



### RECOMMENDED PARAMETERS

#### Fabric Types

100% Cotton Dischargeable fabrics



#### Mesh

Count: 80-230T/in (34-90T/cm)  
Tension: 18-35n/cm<sup>3</sup>



#### Squeegee

Durometer: 60-90-60  
Profile: sharp, square  
Stroke: x1 stroke, medium speed  
Angle: 10-15%



#### Stencil

Water Resistant Emulsion  
Off Contact: 1/16" (2mm)  
Emulsion Over Mesh: 15-20%



#### Flash & Cure

Flash: Not recommended  
Cure: 90 seconds at 330°F (165°C)



#### Pigment Loading

Maximum 6%



#### Aquarius™ Additives

Aquarius™ Discharge Activator ZF  
6% Max  
Aquarius™ Softener 1-5%  
Aquarius™ Thickener 0.1-1%  
Aquarius™ Retarder 1-3%



#### Storage

Store in sealed containers 12 months  
from manufacture >40°F (5°C)  
<77°F (25°C)



#### Clean Up

Water & mild detergent



#### Health & Safety

Find SDS information here:  
[www.avient.com/resources/safety-data-sheets](http://www.avient.com/resources/safety-data-sheets) or contact your local CSR



Aquarius™ Bright Discharge ZF range consists of a high opacity soft hand discharge white and a soft, bright discharge base. Designed to achieve bright discharge white and colors whilst maintaining a super soft flexible hand.

### HIGHLIGHTS

- Bright, opaque discharge white
- Super soft hand feel
- Prints wet on wet for multicolor discharge prints
- Discharge base for intense bright colors

### PRINTING TIPS

- Use 6% Aquarius™ Discharge activator ZF. Mix well and leave for 10 minutes to dissolve. Remix immediately prior to adding to the screen. Once activated inks colors should be used within 8 hours to prevent any color change issues. To prevent wastage only activate a small amount of color at a time
- White can be used as stand alone white or as a highlight white
- Colors should be made in accordance with Aquarius™ IMS Pantone® mixing system with a maximum of 6% pigment loading to ensure crock performance is maintained
- Use 86-230T/34 (34-90T) mesh for best performance and color brightness
- Print with 1/16" or 2mm off contact. Print one stroke
- Avoid the use of flash cures. Print discharge colors dark to light, wet on wet. Print Aquarius™ Bright Discharge White in the last position
- Clean the stencil area when stopped to prevent screen blockages
- Prints should be cured at 330°F/165°C for 90 seconds. Check the cure temperature at the ink surface
- Test all prints for color fastness and print durability before starting the production run

### COMPLIANCE

- Water based, non PVC, non phthalate
- Visit [www.avient.com/products/screen-printing-inks/zodiac-aquarius](http://www.avient.com/products/screen-printing-inks/zodiac-aquarius) for more information

### PRECAUTIONS

- The information above is given in good faith and does not release you from testing inks and fabrics to confirm suitability of substrate and application process to meet your customer standards and specifications



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