



Recommendations	
<b>Product Overview</b>	
Product Code	EL8209
Industry	Inks
Application	Screen Printing
Category	Specialty Inks
Chemistry	Plastisol
Substrate(s)	Poly
Best Used By	12 months
Certification(s)	ISO9001
<b>Curing:</b>	
Fusion Temperature	280 °F
Gel Point	150 °F
<b>Performance:</b>	
Viscosity	High
Coverage	High Opacity
After Flash Tack	Medium
Bleed Resistance	Great for 100% Polyester
<b>Squeegee:</b>	
Squeegee Profile	Square
Squeegee Type	Polyurethane
Squeegee Speed	Medium/High
<b>Screen:</b>	
Mesh	86 to 156
Underlay	EL0755 Endurance PlusGrey Base
Emulsion Type	Capillary film, Direct
Cleanup	Non-Phthalate screen wash
<b>Storage:</b>	
Storage Temperature	65°F - 95°F (18°C - 35°C)
Storage Notes	Avoid direct sun.

Last Change: Feb 2017

## ENDURANCE PLUS BLACK

EL8209 Endurance Plus Black is a press-ready non-phthalate black plastisol ink with great bleed resistance and a wide cure temperature range for printing on 100% Polyester Performance fabrics. For fabrics with severe migration, use EL0755 Endurance Plus Barrier Grey as an underlay. The combination of the two give the best migration resistance. Endurance Plus Black and Endurance Plus Barrier Grey have a cure temperature range from 280°F (138°C) to 300° F (149°C) while still blocking dye migration on most 100% Polyester fabrics. EL0209 Endurance Plus Mixing Base can be used with Rutland's C3 Color Boosters to create desired low temperature colors. Formulations are available in the RGCC Color Mixing Software. Mixed colors would be printed over the Barrier Grey/White layer for the most brilliant prints.

### Features

- Low temperature cure from 280°F (138°C) to 300° F (149°C).
- Smooth athletic surface on cured print.
- Superior bleed resistance for printing on 100% polyester performance fabrics.
- Complies as a non-phthalate and no lead product as defined by CPSC

### Instructions

Print EL9755 Endurance Plus Black over EL0755 Endurance Plus Barrier Grey or directly onto 100% Polyester substrates where applicable. Endurance Plus inks print well through mesh ranges from 86-156 mc in. (34-62 mc CM.) Recommend 70-80 Durometer squeegee with sharp edge for maximum print definition. NOTE: Poorly dyed polyester or too much heat in the curing process can overcome any low bleed inks ability to block dye migration. For severe migration use EL0755 Endurance Plus Barrier Grey as an underlay. Printers should always test the ink on their fabric under their process conditions before printing production runs.

### Recommendation

Do not dry clean, bleach, or iron the printed image.

### 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-isobutyl, 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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