



May 25, 2008

**To: Rutland Plastic Technologies, Certified Dealers
Rutland Plastic Technologies, Distributors**

We are pleased to announce the development and launch of a new foil release additive, M00047. This new additive, designed to be used with standard plastisol inks to retard adhesion of foil and can easily be used on both light and dark fabric.

The accompanying Technical Data Sheet, #302, and Technical Bulletin, #102, is provided for application details. As this product has unique release characteristics, please test for in all applications for suitability prior to use. Also, it is recommended in the Technical Bulletin that M00047 be used in combination with Rutland Screen Printing Inks, and in all ink layers, (underbase + top layers). The recommended dosage is 10% or less as required to get the desired effect, but testing is required prior to use.

Pricing is as follows:

Product: M00047 Foil Release						
	Weight per gallon (Lbs)	Weight per 5 gallon container (lbs)	List Price 55 Gallon Container	List Price 5 GAL	List Price 1 GAL	List Price QT
Published WPG	8.60	43.0				
List Price (USD)			\$59	\$64	\$74	\$25

Orders will be accepted for M00047 beginning June 1, 2008 and orders for M00683 will be accepted up to July 1, 2008, and discontinued thereafter. Effective July 1st, M00047 will be the only foil release product available.

If you need additional information, please feel free to contact the Rutland applications lab at (704) 553-0046 ext. 151 or your customer service representative.

Rutland Plastics Technologies



Technical Data Sheet #302	
Typical properties after adding 10% M00047 to a Plastisol Ink	
Wet Ink Tack	Low
After Flash Tack	Low
Printability	Excellent for fast production
Surface Appearance	Ink dependent
Opacity/Viscosity	Ink dependent
Bleed Resistance	N/A
Gel Point/Flash Time	Ink dependent
Fusion Temperature	320°F. (160° C.)
Squeegee Hardness	Ink dependent
Squeegee Blade	Ink dependent
Squeegee Angle	45° to screen mesh
Underlay	Use ink plus additive
Emulsion	Capillary Film or Liquid Emulsion
Mesh Count	Ink dependent
Extender	N/A
Thickener	N/A
Storage	65°F to 95°F. (18° C. to 33° C.) Avoid direct sun
Cleanup	Bio-degradable screen wash
MSDS	Call
Color Range	M00047 Foil Release
Substrate Type	100% Cotton
Substrate Color's)	Light, Medium & Dark Colors

Specialty additives

M00047 Foil Release Additive

Description

M00047 Foil Release Additive is designed to provide foil release characteristics to Rutlands' plastisol ink allowing the printer to make multi-color designs with foil adhered to desired areas. By mixing M00047 into all layers of ink, the design can be applied to dark shirts and still provide foil release capability.

Features of M00047

M00047 Foil Release Additive

- Provides excellent foil release properties to Rutlands' plastisol inks that have been properly cured.
- Can be used in concentrations of 10% or less to maintain the integrity of the ink film
- Can provide foil release characteristics when printing both light and dark colored garments.
- Phthalate Free for use with Rutland's Clairra Colors and E2 Ink mixing systems

Application

Typical Use: (It is recommended that user evaluate M00047 for fit for use in each application. Special attention should be given to **crook and wash testing** prior to use).

Mixing Procedure:

- Mix release agent into Rutlands' Plastisol Inks at 1-10%(max), using a mechanical stirring device, such as a Turnabout™ type mixer or other low shear mechanical mixing devices. (hand stirring is not recommended)

Printing Procedure:

- Add M00047 to all Rutland Plastisol Inks where foil is not desired per the design
- Print foil release colors through normal printing technique (print-flash-print etc.)
- Print Rutland's Foil Adhesive (NG0274) also known as X-Glue to all areas where foil is desired per the design
- Cure finished print at a minimum of 320°F (160°C) for a minimum of 75 seconds (results vary).
- Test for fit for desired use.
- Do not dry clean, bleach, or iron printed image.



RUTLAND PLASTIC TECHNOLOGIES

May 15, 2008

Technical Bulletin #102

M00047 Foil Release Additive

M00047 Foil Release Additive is designed to be used as an additive mixed with standard plastisol inks to retard adhesion of foil. The unique compatibility properties of M00047 in plastisol ink contribute to the functionality of foil release by creating release functionality on the surface of printed ink. M00047 is a phthalate free additive and can be used with Rutland's EV Clairra Colors and E2 Ink mixing systems. This unique product also allows for foiling dark garments. Simply mix up to 10% in both the underlay and the top layer of plastisol inks for foil release on dark garments.

Please note that the properties desirable to achieve foil release, may impact other finished properties like hand, crocking and fibrillation. Accordingly, Technical Data Sheet # 302 Foil Release Additive is available on the Rutland Plastics Technologies web site www.rutlandinc.com states that concentrations of M00047 should not exceed 10% and that complete testing of the print be performed prior to running production quantities of prints. It is also recommended that M00047 be used with Rutland Plastics Technologies ink series to include MA, MH, M2, EV Clairra Colors, E2 and CB when mixed with MH0540 VO Base, MH0538 Opaque Base or M20063 M2 Extender Base, and that wash and crock tests be performed as the fabric substrate and process conditions may impact overall performance.

