a minimum of 160°C to achieve full wash fastness. Differences in film weight, drying equipment and fabric will greatly affect the dwell time required, but 1.5 - 3 minutes is typical. Some infra-red units can achieve full cure in a very short time. Time will vary dependant on colour (dark colours curing faster than light colours).

It is essential that the entire thickness of the ink film has time to reach the cure temperature or resistance properties will not be achieved. Evaluate your cure schedule by testing the print at the wash schedule it will ultimately be expected to pass.

Flash Curing:

Many factors affect the dwell time required for flash curing. These include the type and wavelength of the equipment used and the distance between the curing unit and the print. Additional factors such as fabric and ink colour, film weight and coverage are also crucial. Under optimum conditions, dwell times of less than 3 seconds can be readily achieved.

Fastness

Texopaque Classic OP has good wash fastness to I.S.O. Test Nos. 1 (40°C), 2 (50°C) and 3 (60°C).

Colour Matches:

It should be noted that the combination of high wash temperatures and strong detergents can cause colour changes in some colour matches, particularly when very small additions of a base colour are added. For example, pastel shades can change colour as the trace additions of base colours are affected in harsh wash cycles. For this reason, it is essential that all formulations are proofed prior to production to ensure wash fastness properties are acceptable.

Prints may be ironed from the back of the fabrics at a cool setting, with a cloth over the printed area. **Prints will not resist dry-cleaning and garments should be marked to this effect.**

Main Characteristics

Co-Plus - what is it?

The interaction of specially engineered raw materials, optimising their internal cohesive forces, to eliminate build-up.

What does it mean for you?

- No build-up - improves productivity
- Excellent opacity - high impact prints
- Low fibrillation - prints look better - longer
- Soft gel - easy to handle - on and off screen
- Soft hand - prints are comfortable to wear



Intermixing and Compatibility With Other Inks

Texopaque Classic OP is intermixable with other Fujifilm plastisols where the presence of phthalate plasticisers is not an issue.

Curing

The ink film must reach 160°C.

Thinning

To increase flow, use up to 5% ZE591 Plastisol Flow Thinner.

Wash-up

Wash up with ZT639 Screen Wash Universal, ZS640 Tursub or Actisol Superjet Screen Spray.

Mesh

Monofilament Nos. 34-100

Stencil Type

Most direct stencil materials are suitable.

Recommended:

Dirasol 916 or Dirasol SuperTex

Coverage & Mesh No.

12-16m²/ltr. No. 43 monofilament.

Applications

Most knitted and woven fabrics typically used for T-shirts, Sweat Shirts, Sports and Fashion Wear, Badges, Hats and Caps, Travel Bags, Footwear.

Fabrics

Suitable on most common, natural and synthetic, fibres, i.e. Cotton, Cotton/polyester blends. Many grades of synthetic fabrics.

Colour Range

PANTONE®* 1000 Matching Formulae available.

Properties

Exceptional opacity. Lead-free. Excellent wet-on-wet printability. Unlimited screen stability. High wash resistance. Build-up free.

IMPORTANT: Stir well before every use. Users should satisfy themselves that Texoplaque Classic OP is compatible with specific textiles and resistance properties are acceptable before commencing production runs.

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Fibrillation

Fibrillation occurs when fibres from the garment break through the ink film during a wash cycle to give a faded appearance. While fibrillation has the look of poor wash fastness it is not caused by the loss of ink, it occurs even with fully cured prints. There are several methods to minimise fibrillation, however, each results in increased print handle:

- Increase ink film weight
- Use a flash-cure ground coat
- Add 5% of EZ444 Nylon Catalyst

As demand for low handle/low film weight prints increases, so does the likelihood of fibrillation. The complex relationship of ink, print technique and garment, reinforces the need to wash test prints to customer requirements prior to production.

Transfer Printing

For transfer printing please refer to 'Textile Transfer System' Product Information Sheet.

PANTONE® Matching System

The Texopaque Classic OP range includes 10 Seritone base colours plus Black, White and Extender Base to produce accurate simulations of the PANTONE colours in the coated ('C' suffixed) section. See section 'Fastness' for important information concerning resistance properties of colour matches.

The Fujifilm package includes:

1. **PANTONE® Color Formula Guide**
2. **Fujifilm Formula Guide**
A booklet containing formulations given in percentages by weight.
3. **Color Manager Software**
For use with IBM compatible computers. This package enables use of the PANTONE formulations plus:
 - Storage facility for user's own formulations.
 - Automatic batch sizing and costing.
 - Ink coverage estimator.
 - Stock control system to calculate the amount of stock and a reminder when stocks fall below a chosen (programmable) level.
4. **PANTONE Formula Scales**
Preprogrammed with the Fujifilm formulations of PANTONE references to ensure maximum accuracy, speed and cost savings.

Colour Range

Texopaque Classic OP

OP001	(S)	Black
OP021	(S)	White
OP025		Super Opaque White
OP042	(S)	Seritone Yellow (Green Shade)/Light Chrome
OP045		Yellow
OP043	(S)	Seritone Yellow (Red Shade)/Mid Chrome
OP101		Light Orange
OP162	(S)	Seritone Orange/Light Red
OP165	(S)	Seritone Magenta
OP166	(S)	Seritone Violet

OP199		Warm Red
OP134	(S)	Seritone Red (Yellow Shade)/Red
OP124	(S)	Seritone Red (Blue Shade)/Deep Red
OP227		Light Blue
OP203	(S)	Seritone Blue/Mid Blue
OP212		Blue
OP206	(S)	Seritone Blue (RS)/Deep Blue
OP207		Navy Blue
OP283		Bright Green
OP320		Green
OP285	(S)	Seritone Green/Deep Green

(S) = Seritone Base Colour

Available in 5 and 1 ltr containers.

OP381 Extender Base

Available in 5 ltr containers.

Super Opaque White does not share the build up resistance of the standard colours.

Thinners/Reducers

ZE591	Plastisol Flow Thinner
ZS640	Tursub

Available in 5 ltr containers.

Flash Cure Whites

For details and comparisons of Flash Cure Whites, see the 'Flash Cure Whites' Product Information Sheet.

Trichromatic Inks

For details and comparisons of the plastisol trichromatic ink ranges, see the 'Special Plastisol Inks and Additives' Product Information Sheet.

Special Purpose and Special Effect Inks

A range of special purpose and special effect plastisol inks such as Metallics and a range of additives and modifiers such as catalysts, etc. is available. See the 'Special Plastisol Inks and Additives' product information sheet for details.

Ancillary Products

During printing, fabrics have to be held to the table by means of a pressure sensitive adhesive to ensure good definition is obtained. FlashFix and T-Fix Extra Spray Adhesives are suitable for this purpose. (See relevant Product Information Sheets)

Fujifilm Speciality Ink Systems Limited:

- Has certification to the International Environmental Standard, ISO 14001
- Is committed to minimising the risk to users of our products, and also to minimising the impact of our activities on the environment, from formulation through to production and supply.
- Research & development team, work to an in house Health, Safety and Environmental policy, termed 'Design for Health, Safety and Environment', with the aim of proactively developing products with the least impact on health, safety and the environment.
- Regularly review and monitor our impacts and activities, setting objectives and targets as part of a continual improvement process.
- Is committed to reducing waste through better use of raw materials, energy, water, re-use and recycling.

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Safety and Handling

Texopaque Classic OP:

- Is formulated to be free from any chemicals toxic to health, carcinogenic, mutagenic or reprotoxic according to Directive 67/548/EC.
- Is formulated free from lead and other heavy metals and is tested to comply to the EN71-3: 1995 Toy Safety Standard.
- For optimum shelf life, all products should be stored at moderate temperatures, between 5°C and 30°C. Storage outside of these temperatures may lead to deterioration in the performance of the product.

Comprehensive information on the safety and handling of Texopaque Classic OP screen inks and solvents is given in the appropriate Safety Data Sheets.

Environmental Information

Texopaque Classic OP:

- Does not contain ozone depleting chemicals as described in the Montreal Convention.
- Is formulated free from aromatic hydrocarbons.
- Is free of any volatile solvent and can therefore be considered to have less impact on the environment, when compared with solvent-based products.

Öko-Tex Standard 100

Contact your Fujifilm supplier for the latest information concerning the compliance of Fujifilm inks.

The information and recommendations contained in this Product Information sheet, as well as technical advice otherwise given by representatives of Fujifilm Speciality Ink Systems Limited and its associated companies, whether verbally or in writing, are based on our present knowledge and believed to be accurate. However, no guarantee regarding their accuracy is given as we cannot cover or anticipate every possible application of our products and because manufacturing methods, printing stocks and other materials vary. For the same reason our products are sold without warranty and on condition that users shall make their own tests to satisfy themselves that they will meet fully their particular requirements. Our policy of continuous product improvement might make some of the information contained in this Product Information sheet out of date and users are requested to ensure that they follow current recommendations.

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