



10008PFX EPIC™ SPECIAL EFFECTS CLEAR

PRODUCT INFORMATION BULLETIN




WILFLEX™ Epic Special Effects Clear is a non-phthalate plastisol ink developed to create specialty effects such as the appearance of glass, gel, water or high gloss surfaces. Special Effects Clear is a low-cure clear with excellent elongation and wash durability.

RECOMMENDED PARAMETERS


HIGHLIGHTS


- High gel, gloss appearance
- Low cure, save energy
- Use as a High Density Clear, either on its own or tint with color
- Use as an overprint clear to enhance color vibrancy and create gloss surfaces
- Excellent adhesion to fabrics, stretch properties, and wash durability


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


PRINTING TIPS


- Stir inks before printing
- Use consistent, high-tensioned screen mesh and sharp edged squeegees for best print results
- For best HD results and adhesive application, use recommended mesh counts with 200 - 400 micron capillary film
- Print in last position or flash after each print if using multiple screens
- Commonly used to produce glossy wet or water drops effects
- Tintable with PC, Equalizer, RIO or MX finished ink colorants. Adjust the % colorant added based on the strength of the colorants and color saturation desired
- Surface of clear may appear milky after flashing but this effect will disappear after cure. Achieves good clarity at high ink deposits
- 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
- Special Effects Clear can be cured between 270°F - 320°F (132°C - 160°C)

Mesh
 Count: 24-110 t/in (9-43 t/cm)
Tension: 25-35 n/cm2


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


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

Flash & Cure
 Flash: 220°F (105°C)
Cure: 270°F (132°C)
Entire ink film

Pigment Loading
 10% - 15% PC recommended
15% - 30% EQ recommended
25% - 50% RIO recommended
25% - 50% MX recommended

Wilflex™ Additives
 N/A

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

Clean Up
 Ink degradant or press wash

Health & Safety
 Find SDS information here:
www.avient.com/resources/safety-data-sheets
or contact your local CSR

COMPLIANCE

- Non-phthalate
- For individual compliance certifications and conformity statements, please visit: www.avient.com/wilflex-compliance

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



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