



# PRODUCT DATA SHEET

## MF-66

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## Nylon Bonding Agent

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#### Product Overview:

MF-66 Nylon Bonding Agent is an additive to plastisol inks for printing on shell or treated Nylon substrates. These substrates generally appear in the form of waterproofed jackets. Since each jacket manufacturer determines the type and amount of waterproofing chemical they apply to their garments, it is recommended that each batch of garments be tested prior to production.

#### Printing:

Add MF-66 to un-modified plastisol ink at a ratio of 10-12% by weight (1 Part MF-66 to 7 Parts of Ink). The mix is critical to success. Mix thoroughly. The addition of MF-66 generally "thins" the ink. Nylon substrates do not absorb ink. Rather, it lays on the surface. A heavy deposit is generally not necessary for opacity. The use of higher mesh counts maintains edge definition and prevents wicking.

Formula for adding 12% of MF-66 into a certain **Amount of Ink** by weight:

Amount of MF-66 to add = (**Amount of Ink**) x (0.136)

**Make sure your container of MF-66 is tightly sealed after each use.**

All other printing procedures are standard, such as stencil system, squeegee durometer and screen tension. We recommend using a jacket clamp or other hold down device and pre-shrinking the jacket with your flash cure unit before printing. This is particularly important if printing multi colors to ensure registration.

#### Stencil:

Use any direct emulsion or capillary film.

#### Pot Life:

Mixtures of MF-66 and plastisol result in a 4-6 hour pot life. It is recommended that you mix only what you intend to use during this period. Do not put unused mixture back into the original ink container as it will affect the ink that is already in the container. Properly dispose of unused, mixed ink.

#### Flashing:

Parameters vary between all flash units. Flash for 2-3 seconds with the ink deposit reaching 150-250°F (65-121°C). Ink should be dry and without tack.

#### Curing:

Cure at 325°F (162°C) over a 60-90 second period, depending on oven type and thickness of ink deposit. A thicker deposit will take longer to cure as the heat must penetrate through the entire ink layer.

#### Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.