



### RECOMMENDED FABRICS

100% Cotton  
Cotton/Polyester Blends  
Some polyester



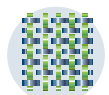
### INK APPLICATION

Metallic Shimmers should be used right from the container without any modifications. Stir well prior to each use.



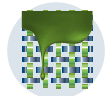
### ADDITIVES

If necessary: 1610 Curable Reducer (Add 1% to 5% by weight)



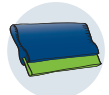
### SCREEN MESH

86 to 110 t/in or 34-43 t/cm Monofilament for Gold and Silver.  
25 to 61 t/in or 9 to 24 t/cm Monofilament for Crystalina.



### EMULSION

Any direct or indirect solvent resistant emulsion.



### SQUEEGEE

60-75 Durometer  
Sharp or beveled edge.



### CURE TEMPERATURES

325°F (163°C). The efficiency of the oven and length of heat tunnel will determine dwell time. Metals reflect heat, so adjust dwell time accordingly.



### CLEAN-UP

Any environment friendly plastisol type screen wash.



### PRODUCT PACKAGING

Quart, 1 gallon, 5 gallon containers



### STORAGE OF INK CONTAINERS

65° to 90°F (18°C to 32°C). Avoid storage in direct sunlight. Keep containers well sealed



### SDS

Refer to SDS prior to use

### FEATURES

- **Crystalina Shimmer 1855** • **Silver Shimmer 1856** • **Gold Shimmer 1857**

AXEON™ Shimmers are used to produce a bright, sparkled look when printed. Add inter-est and bling to your designs! AXEON™ Shimmers print just like a traditional plastisol and designs made with Shimmers may be applied to light or dark fabrics.

### SPOT FLASHING

This product will spot dry, with a very low after flash tack. Dwell time is dependent on the spot dryer used. In some cases, you may have to lower the heat of the spot cure unit because too much heat may actually make the ink tacky. When you spot dry, you are only partially fusing or gelling the surface of the ink. The ink should be just dry to the touch, with no lift off, but not totally fused. Totally fusing the underprint may cause inter-coat adhesion problems with the inks printed on top. Final fusing or curing will occur in the dryer. Failure to fuse ink properly may cause cracking, poor adhesion and poor wash fastness.

### IMPORTANT INFORMATION

1. Shimmer inks are low bleed inks, not non-bleed inks. On some types of fabric, bleeding or dye migration may occur. Always test print the fabric to be printed before beginning production. It is best to do some long term testing on some fabrics to determine if they are going to bleed. Bleeding or dye migration may not occur immediately.
2. Thinning this product may reduce the metallic sparkle.
3. When printing wet on wet, print the Shimmer inks last in a design to avoid excessive pick-up of the ink.
4. Too high of a temperature in the dryer, above 350°F (177°C), may reduce the brilliance of the Shimmer inks.
5. To improve adhesion on some fabrics, it may be necessary to add 900 Catalyst.
6. The Shimmers will spot dry, with a very low after flash tack, in 2 to 8 seconds depending on the spot dryer used. This allows the inks to be printed earlier in a design when desired.
7. The Gold and Silver Shimmers offer good opacity on dark fabrics. However, in some instances, when printing through finer mesh counts, double hits with or without a flash may be needed.
8. Do not mix Shimmers with opaque inks as those inks will block out or cover the Shimmer flakes.

For best durability of the Shimmers after they are applied, it is recommended that the garment be hand washed or machine washed (delicate cycle) inside out, and then line or air dried. Do not use bleach. Do not iron printed area. Test dryer temperatures and wash test printed product before and during a production run.

This ink and those in the AXEON™ product line are not formulated with PVC resins or phthalate plasticizers, nor are they intentionally added.

**Care should be taken to not cross-contaminate the AXEON™ products with PVC or phthalate containing products.**

**Do not use standard plastisol curable reducers with this or any of the AXEON™ products.**

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