

# AVIENT SPECIALTY INKS

## PRODUCT INFORMATION BULLETIN



### 2460 INFINITE FX SHARP CLEAR

Avient™ Specialty Inks INFINITE FX HD SHARP CLEAR is a low-cure special effect clear developed to create high resolution graphics with sharp detail. HD Sharp Clear can be used in high density applications or blended with other texture inks to create unique effects.

#### HIGHLIGHTS

- ▶ Satin finish, dry hand feel
- ▶ Low cure, save energy
- ▶ Super straight-edge definition, excellent sharp-corner properties
- ▶ Use as an overprint clear, tintable or may be overprinted with color
- ▶ Excellent adhesion to fabrics, stretch properties, and wash durability

#### PRINTING TIPS

- ▶ Use consistent, high-tensioned screen mesh and sharp edged squeegees for best print results. Recommended mesh counts can vary depending on particle size
- ▶ For best HD results, use open mesh counts with 200 - 400 micron capillary film and print-flash-print. Use a heavy flood to fully fill the open areas of the stencil with ink then print with medium squeegee pressure
- ▶ HD Sharp Clear stacks easily for HD application. Commonly overprinted with multiple colors for a unique look and feel
- ▶ Suitable for fine mesh printing for tone-on-tone look
- ▶ Tintable with plastisol colorants. See Pigment Loading section for suggested tinting percentages. Adjust the % colorant added based on the strength of the colorants and color saturation desired
- ▶ Surface of clear may appear milky during application but will gain transparency after cured. Clarity of HD Sharp Clear is dependent on thickness
- ▶ Curing is a time and temperature process, a lower oven temperature setting with a slower belt speed while maintaining recommended ink cure temperature is always best to protect fabric and reduce energy consumption
- ▶ INFINITE FX HD SHARP CLEAR can be cured between 270°F - 320°F (132°C - 160°C). Excessive cure temperatures above 350°F (177°C) can result in tacky hand feel, rounded edges, and an increase in gloss

#### COMPLIANCE

- ▶ Non-phthalate
- ▶ For individual compliance certifications and conformity statements, please visit [www.avientspecialtyinks.com/services/compliance-support](http://www.avientspecialtyinks.com/services/compliance-support)

#### PRECAUTIONS

The information above is given in good faith and does not release you from testing inks and fabrics to confirm suitability of substrate and application process to meet your customer standards and specifications

#### RECOMMENDED PARAMETERS



##### Fabric Types

100% cotton, blends, spandex, uncoated nylon, acrylic



##### Mesh

Count: 86-196 t/in (34-77 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



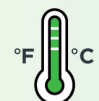
##### Squeegee

Durometer: 60/90/60, 60-70  
Profile: Square, Sharp  
Stroke: Hard flood, Slow stroke  
Angle: 10-15%



##### Stencil

2 over 2  
Off Contact: 1/16" (.2cm)  
Emulsion Over Mesh: 15-20% or 200-400 micron



##### Flash & Cure

Flash: 220°F (105°C)  
Cure: 270°F - 320°F (132°C - 160°C)



##### Pigment Loading

upto 10% Wilflex PC  
upto 15% Wilflex EQ  
upto 40% Wilflex RIO / MX  
up to 30% Rutland C3 Boosters



##### Additives

N/A



##### Storage

65-90°F (18-32°C)  
Avoid direct sunlight  
Use within one year of receipt



##### Clean Up

Dispose unused ink responsibly. Standard plastisol cleaners, press wash, or ink degradant



##### Health & Safety

Find SDS information here:  
[www.avient.com/resources/safety-data-sheets](http://www.avient.com/resources/safety-data-sheets)  
or contact your local CSR



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V1.01 (Modified: 10/27/2022)

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