



### Libra™ Clear Gel

#### RECOMMENDED PARAMETERS

##### Fabric Types



100% Polyester, Nylon, Cotton and Poly/Cotton blended fabrics

##### Mesh



Count: 156-305t/in (61-120t/cm)  
Tension: 18-35n/cm3

##### Squeegee



Durometer: 70 or 60-90-60  
Profile: sharp, square  
Stroke: x2 stroke, medium speed  
Angle: 10-15%

##### Stencil



Standard Emulsion  
Off Contact: 1/16" (2mm)  
Emulsion Over Mesh: 25-40 micron

##### Flash & Cure



Flash: 280°F(138°C) for 4 seconds (on preheated pallets)  
Cure: 60 seconds at 270°F(132°C)

##### Pigment Loading



Libra™ Silicone Pigments Maximum 20%

##### Libra™ Additives



Libra™ Retardant: 0.1-2%

##### Storage



Store in sealed containers 12 months from manufacture >40°F (5°C) <77°F(25°C)

##### Clean Up



Standard plastisol cleaners

##### 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

Libra™ Clear Gel is a low-medium viscosity 2-part system (LIB0410 Part A/ LIB0411 Part B) designed to be mixed in a 1:1 ratio with no Catalyst required. This silicone ink provides a crystal clear and high gloss finish for special effect embellishments and can be used with glitters, shimmers and color shifting particles to create eye popping effects. A semi-tacky hand feel and excellent hand and drape-ability are achieved with this gel.

#### HIGHLIGHTS

- Crystal clear, extreme gloss finish
- Semi tacky hand with excellent drapability
- Excellent adhesion to Nylon
- Super-soft hand feel
- Water droplet effect
- DWR (Durable Water Repellents) may effect cure

#### PRINTING TIPS

- Mix Libra™ Clear Gel Part A and B in a 1:1 ratio, no Libra™ Catalyst is required. Libra™ Silicone pigments or special effect powders can be added up to 20 parts. Mix well and print. To prevent wastage only mix what is need to print for 4 hours.
- Use 156-305t/in (61-120t/cm) mesh screens for best performance.
- Printing over an underbase prevents the low viscosity gel from absorbing into fabric and keeps it on top for best effect. Printing over a Libra™ RFU black when using colorshifting pigments will maximize effect.
- Print with 1/16" or 2mm off contact.
- Print two strokes to ensure the mesh is clear and you have a good ink deposit. Flash between prints.
- Clean the stencil area when stopped to prevent screen blockages.
- Prints should be cured at 270°F /132°C for 60 seconds. Check the cure temp at the ink surface.
- Test all prints for print durability before starting the production run. Certain antimicrobial and DWR (Durable Water Repellents) may effect cure.

#### COMPLIANCE

- Non-PVC, non-phthalate
- Visit [www.avient.com/products/screen-printing-inks/zodiac-libra](http://www.avient.com/products/screen-printing-inks/zodiac-libra) for more information

#### 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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