



AVIENT SPECIALTY INKS

PRODUCT INFORMATION BULLETIN



2535 Infinite FX Particle Base

2535 Infinite FX Particle Base is a crystal clear base specifically designed for printing glitter particles. The particle base allows for infinite creativity in designs and can be mixed with multiple colored glitter flake sizes. 2535 Infinite FX Particle Base is a low-cure special effect with excellent adhesion and wash durability.

RECOMMENDED PARAMETERS

HIGHLIGHTS

- ▶ Add glitter particles to base for infinite designs
- ▶ Low-cure, save energy
- ▶ Tintable with plastisol colorants
- ▶ Use on various colored grounds and underbase for different effects
- ▶ Excellent adhesion to fabrics, stretch properties, and wash durability



Fabric Types

100% cotton, blends, some synthetics



Mesh

Count: 24-61 t/in (9-24 t/cm)
Tension: 25-35 n/cm2



Squeegee

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

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
- ▶ Mix up to 15% glitter particles dependent on particle size and desired look, mix thoroughly. A particle size of .008" x .008" is a good recommendation
- ▶ Print in last position or flash after each print if using multiple screens
- ▶ Print direct to fabric or over a flashed-dried base plate. Use a suitable underbase when printing on garments prone to bleed
- ▶ 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
- ▶ Metallics reflect infrared heat and a forced air dryer is recommended for curing. If using an electric oven, extend dwell time to achieve proper cure
- ▶ 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, control dye migration and reduce energy consumption
- ▶ INFINITE FX GLITTERS can be cured between 270°F - 320°F (132°C - 160°C)
- ▶ Can be mixed with other Infinite FX HD bases or clears
- ▶ For cold-peel transfers, use a coated release paper or polyester film. Print using 70 duro squeegee and recommended mesh counts followed by adhesive. Gel at 212°F (100°C) for 60 sec. Apply transfer with heat press at 300°F (150°C) for 10-12 sec at medium pressure. For transfers on polyester, back with a low bleed white and/or blocker. Verify process.



Stencil

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



Flash & Cure

Flash: 220°F (105°C)
Cure: 270°F (132°C) Entire Ink Film



Pigment Loading

up to 5% Wilflex PC
up to 10% Wilflex EQ
up to 15% Wilflex RIO / MX
up to 10% 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 degreasant



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.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



AVIENT
SPECIALTY
INKS

V1.03 (Modified: 09/26/2024)

2024, Avient Corporation. Avient makes no representations, guarantees, or warranties of any kind with respect to the information contained in this document about its accuracy, suitability for particular applications, or the results obtained or obtainable using the information. Some of the information arises from laboratory work with small-scale equipment which may not provide a reliable indication of performance or properties obtained or obtainable on larger-scale equipment. Values reported as "typical" or stated without a range do not state minimum or maximum properties; consult your sales representative for property ranges and min/max specifications. Processing conditions can cause material properties to shift from the values stated in the information. Avient makes no warranties or guarantees respecting suitability of either Avient's products or the information for your process or end-use application. You have the responsibility to conduct full-scale end-product performance testing to determine suitability in your application, and you assume all risk and liability arising from your use of the information and/or use or handling of any product. AVIENT MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, either with respect to the information or products reflected by the information. This literature shall NOT operate as permission, recommendation, or inducement to practice any patented invention without permission of the patent owner.