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TDS of 3D silicone heat transfer logo printing

How to print high density brush silicone stickers. 3D silicone brush transfer logo

printing tips:

Matte PET films or Teflon paper:

Mesh number: 120-200 , Mesh(screen film)thickness 0.1-0.2MM,it is depends on printing Artworks.

Squeegee: 65-80 degree .

Printing tips:

1. Transfer hot melt glue XG-360R-2 or XG-360R-3 print for 8-10 times

When printing glue to use **cyclohexanone** to liquid the glue,mixing ratio 10%.This type of glue easy to be thick and mesh printing.

Flash by room temp or by 100-120 degree.

2. Mid layer Transfer silicone crossing linker printing for 2 times:

Crossing linker XG-360Z-3X 50G

Catalyst XG-866B-2+ 2.5G 5%

Flash by 100 to120 degree.

3. Transfer silicone ink clear layer printing 4 -6 layers:

Silicone ink XG-866A-2Y 100G

Catalyst XG-866B-2 3 G 3%

Thinner XG-128AH 10-20G 10-20%

Hot melt glue with solvent chemicals so will get silicone ink not easy to dry ,if need fast dry then can mix with more catalyst.

Flash by 100 to120 degree.

For high density stickers,if need more high density then print more times clear.

4. Transfer silicone ink color print for 2-4 layers :

Silicone ink	XG-866A-2Y	100G	
Pigments or special powders		10-20G	(10-20% white&fluorescent 15-20% other colors 10%)
Catalyst	XG-866B-2	3G	3%
Thinner	XG-128AH	10-20G	10-20%

5. Transfer silicone for brush print for about 20 layers.

Silicone ink	XG-866A-2Y	200G	
Color pigments	XG-series	10-40G	white and fluorescent color 20% others 10%
(If need color brush effect)			
Fast dry catalyst	XG-866B-2	6G	3%
Thinner	XG-128AH	40-60G	20-30%

Cure by temp of 120°C 6-15 seconds.

Tips for silicone brush printing:

- After 3 times brush printing should add 10% more thinner and print by pulling printing
- Need more thinner liquid silicone ink full coating on the screen.
- Mixing more ink and make sure ink coat the screen when printing brush.
- Print very soft to get more ink drop though the mesh and pull up the screen to get high density.

6. After finish, put into the oven to bake by 100 degree for 30 minutes .

7. Heat press the stick on the heat transfer press machine by the temp of 160-170 degree for 10-16 seconds with pressure of 4KG.

TIPS: Kindly doing test before the bulk goods printing every time.

If any questions kindly contact by Cell: +86 18319607489 wechat&whatsapp the same number