

# AVIENT SPECIALTY INKS

## PRODUCT INFORMATION BULLETIN



### INFINITE FX HD SOFT DENSITY

Avient™ Specialty Inks INFINITE FX HD SOFT DENSITY is specifically formulated for high density printing with a soft texture feel. Printed images can have either a smooth or textured surface depending on mesh counts and printing parameters. HD Soft Density is soft to the touch, durable and stretchable and prints through a wide range of mesh counts and stencil thicknesses.

### RECOMMENDED PARAMETERS

#### HIGHLIGHTS

- ▶ K2574 HD SOFT BASE
- ▶ 11000 HD SOFT WHITE
- ▶ 19000 HD SOFT BLACK
- ▶ Smooth or textured soft surface and good edge definition
- ▶ Tintable for infinite color combinations
- ▶ Excellent adhesion to fabrics, stretch properties, and wash durability
- ▶ Suitable for high density or conventional flat screens

#### Fabric Types



100% cotton, cotton blends, some synthetics

#### 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
- ▶ Best results when printed directly onto fabric
- ▶ Adjust off-contact to imprint mesh patterns into HD Soft Base for textured feel and unique design effect
- ▶ Tintable with plastisol colorants. See Pigment Loading section for suggested tinting percentages. Reduce the amount of white colorant in the formula as specialty base will lighten the color
- ▶ Adjusting cure temperature and dwell time will yield a variety of textured effects

#### Mesh



Count: 86-230 t/in (34-91 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>

#### COMPLIANCE

- ▶ Non-phthalate

#### Squeegee



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

#### PRECAUTIONS

#### 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: 320°F (160°C)

#### Pigment Loading



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

#### Additives



2910 VISCOSITY BUSTER - 1% max  
2912 VISCOSITY BUSTER - 1% max

#### 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](http://www.avient.com/resources/safety-data-sheets)  
or contact your local CSR



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