

## WORKSHOP AGENDA

# Greave's on Garments at Mind's Eye

May 1-2, 2015

1019 W Commerce Drive

Decatur, IN 46733

### Thursday April 30, 2015

6 – 9 PM

Meet & greet networking at Mind's Eye Graphics, pizza & munchies along with some friendly card playing. Put a name and a face together if you arrive early.

### Friday May 1, 2015

8 AM

Registration check in with Coffee, juice & breakfast snacks

9 AM

**Greaves on Garments- Part 1**

10:30 AM

Morning Break

10:45 AM

Resume - Greaves on Garments- Part 1

12:00 PM

Lunch break - Catered by Manley Meats

1:00 PM

**Greaves on Garments – Part 2**

2:00 PM

Break

2:15 PM

Resume - **Greaves on Garments – Part 2**

3:30 PM

Break

3:45 PM

Resume – **Day 1 Q&A Story Time**

5:00 PM

Mind's Eye Graphics World Famous Networking BBQ and BS Extravaganza

9:00 PM

Dismiss for day.

### Saturday May 2, 2015

8:00 AM

Coffee, juice & breakfast snacks

9:00 AM

**Greaves on Garments – Part 3**

10:30 AM

Morning Break

10:45 AM

Resume - **Greaves on Garments- Part 3**

12:00 PM

Lunch break - Catered by Manley Meats

1:00 PM

**Greaves on Garments – Part 4**

2:00 PM

Break

2:15 PM

Resume - **Greaves on Garments – Part 4**

3:30 PM

Break

3:45 PM

Resume - **Day 2 Q&A Story Time**

5:00 PM

Dismiss for day- Dinner location TBA

Travel Safe

The scheduled agenda is subject to change as the class takes off on wild goose chases as Richard leads us down the yellow brick road to really find out who the man behind the curtain is. Be prepared to challenge everything you thought you knew about the craft and business of screenprinting.

The pages that follow are Richard's bullet points that reflect just some of the content we will be discussing. Thanks for being a part of this adventure.

*Richard & Greg*

## Richards Notes for Greaves on Garments at Mind's Eye Workshop

### ***In no particular order***

What are you hoping for? my favorite diagnostic

How are you measuring? #3

Internal standards vs. external standards

Business

Contract printing requires Emergency Room speeds

Technology cycles

Computers, inkjet, DTG have disrupted companies that didn't keep up

### **Sales**

### **Billing**

Log gifts in red ink on the bill

### **Credit**

Oh, you don't have a credit card?

Finance

### **Employees**

Stealers

### **Infrastructure**

### **Insurance**

Vandals more than burglars

### **Taxes**

### **Management**

Time management "Time's a wasting, boss"

Morning meeting

lost time is never found again

poorer by one day

Access to bank vault for 5 minutes

### **Work orders**

Tiny t-shirt diagram

Work Order Flow

**Pre-Press Practicum** has excellent tips

Art comes in

Blowup small art as a teaching example

40 fonts - Stock colors

### **Separations**

Not art, but prep

Justo Thomas Chap. 18 My Aim is True

Complexity vs. complicated from CheckManifesto

Anticipate danger to avoid it

Diagnose fine line failure as part of the separation work - Predict

What you have, and what you have to do, to get what you hoped for

Porsche vs. Beetle

If it fails at press, it wasn't prevented -Fire extinguishers  
"Missed goal" soccer or basketball  
Drag staff to the accident scene at the press  
Tolerated? Cancer  
What were you hoping for !. Customer hoped 2. Production hopes  
Alan Ducasse quote

### **Design creation -Art**

Any fool can paint a picture, but it takes a wise man to be able to sell it. -Samuel Butler

### **Internal record keeping**

Design numbers separate from Job number

### **Positive making**

It's all about the UV density  
Densitometer  
Head types  
Film coatings

### **Screen making** lots of invisible

SM Management in the binder  
Screen Cycle [poster](#) Book link on GDrive  
KIWO [poster](#)  
UV Energy  
    Crust or Penetration through the stencil  
    Under exposure effect on reclaim  
    Radiometer Accumeter  
Light scatter  
Undercutting  
Distance  
    Inverse square law Dinner for one turns into dinner for 16  
    Lamps emit a fixed amount of energy  
Sensitizer choices  
    At factory  
Time spent coating with direct film or direct emulsion  
4 drying steps - Water in stencils  
Mesh purpose  
Thin thread Joe Clarke "high volume"? phrase  
Drying stencils  
Tension  
How to teach your friends about screen printing **SPM GOG Nov 1992**

### **Pre-Reg**

#### **Setup**

Blade width

#### **Loading**

## Approval

- Discussion of what we expect to go wrong
- Why wasn't that addressed in separations?
- Visible sample for comparison
- Color lighting

## Keep the press running

- Downtime** -the cancer of printing
- Loading table

## Curing

- the Number 1 invisible nightmare
- UV & IR cure is related
- Heat guns Atkins thermo probe
- Mylar test sheets for opacity
- Tapes
- IR gun calibrated *Greaves make movie*

## Ink choices

- Garment types
- Packing
  - I'm a count in tens man
- Over Under runs
- The brutality of contract printing other peoples mysteries
- DTG assimilation
- Customer hijinx
- Endgame for all phases of these topics

- Job Descriptions
- Checklists
- SOP

## Shop Layout

- Flow
- Dirty side

## Ink Labels

## Ink is Multi-Viscosity

- Art Dobie slides
- 10" ink knives Plastic is False economy

## Squeegee

- Abbott teachings
- Timeline
  - Overcome mesh resistance

The printing is the easiest part -*All mistakes happen in pre-press*

Begin with the end in mind -*Collect the check*

Study -*see my book lists*

[www.nbm.com/printwear/guidebook](http://www.nbm.com/printwear/guidebook)

[www.usscreen.com](http://www.usscreen.com)

[www.sgia.org](http://www.sgia.org)

[www.stpubs.com/books\\_subject.html#screenweb](http://www.stpubs.com/books_subject.html#screenweb)

Sales is the hidden part of running the garment business

Art is really separation

Handling computer art from customers -*Wrong sizes, fonts, layers, etc.*

Centerlines -*Mark the neck and all centers so there is no guessing*

Pre-registration -*Jig system, pins, TriLock*

Equipment needed

Camera -*Digital or conventional*

Light table

Computer

## Screen

Coating with capillary or direct emulsion

Thickness of the coating is important

Dry Screens to remove all moisture in a dry environment less than 50% Rh

Exposure -*Not enough and they wash out, too much and fine lines close up*

Choosing mesh -*Focus on average thread diameter 60, 86, 120, 140, 160, 180, 200, 255, 305*

Tension - *If the tension changes, the image changes size and reduces snap-off*

## Press

Pre-registration

Print order

Odd platens for odd things

Print with flood, print, lift -*Pressure only bends the blades* - Remember the tape roll

## Ink

Plastisol

Water-based Only water

Brand name vs. OEM

Water phase Water w/Oil

Wet-On-Wet

Thick ink on darks

## Ink for dark garments

Pick a palette *What colors work on darks?* Yelo, orange, green, blue, purple, white

Darker translucent colors don't require as much ink to mask the shirt color

Opaque on dark ink *or* FLASH for base? -Flash w/fast fusion white on 100% cotton

One color flash as a SEALER - fuzzy hairs that discolor the sealer

Thick/Thin viscosity -*Sit on top/penetration*

Thick/Thin deposit -*physical thickness as a function of variables*

Pigment loading -*ink classes of opacity [light stopping power]*

HO High Opacity

O Opaque

SO Semi-opaque Translucent

T Transparent

Add more load, uses up the resin power

Thick deposit, pushed into the shirt -*too much pressure*

Flash cure

Light ink on Dark without flash

Process

Process on Dark

Fluorescent

Puff

Metallic

Transfers

Opacity

Mixing with a program

Color Wheel

## **Curing**

Donut probe vs. temperature tapes

Convection vs. IR Panels