

## IcoTex Nylo PE

One/Two packing Screen Printing Inks

Issue No. 008/2019

**IcoTex Nylo PE** screen inks are specially for direct printing onto nylon bags, polyester fabric labels and synthetic fabrics – including many which have been treated for water resistance.

### PE Catalyst

**IcoTex Nylo PE** inks can be used as a simple one-pack system but for more demanding requirements, **PE386 IcoTex Catalyst** is available to improve adhesion and fastness properties.

Catalysed inks have a pot life of approximately 8 hours. Estimate the amount of ink required for a day's work and thoroughly mix the ink base and catalyst in the following ratio:

<b>IcoTex Nylo PE Ink</b>	90 parts by weight
<b>IcoTex Catalyst</b>	10 parts by weight (90% + 10%)

**Catalysed ink left over at the end of the printing run must be discarded.**

### Adhesion

**IcoTex Nylo PE** inks have good adhesion and flexibility on many fabrics which have been treated for water resistance. Some fabrics may be finished or impregnated with certain waterproofing agents that may impair adhesion, even a considerable period after printing.

For maximum adhesion, it is recommended to catalyse the ink before use. Where lower opacity is tolerable, further improvements to adhesion may be achieved by printing at a lower viscosity to aid penetration into the fabric.

**In some cases, incompatibility between ink and fabric may lead to reduced tear resistance in the printed area - especially if uncatalysed ink is used on very lightweight fabrics**

### Fastness

Uncatalysed inks have excellent wash fastness to I.S.O. Test No. 1 (40 °C).

Catalysed inks have excellent wash fastness to I.S.O. Tests Nos. 3 (60 °C) and 4 (95 °C).

The fastness properties will vary depending on the fabric and whether catalysed or uncatalysed ink is used.

### Workwear Emblems

Catalysed **IcoTex Nylo PE** inks can be used to produce durable workwear transfers or badges capable of withstanding high temperature industrial wash processes.

### Main Characteristics

#### Properties

- High Opacity.
- Good Flexibility.
- Excellent Adhesion.
- Excellent wash Fastness.
- Lead-free Pigmentation.

#### Drying

- Air dry: 30-60 minutes followed by racking overnight.
- Convection oven, infra-red or heated wicket conveyor dryer: 100 °C for two minutes.

#### Thinning

For maximum opacity, print unthinned.

If necessary, thin with up to 10% **ZVC557HF** Standard Thinner  
For extreme hot shop conditions, add up to 10% **ZV558** Retarder.

#### Wash-up

Wash up with **ZTC639** Screen Wash

#### Mesh

For optimum opacity: Nos. 34-62 monofilament mesh.

For fine detail: Nos. 77-100 monofilament mesh.

#### Stencil Type

Most solvent resistant.

#### Recommended:

**Dirasol 915**

#### Coverage & Mesh No.

Up to 26m<sup>2</sup>/Ltr. No. 62 monofilament mesh

#### Colour Range

14 Intermixable Colours

**IMPORTANT: Stir well before every use. Users should satisfy themselves of inks and fabric compatibility to ensure adhesion and fastness requirements are met by testing under production conditions, prior to commencing a full production run.**

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### Colour Range

**IcoTex Nylo PE:**

PE001	Black
PE021	White
PE042	Light Yellow
PE043	Yellow
PE045	Mid Yellow
PE101	Orange
PE124	Red (YS)
PE134	Red (BS)
PE154	Magenta
PE127	Violet
PE212	Blue
PE227	Light Blue
PE320	Green
PE381	Extender Base

Available in 5 Ltr containers

**Additives:**

PE386 Catalyst

Available in 1 Ltr containers

**Solvent:**

ZVC557HF Standard Thinner

ZV558 Retarder

Available in 5 Ltr containers

### Safety and Handling

**IcoTex Nylo PE:**

- Are formulated to be free from any (toxic) carcinogenic, mutagenic or reprotoxic chemicals.
- Are formulated free from lead and other heavy metals.
- Should be stored away from heat.

**IcoTex Catalyst PE386:**

- Contains isocyanate and should not be used by persons suffering from bronchitis or asthmatic symptoms.

**IcoTex Nylo PE & IcoTex Catalyst:**

- Have a flashpoint greater than 61°C and are not classified as a 'dangerous substance' under the Dangerous Substances and Explosive Atmospheres Regulations (DSEAR)

Comprehensive information on the safety and handling of IcoTex Nylo PE screen inks and solvents is given in the appropriate ICONINKS Safety Data Sheet, available upon request.

### Environmental Information

**IcoTex Nylo PE & IcoTex Catalyst:**

- Does not contain ozone depleting chemicals as described in the Montreal Convention.

The information and recommendations contained in this Product Information sheet, as well as technical advice otherwise given by representatives of our Company, 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.

#### ICONINKS LIMITED

**Hong Kong**  
**ICONINKS LIMITED**  
 Unit B, 12/F., Reason Group Tower,  
 No. 403 Castle Peak Road,  
 Kwai Chung, N.T., Hong Kong  
 Tel: +852 2426 6121  
 Fax: +852 2420 4230  
 Email: sales@hk.iconinks.com

**China**  
**ICONINKS (Nanjing) Co., Limited**  
 Rm. 916, Baoyuan Huafeng Economic. Hq. Building  
 Xixiang Avenue, Xixiang Street  
 Baoan Area, Shenzhen, P.R. China.  
 Zip Code: 518102  
 Tel: +86 755 2736 8101, +86 755 2736 8139  
 Fax: +86 755 2736 8073  
 Email: sales@iconinks.com

**Australia**  
**Icon 21**  
 30/4a Bachell Ave,  
 Lidcombe NSW 2141,  
 Sydney, Australia  
 Tel: +61 0418 474908  
 Mobile: +61 02 90296018  
 Email saeed@autofilm.com.au

**Germany**  
**ICONINKS GmbH**  
 Turnhallenweg 7a  
 74858 Aglasterhausen  
 Germany  
 Tel: +49 (0) 62 62 912630  
 Fax: +49 (0) 62 62 912096  
 Email: info@int.iconinks.com

**Turkey**  
**AKER SERIGRAFI BOYALARI**  
 Cebeci Mahallesi 2. cebeci yolu  
 No:7 -34265 Sultangazi-Istanbul  
 Turkey  
 Tel: +90 (0)21 2594 3094  
 Email: info@akerserigrafi.com  
 www.akerserigrafi.com

#### Customer Service Hotlines:

Asia: +852 2426 6121    China: + 86 755 2736 8101    Australia: +61 (0)418 474908    Germany: +49 (0) 62 62 912630

[www.iconinks.com](http://www.iconinks.com)