

**SPTB-02
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Flashing Plastisol Inks

The purpose of this bulletin is to clarify the appropriate time and temperature an ink underlay on a garment should be flashed in order to print another ink deposit on top of it. When using a first down white, printing the same color twice with a flash in between, or printing two color numbers, the first deposit should only reach a temperature in which it shows signs of gelling. At this stage, the plastisol is tack free, and other layers may be printed with no build up on the back of the screen.

By accidentally fusing the first deposit after you flash, two distinct films are created when the second layer is printed on top of it. When the garment is run through the dryer, the two layers may not melt together and fuse as one continuous film. This is because plastisol films are good insulators, and the bottom layer may not reach its desired remelt temperature. The result is that the ink films will not adhere to each other and will actually peel apart.

Ideally, the first deposit is flashed until it is just gelled. When the second layer is printed on top of it and the garment is run through the dryer, the two deposits melt together and will form one continuous ink film. It is important to run in your dryer a thicker film longer than a single film, since the thicker the film the longer the cure time.