

**RECOMMENDED FABRICS**

100% Polyester  
50/50 Cotton/Polyester Blends



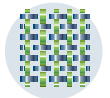
**INK APPLICATION**

1200 Series Colors should only be used with other 1200 Series Colors, without any modifications



**ADDITIVES**

If modification is necessary, use 1% to 5% by weight of 1610 Non-PVC Curable Reducer or 1200 Non-PVC Extender Base



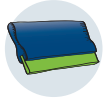
**SCREEN MESH**

110-305 t/in (43-120 t/cm) monofilament



**EMULSION**

Any direct or indirect emulsion or capillary film in the 35 to 70 micron range



**SQUEEGEE**

65-70 Durometer  
Sharp edge



**CURE TEMPERATURES**

325°F (163°C) entire ink film



**CLEAN-UP**

Any eco-friendly plastisol type screen wash



**PRODUCT PACKAGING**

Quart, 1 gallon, 5 gallon, 30 gallon, or 50 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**

AXEON™ UltraMix® 1200 Series Non-PVC Pantone® Color System consists of 19 non-phthalate, non-PVC, high performance colors, plus an extender base, that is formulated for ultra high speed wet-on-wet automatic printing.

Create special or standard colors by using International Coatings' UltraMix®, Pantone® color matching software, either online or on the desktop version.

UltraMix® 1200 Series is RSL tested to meet and pass brand requirements.

**COLORS**

1200 Extender Base	1215 Blue B (RS)	1225 Fluorescent Green
1203 Yellow	1217 Green	1227 Fluorescent Yellow
1205 Scarlet	1236 Mixing Black	1229 Fluorescent Lemon
1207 Red	1238 Mixing White	1231 Fluorescent Orange
1209 Violet	1219 Fluorescent Magenta	1233 Fluorescent Pink
1211 Marine Blue	1221 Fluorescent Violet	1235 Fluorescent Red
1213 Blue A (GS)	1223 Fluorescent Blue	

**SPOT FLASHING**

AXEON™ UltraMix® 1200 Series inks 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 of the flashed ink. Final fusing or curing should occur in the dryer.

**IMPORTANT INFORMATION**

In order to achieve the best color matching results using the AXEON™ UltraMix® 1200 Series Pantone® Color System, the specified system primaries must be used. Using colors other than the specified primaries will produce inaccurate matching results.

Colors produced using the AXEON™ UltraMix® 1200 Series Pantone® Color System will vary in opacity. Colors will reproduce best on white or light colored fabrics. Colors may appear metameric (not match well) when viewed under different types of lighting.

Adding too much reducer or other additives to the 1200 Series inks may cause curing/fusing or increased dye migration problems.

Use an underbase print when printing 1200 Series inks onto dark fabrics. Use 1244 or 1248 white as an underbase ink. To achieve a softer hand and faster production speeds, print underbase ink through finer mesh counts (230 to 305 t/in or 90 to 120 t/cm mesh).

Always test print the fabric to be used before beginning production to see if the desired performance is obtained.

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.**

**LEGAL DISCLAIMER**

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