

# AVIENT SPECIALTY INKS

## 2574 INFINITE FX HD SOFT BASE

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.

### HIGHLIGHTS

- ▶ HD SOFT BASE | 2574
- ▶ HD SOFT WHITE | 11000
- ▶ HD SOFT BLACK | 19000
- ▶ 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

### 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

### COMPLIANCE

- ▶ Non-phthalate
- ▶ For individual compliance certifications and conformity statements, please visit [www.avientspecialtyinks.com/services/compliance-support](http://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



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V1.00 (Modified: 05/10/2021)

## PRODUCT INFORMATION BULLETIN



### RECOMMENDED PARAMETERS



#### Fabric Types

100% cotton, cotton blends, some synthetics



#### Mesh

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



#### Squeegee

Durometer: 70/90/70, 70  
Profile: Square, Sharp  
Stroke: Hard flood, Medium 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: 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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