

JULY 2019

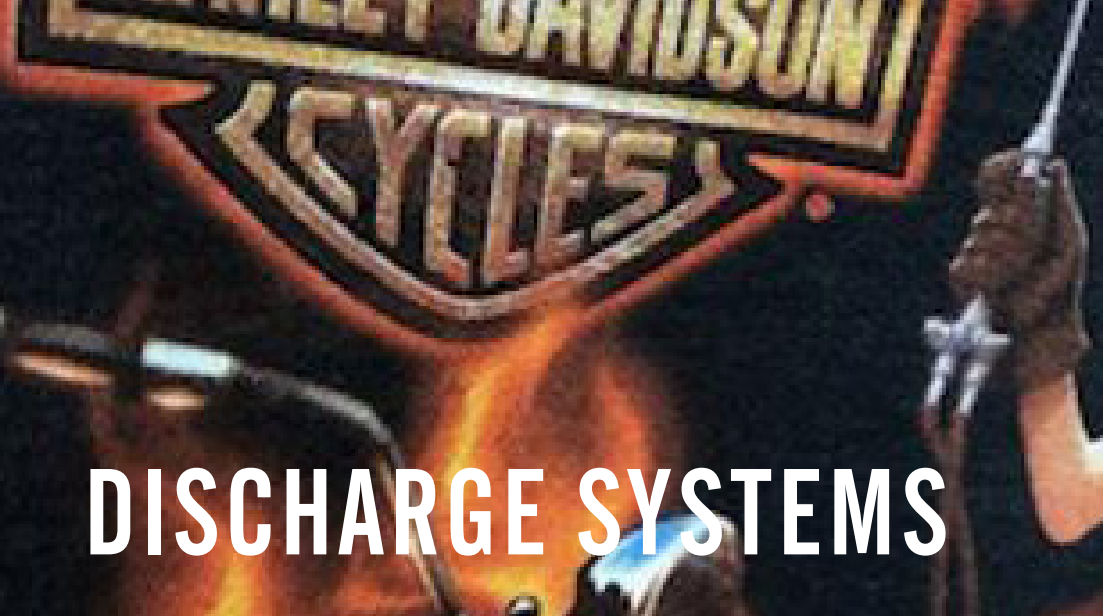


# GSG<sup>®</sup> PULSE

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APPAREL DECORATING



# DISCHARGE SYSTEMS

## What is the Discharge printing process?

Printing with Discharge is a chemical reaction that removes the dyes from the shirt fabric, leaving the natural color of the cotton. It enables the printer to eliminate using white plastisol as the under-base. Using discharge as the under-base yields a much softer-hand print.

## Advantages of Discharge as an Under-Base

The discharge under-base will produce a softer hand and the print will not have the typical plastisol feel associated with printing on

dark garments with a regular white plastisol under-base. The printer will also increase production output since the discharge under-base is absorbent and does not seal the garment, allowing for each subsequent color to be easily printed wet-on-wet on top of the under-base.

## Screen Preparation

Water resistant emulsion for the stencil is required, since discharge ink is a water-based product.

## Mesh Specifications

Recommended mesh size for printing a discharge under-base is typically 123 or 156 mesh for standard printing, or up to 305 can be used depending on the amount

of details or halftones in the design. If plastisol is being used for the top colors a higher mesh count such as 230 to 305 is recommended to give the entire print a super soft-hand feel.

## Ink Preparation

Discharge inks need to be mixed with 6% discharge activator prior to going on press. It is recommended to activate the discharge ink at least 30 minutes before use, stirring regularly to allow the activator to dissolve.

## Printing Specifications

Printing with discharge is directly opposite of printing with plastisol as an under-base. Squeegee pressure needs to be adjusted so that the ink is driven into the garment enough to eliminate the garment color beyond the visible depth and to avoid having the undischarged sides of the threads showing when the fabric is stretched. This is achieved by using more squeegee pressure and a fast print stroke.

## Curing

A minimum of 90 seconds at a temperature of 320 degrees in a well-ventilated dryer, preferably with forced air is needed to properly cure the Discharge inks and plastisol if it is used for the overprint colors.

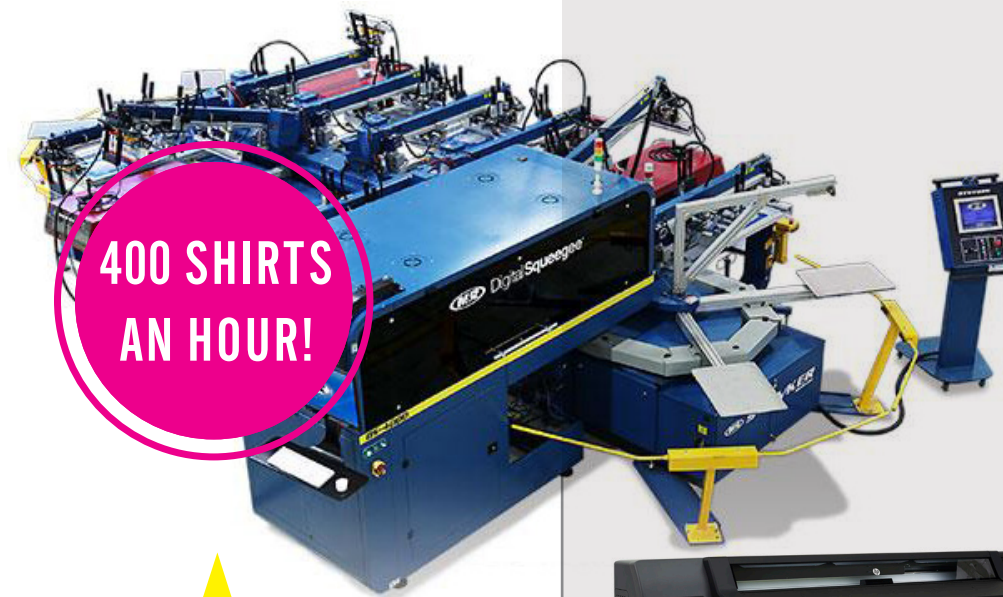
## Clean up and Reclaim

Discharge ink clean up can be done with just water, whether on-press or during the reclaim process. The screens can then be reclaimed in the normal fashion of plastisol printing.

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