



# 10088PFXHDC EPIC™ HD SHARP CLEAR

## PRODUCT INFORMATION BULLETIN

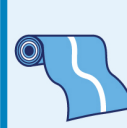


WILFLEX™ Epic HD Sharp Clear is a non-phthalate, low-cure special effect clear developed to create high resolution graphics with sharp detail. HD Sharp Clear can be used in high density applications or blended with other texture inks to create unique effects.

### RECOMMENDED PARAMETERS

#### 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



#### Fabric Types

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



#### Mesh

Count: 24-110 t/in (9-43 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



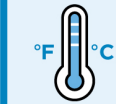
#### Squeegee

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

#### PRINTING TIPS

- ✔ Stir inks before printing
- ✔ Use consistent, high-tensioned screen mesh and sharp edged squeegees for best print results
- ✔ For best HD results, use recommended mesh counts with 200 - 400 micron capillary film and print-flash-print
- ✔ Print in last position or flash after each print if using multiple screens
- ✔ HD Sharp Clear stacks easily for HD application. Commonly overprinted with multiple colors for a unique look and feel
- ✔ 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 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
- ✔ 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
- ✔ Suitable for fine mesh printing for tone-on-tone look

#### COMPLIANCE

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