



Libra™ Gloss Clear Base

RECOMMENDED PARAMETERS



Fabric Types

100% Polyester, Cotton and Poly/
Cotton blended fabrics



Mesh

Counts: 80-225t/in (34-90t/cm)
Tension: 18-35n/cm³



Squeegee

Medium: 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: High Density
100-400 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 Pigments
Maximum 20%



Libra™ Additives

Libra™ Catalyst: 3-5%
Libra™ Retardant: 2-4%
Libra™ Pigment/Toner: up to 20%



Storage

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



Clean Up

Standard plastisol cleaners



Health & Safety

SDS: www.polyone.com/resources/safety-data-sheets
or contact your local CSR

Libra™ Gloss Clear base consists of a medium viscosity translucent base with excellent printability to bring a glossy effect to your silicone prints. The ink can be pigmented with Libra pigments and toners or special effect additives. Designed to achieve a glossy effect with extreme stretchability while maintaining a super-soft flexible hand.

HIGHLIGHTS

-  Glossy finish
-  Clear base
-  Extreme stretchability
-  Non-tacky hand
-  Super-soft hand feel

PRINTING TIPS

-  Use 3-5 parts Libra™ Silicone Catalyst and 0.5-3 parts Libra™ Silicone Retardant to 100 parts Libra™ Gloss Clear Base. Libra™ Silicone toners or special effect powders can be added up to 20 parts. Mix well and print. To prevent wastage only catalyze what is needed to print for 4 hours.
-  Colors should be made in accordance with Libra™ IMS Pantone® mixing system with a maximum of 20% pigment loading.
-  Use 86-225t/34-90t 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.polyone.com/zodiacinks/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