



Technical Data Sheet

Apocalypse Cotton Colors

Non-Phthalate

Description: Apocalypse Cotton colors are a non-phthalate, lead free, High Opacity, bright, high performance colors that have excellent coverage on dark garments. The low tack formula allows printing through finer mesh counts without the use of viscosity modifier. Apocalypse Cotton Colors perform well on both automatic and manual presses. Formulated for lower temperature curing for softer hand.

Substrate: 100% Cotton Garments

- Features:**
- Creamy, short body plastisol.
 - User Friendly, no viscosity modifiers necessary.
 - Formulated to be non-phthalate.
 - Fast Flash
 - High Opacity and great coverage
 - No under base needed on most colors.

Physical Properties:	Wet Ink Tack	Low
	Surface Appearance	Satin Finish
	Opacity	High
	Gel point	160 °F
	Flash Temp	240° - 260°F
	Fusion Temp	300° - 320° F
	Squeegee Blade	70° - 80° durometer
	Mesh Count	86 – 300 mc in

Performance: Print Apocalypse Cotton Colors straight from the container through mesh ranging from 86 to 300 mc without modifications of the viscosity. Use finer mesh counts for softest hand and good opacity. Stir ink before use.

Storage and Handling: 65°F to 95°F avoid direct sunlight. **Never exceed temperatures above 95°F during storage.**



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Recommendations: Stir plastisol ink before printing. Any modifiers and additives should be mixed in clean containers using clean mixer blades and ink knives. Any contamination from other ink sources could make the ink test positive for restricted phthalates. Do not dry clean, iron or bleach the printed image.

Perform fusion tests before production. Failure to cure ink properly can result in poor wash fastness, inferior adhesion, and unacceptable durability.

Adjust flash cure temperature and dwell time so ink is just dry to touch. Avoid excessive flash temperatures. If surface is hot and tacky, the ink film has been over flashed. Reduce temperature or time to prevent an inter-coat adhesion problem.

Curing is a time and temperature process, a lower oven temperature setting with a slower belt speed while maintaining recommended ink cure temperature is always best to protect fabric and reduce energy consumption.

Apocalypse Cotton Colors can be cured between 300°F - 320°F. Running at higher temperatures and/or longer dwell times maybe required to achieve proper cure on jobs that contain high ink deposits or heavy weight garments.

Monarch Color does not knowingly add plasticizers containing the phthalates listed and outlined in California Bill 1108, CPSC HR-4040 and Oeko-tex Standard 100. The plasticizers identified may include di-(2-ethylhexyl) phthalate (DEHP), dibutyl phthalate (DBP) benzyl butyl phthalate (BBP), diisononyl phthalate (DINP), diisodecyl phthalate (DIDP), di-n-octyl phthalate (DnOP), (DIBP), Di-iso-butyl, and (DMP) Dimethylphthalate, including esters of ortho-phthalic acid and are not direct ingredients in the manufacture of Monarch plastisol direct to fabric screen printing inks. Monarch does not test the final product for amounts of the above mentioned phthalate plasticizers and esters and advises users to conduct testing for their intended use.

(Revised 3/29/19)