



QS-9000/ISO 9001 Registration #60047

Technical Data Sheet:

# 219

Date:

May 15, 2002

Product:

HG0185 Pearl Gel

**FEATURES**

Short body and very low wet tack for easy printing.  
Fast shearing action means higher press speeds.  
Easy to use, no viscosity modifications necessary.  
Can be tinted with up to 10% Color Boosters to make pearl Gel Colors.  
Extreme high gloss when printed in thick film.  
Functions as an adhesive for foil transfers.

**DESCRIPTION**

HG0185 Pearl Gel is formulated as a press-ready plastisol for printing on 100% Cotton or poly/cotton. This product has excellent edge definition when stacked for that 3D look.

**APPLICATION**

HG0185 requires stirring before printing. Print HG0185 directly onto substrates. HG0185 is normally printed through mesh ranges from 86 - 110 mc./in. You may print through finer mesh to achieve fine details with less height. Recommend 60 Durometer squeegee and thick film for superior edge definition when stacking. For high gloss, cure at higher temperature and longer times. Note: Like all luster metallics, this product may tarnish after several washings.

**RECOMMENDED PRINTING TECHNIQUES**

**Manual Machine Printing**

- Load ink into mesh opening with soft, sharp squeegee.
- Only the image area should be filled with ink.
- Transfer ink to the fabric surface with a light squeegee pass using just enough pressure to clear the mesh.

**Automatic Machine Printing**

- Examine the flood bar and smooth edges if necessary.
- Adjust the flood to just transfer the ink from the front to the back of the screen.
- Transfer ink to the fabric surface with a light squeegee pass using just enough pressure to clear the mesh.

**SPECIAL RECOMMENDATIONS**

Plastisols are THERMOPLASTIC, requiring heat for fusion. Test print area for crock fastness. Should color rub off on white cloth, adjust oven temperatures and/or dwell time until crock test passes (cloth wipes clean). Stir plastisols prior to printing. Do not dry clean. Do not use bleach. Do not iron image area.

HG0182 is available in 5-gallon pails.

Any application not referenced in this technical data should be pretested or consultation sought with Rutland's Applications Laboratory prior to printing.

**TECHNICAL DATA**

*Wet Ink Tack - Low*

*After Flash Tack - Medium*

*Printability - Great*

*Surface Appearance - High Gloss*

*Opacity/Viscosity - High/High*

*Bleed Resistance - N/A*

*Gel Point / Flash Time - 160°f. / decreases with deposit thickness*

*Fusion Temperature - 320° f.*

*Squeegee Hardness/ Blade/ Angle - Soft/ Sharp/ 45°*

*Squeegee Speed - Medium to High*

*Underlay - N/A*

*Emulsion - Capillary Film*

*Mesh Count - 86 - 156 mc. In.*

*Extender - N/A*

*Thickener - N/A*

*Storage - 65°F to 95°F. Avoid direct sun*

*Cleanup - Mineral Spirits, Varsol or some non-hazardous screen washes*

*MSDS - #7*

*Color Range - HG0185 Pearl Gel*

*Substrate Type - Cotton or 50/50 Poly*

*Substrate Color(s) - Light, Medium, & dark fabrics.*

**Note:**

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