



Technical Service Data Sheet

东莞长联新材料科技股份有限公司

711-1 3D white paste 711C-1 3D clear paste

1 产品概述

- Category: 3D paste
- Feature: High fastness, good elasticity, easy to use, easy up thick, not dented or warped
- Fabric: suitable for 3D printing on various cotton and T/C fabric.
- Storage: Keep in cool and ventilated place at 5-35 centigrade, well sealed for 6 month.
- Eco status: Meet GB 18401. OEKO-TEX 100 certificate, adidas A-01, Nike RSL.
- Technical specification:

Code No	711-1	711C-1	Reference standard/ method
Technical data			
Appearance	White paste	Pale yellow paste	Visual Inspection
pH value	6.0-7.5	6.0-7.5	GB/T 7573-2009
formaldehyde/mg/kg	<20	<20	Oeko-tex standard 100、 Adidas A-01、 EN71-3 (Soluble heavy metals)
Soluble heavy metals/mg/kg	PASS	PASS	
AP/mg/kg	not detected	not detected	
APEO/mg/kg	not detected	not detected	
Phthalate/mg/kg	not detected	not detected	
Organo-tin compound/mg/kg	not detected	not detected	
AZO/mg/kg	not detected	not detected	

Remarks: For detailed eco-friendly status , please refer to the test report.
not detected =less MDL



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2 使用说明

2.1 应用配比:

Color Formulation/%	Light	Medium	Dark
711-1	70	45-55	5-15
711C-1	30	45-55	85-95
711-1+711C-1	100	100	100
Pigmen	3-5	6-8	8-12

Notes: We suggest to use CLT high fastness and fluorescent pigment. The usage of pigment should less than 12%. Otherwise, the color may fade or migrate. Fluorescent pigment may affect the binder elasticity. To increase the fastness, our 1% pc-100 crosslinking agent can be added..

2.2. Printing Technology

2.2.1 Printing Condition

A. For your best result, please print at moisture condition of 50-80% and note the impact of temperature to operability. Please make sure to extend the curing time when moisture is higher than 80% to avoid stickness and poor washing fastness. When moisture is less than 50%, we suggest to add MDR wetting agent to avoid the chocking problem.

B. Squeegee: 75hardness oil based

C. Mesh: 80-120mesh

D. Curing: at 130-140°C X 90s. Heat press at 135°C for 10 s

2.2.2 Printing Process

A. 711c-1 printing 8-9 times (thickness according to customer operation requirements), each time need table dry.

B. Then cover 711-1 white glue or color mixing, printed 2-3 times, each time need table dry

C. Leave to dry for 24 hours after printing

D. Curing: 135°C*90s

2.3 Options for Auxiliaries



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A.If the fastness needs to be increased, the crosslinking agent 1% pc-100 of our company can be added. Before use, the crosslinking agent should be mixed evenly and used within 8 hours, otherwise the phenomenon of agglomeration and thickening will occur.

B.When the temperature is high or low, the glue crosslinking will be slow, so pay attention to extend the drying time properly, to ensure that the printing is completely dry before washing water test, otherwise it will affect the test effect

3 Properties for Finished Printed Fabric

3.1 Conditions for Making Mesh

Testing size: 200*200mm real printing

Testing fabric: 100% cotton

Printing condition: 10 times printing, 3 squeegees each time

Curing condition: 135°C X90s

Testing item	711-1	711C-1	Test method
Softness	3	3	Inner standard: 5grade: super soft, 4 grade: relatively soft 3 grade: soft 2 grade: slightly stiff 1 grade: stiff
Elasticity	4	4	Inner standard: 5grade: very good 4 grade: good 3 grade: normal 2 grade: bad 1 grade: worse
Gloss	Plain	Plain	VISUAL TEST
Whiteness	Good	-	VISUAL TEST
Coverage	Good	Good	VISUAL TEST
Machine wash fastnes	PASS	PASS	Use Libai detergent powder 5g wash at 60 centigrade, 1200 Speed. Standard washing 2.5H :5 times washing/ 5 times curing.
Dry rubbing	3-3.5	3-4	GB/T 3920-2008, 10 cycle rubbing
Wet rubbing	3-3.5	3-4	GB/T 3920-2008, 10 cycle rubbing



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Odor smell test	NO	NO	GB 18401-2010、GB/T 14272-2011
Color migration	No color migration		Click the printed fabric by stainless steel glass for 24 hours at 80 centigrade 5kg weight.
Overlap sticky test	No sticky and broken on surface		Press the overlap printed fabric at 80 centigrade for 24 hours at 5kg weight. Then peel off till the temp back to normal
Anti-frozen	PASS		Keep 24 hours at -20 centigrade

Notes: All the tests above are based on certain conditions. Make sure to do the trial test before mass production.

For any questions, please contact our company for details. We keep the right to amend the manual without prior notification.