



#### RECOMMENDED PARAMETERS

##### Fabric Types



100% Polyester, Cotton and Poly/  
Cotton blended fabrics

##### Mesh



Count: 80-225/in (31-88/cm)  
Tension: 18-35n/cm<sup>3</sup>

##### Squeegee



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: 300°F(149°C) for 4 seconds (on  
preheated pallets)  
Cure: 60 seconds at 270°F(132°C)

##### Pigment Loading



Libra™ silicone toners Maximum 20%

##### Libra™ Additives



Libra™ Catalyst: 3-5%  
Libra™ Retardant: 0.5-3%

##### 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™ Silicone Specialty Toners are best used with Libra™ Clear Gloss Base to highlight the shimmer and crystallina effect but can be used in any of the Libra™ bases for different finishes.

#### HIGHLIGHTS

- ☞ Toners deliver ease of use for popular specialty ink applications

#### PRINTING TIPS

- ☞ Mix up to 20% Toner to Libra™ Clear Gloss Base or other Libra™ silicone bases. Once Libra™ Toners are mixed in base for desired color, add 3-5% catalyst and mix well before printing.
- ☞ Use 86-225/in (34-88/cm) mesh screens for best performance.
- ☞ 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.

#### 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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