

# Screen Print Facilities Best and Worst Practices

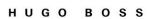
Lawrence Lai Levi Strauss & Co





































### Content

- General Factory Conditions
- Ink Mixing / Store Area
- Screen / Mixing Tool Storage Area
- Curing
- Quality Control







































# **General Factory Conditions**

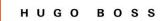
- Printing surfaces should be clean and smooth.
- No clutter or dirt under the tables, plus the tables are cleaned down after each print run.
- Stand / trolley is a good idea for storing production ink.







































# **General Factory Conditions**

### **Worst Practices**

- Ink stored on the floor can get contaminated or spilt
- Storing old/unused screens under printing benches is not allowed
- Squeegee type not properly labeled
- Uncontrolled storage areas contaminated with ink













































































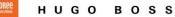












































































































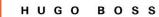








































### **Ink Mixing / Store Area**

- Aluminum surfaces to help with cleaning
- Ink mixing scales are covered in a protective film and calibrated
- All dye containers should cleaned, labeled and have lids on them to stop possible color contamination
- Tools and chemicals properly labeled
- MSDS, spill clean up equipment available





































## **Ink Mixing / Store Area**

#### **Worst Practices**

- Workspace dirty
- Ink containers have multiple colors of ink on them and no lids
- Weighing equipment out of calibration
- Tools and chemicals not labeled or labeled improperly









































































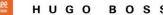












































































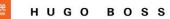








































# Screen / Mixing Tool Storage Area

- Screens properly cleaned, dried before put away for storage
- Screens stored off the floor
- Each mesh type should marked clearly
- Tension should be checked to meet with the required specifications







































# Screen / Mixing Tool Storage Area

#### **Worst Practices**

- Screens stacked against each other
- Screens sitting on the floor
- Ink residue left on screens
- Do not have proper screen stretching equipment



































































































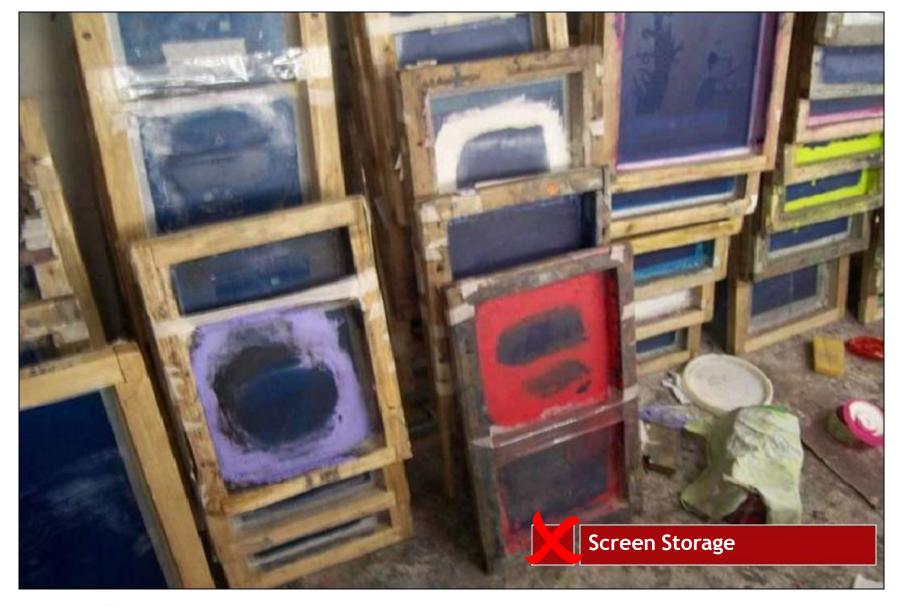










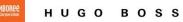














































































































## Curing

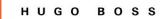
- Table top flash curing is recommended
- Maintain a good condition of curing belt





































# Curing

### **Worst Practices**

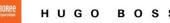
 Flash curing with Hair Dryers or Heat Guns is not allowed



















































































ESPRIT GMBOREE HUGO BOSS























































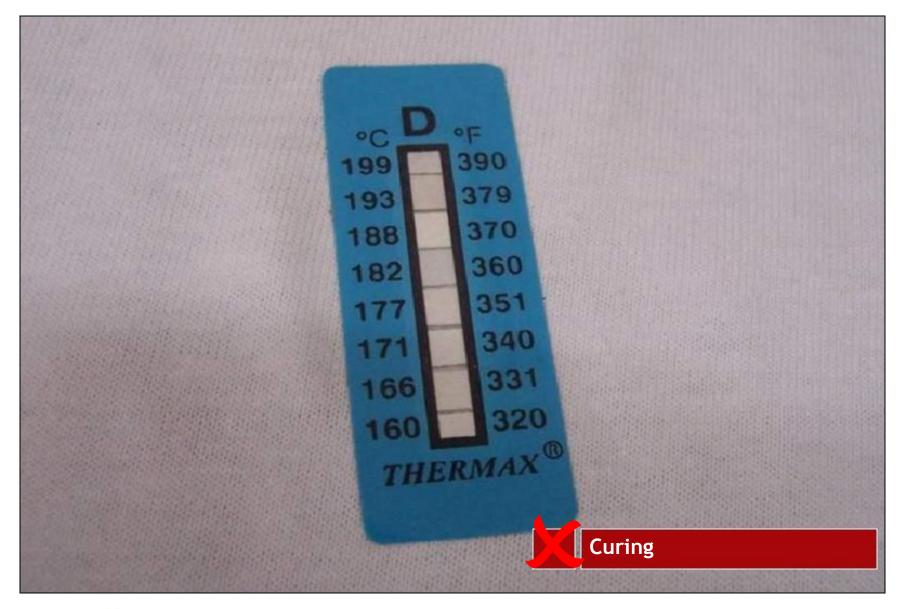










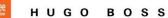






































## **Quality Control**

- QC's should check color against approval, prior to production.
- In-Line QC's should check prints as often as possible
- Approved samples should be available at the end of the production line.
- Final 100% QC check should be carried out.























































































































































2011

### **Toolkit Reference**

### AFIRM Supplier Toolkit



 Appendix I—Screen Printing & Applications/Finishing Best Practices

Screen Print Facility Best & Worst Practices

This document provides examples and pictures of best and worst practices at screen print facilities:



Screen Print Facility Best & Worst Practices.pptx

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