



## RECOMMENDED PARAMETERS

### Fabric Types



100% Cotton, blends or synthetic fabrics.

### Mesh



Count: 60- 86T/in (20-34T/cm)  
Tension: 18-35n/cm<sup>3</sup>

### Squeegee



Durometer: 60-90-60  
Profile: sharp, square  
Stroke: x2 stroke, medium speed  
Angle: 15-20%

### Stencil



Water Resistant Emulsion  
Off Contact: 1/16" (2mm)  
Emulsion Over Mesh: 15-20%

### Flash & Cure



Flash: Not recommended  
Cure: 90 seconds at 330°F (165°C)

### Pigment Loading



Maximum 6%

### Aquarius™ Additives



Aquarius™ Softener 1-5%  
Aquarius™ Thickener 0.1-1%  
Aquarius™ Retarder Gel 1-5%

### Storage



Store in sealed containers 12 months from manufacture >40°F (5°C) <77°F(25°C)

### Clean Up



Water & mild detergent

### Health & Safety



Find SDS information here:  
[www.avient.com/resources/safety-data-sheets](http://www.avient.com/resources/safety-data-sheets) or contact your local CSR

Aquarius™ Metallics are ready to use metallic print pastes available in Silver and Gold.

## HIGHLIGHTS

- Excellent wash durability
- Produces metallic effects
- Print directly to fabric for best effect

## PRINTING TIPS

- Ready to use, but can be tinted with Aquarius™ Pigments up to 6%
- Use 60- 86T/in (20-34T/cm) mesh
- Print with 1/16" or 2mm off contact
- Print two strokes to ensure the mesh is clear and you have a good ink deposit
- Print in last position or flash after each metallic print if using multiple screens
- Clean the stencil area when stopped to prevent screen blockages
- Prints should be cured at 330°F /165°C for 90 seconds. Check the cure temp at the ink surface
- Test all prints for color fastness and print durability before starting the production run

## COMPLIANCE

- Water based, non PVC, non phthalate
- Visit [www.avient.com/products/screen-printing-inks/zodiac-aquarius](http://www.avient.com/products/screen-printing-inks/zodiac-aquarius) for more information

## PRECAUTIONS

- The information above is given in good faith and does not release you from testing inks and fabrics to confirm suitability of substrate and application process to meet your customer standards and specifications



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