



2470 Infinite FX Therm-O-Line Clear

2470 Infinite FX Therm-O-Line Clear is a multi-purpose high viscosity clear that can be used as an overprint clear, particle carrier, or flock adhesive on garments.

HIGHLIGHTS

- ▶ Semi-gloss gel appearance
- ▶ Use as flock adhesive on garments
- ▶ 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 semi-gloss surfaces
- ▶ Excellent adhesion to fabrics, stretch properties, and wash durability

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
- ▶ For best HD results, use open mesh counts with 200 - 400 micron capillary film and print-flash-print. Use a heavy flood to fully fill the open areas of the stencil with ink then print with medium squeegee pressure
- ▶ Print in last position or flash after each print if using multiple screens
- ▶ 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
- ▶ Amber appearance in the bucket but will gain transparency after cure
- ▶ For flock adhesion, print using 70 duro squeegee 86-110 t/in (34-43 t/cm) with 200 micron stencil and then apply the flock fibers onto the wet ink layer and cure at 320°F (160°C)
- ▶ For improved flock adhesion, add up to 5% Infinite FX Hugger Catalyst. Adding Hugger Catalyst reduces pot life to 4-8 hours

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



RECOMMENDED PARAMETERS



Fabric Types

100% cotton



Mesh

Count: 86-230 t/in (34-90 t/cm)
Tension: 25-35 n/cm²



Squeegee

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



Stencil

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



Flash & Cure

Flash: 220°F (105°C)
Cure: 270°F - 320°F (132°C - 160°C)



Pigment Loading

upto 10% Wilflex PC
upto 15% Wilflex EQ
upto 40% Wilflex RIO / MX
up to 30% Rutland C3 Boosters



Additives

2940 Hugger Catalyst



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 degradant



Health & Safety

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



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