

## 10680W1C WILFLEX ONE CLEAR

Wilflex™ One Clear is a non-PVC, non-phthalate gloss clear for topcoat applications or used as a carrier for metallic and glitter particles to enhance the aesthetic on any print. The clear can also be added to Wilflex One MX colors as an extender or used to improve soft-hand.

### Highlights

- ▶ Non-PVC, Non-phthalate
- ▶ Gloss finish
- ▶ Optical clarity
- ▶ Easily achieve high ink column
- ▶ Excellent stretch
- ▶ Extender for colors or soft hand improvement

### Printing Tips

- ▶ Print - Flash
- ▶ Allow ink to cool prior to printing subsequent layers
- ▶ Use consistent, high-tensioned screen mesh to optimize performance properties

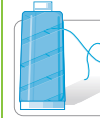
### Compliance

- ▶ Non-PVC, Non-phthalate
- ▶ For individual compliance certifications, please visit [www.wilflex.com/compliance](http://www.wilflex.com/compliance)

### Precautions

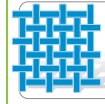
- ▶ Do not dry clean, bleach or iron printed area
- ▶ Stir plastisols before printing
- ▶ Avoid over flashing as it can result in poor intercoat adhesion of colors.
- ▶ Perform fusion tests before production. Failure to cure ink properly may result in poor wash fastness, inferior adhesion and unacceptable durability. Ink flash and cure temperatures should be measured using a thermoprobe placed directly in the wet ink film and verified on the production run substrate(s) and production equipment. It is the responsibility of the printer to determine that the correct ink has been selected for a specific substrate and the application processes meet your customer's standards or specifications.
- ▶ Adjust the time and temperature settings for the flash station and dryer to reach minimal flash and full cure temperatures respectively.
- ▶ Wilflex products have been carefully designed to perform within a given viscosity range and any dramatic change in viscosity may result in a change in printing characteristics
- ▶ **AVOID CONTAMINATION OF NON-PVC INKS:** Do not add or mix other inks, additives or extenders with Wilflex One inks. All buckets, palette knives, stirring apparatus, squeegees, flood bars and screens must be cleaned properly and free of phthalates and pvc-containing inks. Non-phthalate emulsions and pallet adhesives must be used. Failure to follow these precautions may cause phthalate or PVC contamination in violation of consumer protection laws, regulations or brand specifications
- ▶ Any application not referred in this product information bulletin should be pre-tested or consultation sought with Wilflex Technical Services Department prior to printing
- ▶ Email: [techserviceswilflex@polyone.com](mailto:techserviceswilflex@polyone.com)

## Recommended Parameters



### Fabric Types

100% Polyester, cotton/polyester blends, 100% cotton



### Mesh

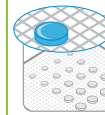
#### Counts:

Metallic & Glitter Carrier (typical):  
25 - 110 t/in (10-43 t/cm)  
Topcoat (typical):  
110 - 180 t/in (43-71 t/cm)  
Tension: 25-45 n/cm<sup>2</sup>



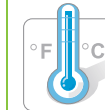
### Squeegee

Durometer: 60-90, 70/90, 70/90/70  
Edge: Sharp  
Stroke: Medium  
*\*Do not use excess squeegee pressure.*



### Non-Phthalate Stencil

Direct: 2 over 2  
Capillary/Thick Film: N/A  
Off Contact: 1/16" (.2cm)



### Flash & Cure Temperatures

Flash: 220°F (105°F) for 3 - 5 seconds  
Cure: 320°F (160°F) peak



### Additives

Reducer: Wilflex One Viscosity Buster  
- 1% max  
*\*All percentages listed at % by weight.*



### Shipping & Storage

65°F - 90°F (18°C - 32°C)  
Avoid direct sunlight  
Use within one year of receipt



### Clean Up

Ink degradent or press wash



### Health & Safety

SDS: [www.polyone.com](http://www.polyone.com) or  
Contact your local CSR.