



## 10009PFXHDC EPIC™ HD CLEAR 2

WILFLEX™ Epic HD Clear 2 is a non-phthalate clear developed to create the appearance of glass, gel, water or high gloss surfaces. HD Clear 2 can be used in high density applications or blended with other texture inks to create unique effects. It is also an effective adhesive carrier for foil, flock, and other applications.

### HIGHLIGHTS

- High gel, gloss appearance
- Use as foil or flock adhesive
- 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

### 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 as a foil or flock adhesive
- 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 cure. Achieves good clarity at high ink deposits

### 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



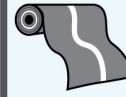
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V3.00 (Modified: 02/18/2021)

## PRODUCT INFORMATION BULLETIN



### RECOMMENDED PARAMETERS



#### 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>



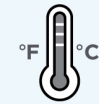
#### Squeegee

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: 320°F (160°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

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