

**RECOMMENDED FABRICS**

100% Cotton  
50/50 Cotton/Polyester Blends  
Nonwoven Polypropylene Bags (NPB), some Polyesters



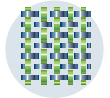
**INK APPLICATION**

Cool Sport™ Colors should be printed without any modifications



**ADDITIVES**

If viscosity adjustment is necessary, use 1% to 3% by weight 1110 Curable Reducer or 1099 Low Bleed Curable Reducer for 50/50 garments



**SCREEN MESH**

61-200 t/in (24-79 t/cm) monofilament



**EMULSION**

Any direct or indirect emulsion or capillary film in the 35 to 70 micron range, depending on the opacity desired



**SQUEEGEE**

65-70 Durometer  
Sharp edge



**CURE TEMPERATURES**

275°F to 325°F (135°C to 163°C) entire ink film. Fusing at lower temperatures may require longer dryer retention times



**CLEAN-UP**

Any eco-friendly plastisol 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**

Cool Sport™ Color (6100 Series) direct print plastisol inks are newly reformulated using our proprietary CoolTech™ technology. The series features 13 bright, ready-for-use team-related colors.

CoolTech™ uses the same chemistry found in our popular Cool White™ (7022). CoolTech™ adds strength, elongation, and elasticity to inks, and the resulting ink is smooth, creamy and even in consistency. It prints beautifully on automatic and manual printers and enables Cool Sport™ inks to be printed on multiple substrates. Cool Sport™ Colors are part of our expanding line of FlexCure™ screen printing inks.

FlexCure™ offers a 'flexible' curing range – from a low of 275°F/135°C to the standard 325°F/163°C.

**COOL SPORT™ COLOR INKS:**

Contain a high pigment load for maximum coverage on dark garments, thus reducing the need for under-basing.

Are suitable for printing on a variety of substrates including 100% cotton, 50/50 blends, non-woven polypropylene and some polyesters.

Can print through higher mesh counts on light-colored garments or can be reduced to obtain soft-hand, opaque prints.

**COLORS (IC SKU# | PMS EQUIVALENT)**

<b>Yellow</b> 6153   102 C	<b>Red</b> 6161   199 C	<b>Athletic Gold</b> 6155   123 C
<b>Hot Pink</b> 6165   225 C	<b>Scarlet</b> 6159   485 C	<b>Burgundy</b> 6163   202 C
<b>Orange</b> 6157   021 C	<b>Purple</b> 6167   268 C	<b>Reflex Blue</b> 6173   Reflex Blue C
<b>Teal</b> 6169   327 C	<b>Navy Blue</b> 6175   282 C	<b>Process Blue</b> 6171   Reflex Blue C
<b>Black</b> 6177   Black 6 C		

**SPOT FLASHING**

Cool Sport™ Colors 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. Too much heat may 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 any flashed color may cause inter-coat adhesion problems with inks printed on top of the flashed ink. Final fusing or curing should occur in the dryer.

**IMPORTANT INFORMATION**

Cool Sport™ Color inks are formulated with low-build performance characteristics; however, this does not mean that build-up will occur. 6100 Series inks may require flashing after colors if printing a wet-on-wet design. Adding too much reducer or other additives to Cool Sport™ inks may cause problems with curing/fusing or increased dye migration.

Adding any reducers or additives can lower the bleed resistance, opacity, or increase cure times of ink. STIR the ink prior to printing on press and after adding reducers or additives.

Test dryer temperatures and wash-test printed product before and during a production run.

**LEGAL DISCLAIMER**

Recommendations and statements made are based on International Coatings' research and experience. Since International Coatings does not have any control over the conditions of use or storage of the product sold, International Coatings cannot guarantee the results obtained through use of its products. All products are sold and samples given without any representation of warranty, expressed or implied, of fitness for any particular purpose or otherwise, and upon condition that the buyer shall determine the suitability of the product for its own purpose. This applies also where rights of third parties are involved. It does not release the user from the obligation to test the suitability of the product for the intended purpose and application.