



Recommendations	
<b>Product Overview</b>	
Product Code	M32443
Industry	Inks
Application	Screen Printing
Category	Mixing Inks
Sub-Category	M3 Mixing System
Chemistry	Plastisol
Substrate(s)	Cotton
Best Used By	12 months
Certification(s)	ISO9001
<b>Curing:</b>	
Fusion Temperature	320 °F
Gel Point	160 °F
<b>Performance:</b>	
Viscosity	Medium
Coverage	High Opacity
Printability	Great
After Flash Tack	Low
Bleed Resistance	None except M39000 White
<b>Squeegee:</b>	
Squeegee Profile	Square
Squeegee Type	Polyurethane
Squeegee Speed	High
<b>Screen:</b>	
Mesh	86 to 305
Screen Tension	As recommended for mesh
Underlay	NPT Cotton White for 100% cotton dark
Emulsion Type	Capillary film, Direct
Cleanup	Bio-degradable screen wash
<b>Additives:</b>	
Extender	ES0840 or EH0542
Thickener	M00010 Thickener #10 (powder)
Thinner	EA0005 Viscosity Reducer
<b>Storage:</b>	
Storage Temperature	65°F - 95°F (18°C - 35°C)
Storage Notes	Avoid direct sun.

Last Change: Nov 2016

## NPT HO MARINE M3

M3 Ink Mixing System is a non-phthalate finished ink mixing system. M3 colors directly replace the M2 and EM ink mixing colors. They are opaque resulting in excellent coverage on dark garments. The tackfree formula allows printing through a range of mesh counts without the need for a viscosity modifier. Use a white underlay when printing on dark fabrics for that extra "pop" in brightness. No build-up formulations ensure the highest print efficiencies without down time for wiping screens. Mix thousands of finished ink colors by choosing Pantone colors from our M2007 Ink Mixing Software or by custom mixing your own colors. NPT Low Bleed White underlay for printing on polyester/cotton blends. NPT Cotton White underlay for printing on 100% cotton. Clairra NPT Barrier Base (Dyno Grey) available for printing on 100% polyester

### Instructions

Printing on White Garments: Mix per formulation or by eye to achieve brilliant colors on 100% cotton whites. For extremely soft-hand prints, mix finished color up to 1:1 with Clairra ES0250 NPT Chino Base. Printing on Dark Garments or over an underlay: When printing on dark garments, mix per formulation or custom blend to achieve brilliant colors over an underlay. Use the NPT Low Bleed White on poly/cotton blends and the ES0266 NPT Barrier Base when printing on 100% polyester Puff designs: Mix 10-15% of Clairra NPT Puff Additive to any formulated Clairra™ Color to create a puff ink. PRODUCTS:

M31037	NPT OPAQUE FLUOR VIOLET M3	M36055	NPT OPAQUE FLUOR PINK M3
M31440	NPT HO VIOLET M3	M36056	NPT OPAQUE FLUOR RED M3
M32065	NPT OPAQUE FLUOR BLUE M3	M36446	NPT HO SCARLET M3
M32441	NPT HO BLUE #1 M3	M36447	NPT HO RED M3
M32442	NPT HO BLUE #2 M3	M38394	NPT HO BLACK M3
M32443	NPT HO MARINE M3	M39000	NPT LB NG RETRO WHITE M3
M33033	NPT OPAQUE FLUOR GREEN M3	M39256	NPT HO WHITE M3
M33443	NPT HO GREEN M3	M31018	NPT FF FLUOR MAGENTA M3
M34037	NPT OPAQUE FLUOR YELLOW M3	M31038	NPT FF FLUOR VIOLET M3
M34041	NPT OPAQUE FLUOR LEMON M3	M34042	NPT FF FLUOR LEMON M3
M34449	NPT HO YELLOW M3	M36057	NPT FF FLUOR RED M3
M35018	NPT OPAQUE FLUOR ORANGE M3		

### Recommendation

Clairra Colors™, bases, modifiers and additives should be mixed in clean vessels using clean mixer blades and utensils. Any contamination from other ink sources or non-approved additives could make Clairra Colors™ test positive for the restricted phthalates. Do not dry clean, bleach, or iron the printed image. Note to 100% cotton users: With low bleed ink, 100% cotton could produce a ghost image. Clairra M39000 NPT LB NG RETRO WHITE is a low-bleed ink that is formulated to print on cotton or polyester cotton without causing a ghost image. M39000 NPT LB NG RETRO WHITE is not recommended for 100% polyester. Use Clairra Barrier Base for 100% polyester.

### Statement

Rutland Plastic Technologies does not knowingly add plasticizers containing the phthalates listed and outlined in California Bill 1108, CPSIA 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 Clairra High Opacity Non-Phthalate Inks. Rutland Plastic Technologies does not test the final product for amounts of the aforementioned phthalate plasticizers and esters and encourages all users to conduct testing for their intended use.

### Disclaimer:



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