

## FEATURES

- A plastisol “Clear” that achieves high gloss when used as a base or overprint.
- Very glossy product, which is not sticky or tacky after curing.
- 3809\* Gel Gloss Clear works very good as a High Density clear for “stacking”.
- Has minimal after flash tack and cures at lower temperatures.

\*Lead Compliant (Contains less than 90 ppm lead)

**3809 SPECIAL FX CLEAR**

## Application & Storage Information

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| <b>HOW TO USE</b>                | <p>3809 Special FX Clear should be printed right from the container without modification. Use as a final overprint (print-flash-print method) to produce a clear, glossy wet look. Do not print product wet-on-wet.</p> <p>3809 Special FX Clear is not a low bleed product. Not recommended to be printed over some inks or low bleed underbases that contain blowing agents. Pre-print and test all fabrics before a production run.</p> <p>Make sure the 3809 Special FX Clear is completely cured for best appearance. To maintain maximum gloss level when using 3809 Special FX Clear, allow printed area to cool before stacking garments. Gloss levels may diminish if garments are stacked hot. For best durability, it is recommended that the printed garment be hand washed or machine washed (delicate cycle) inside out and dried with low heat. Do not use bleach or dry clean. Do not iron printed area.</p> |
| <b>SCREEN MESH AND EMULSION</b>  | <p>24-110 t/in or 10-43 t/cm Monofilament Mesh.<br/>Any direct, indirect or capillary plastisol resistant emulsion.<br/>Use 35 to 70 micron.</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |
| <b>SQUEEGEE/FLOODBAR</b>         | <p>65-75 Durometer: Sharp or Beveled Edge<br/>60-90-60 Triple Durometer: Sharp Edge<br/>For High Density — Use a squeegee for the flood bar with</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |
| <b>CURE TEMPERATURE</b>          | <p>325°F (163°) Fusion temperature for entire ink film.</p> <p>Since plastisols do not air dry, they must be fused with an appropriate heat source in order to achieve durability. The optimum time/temperature cycle will vary with the amount of ink deposited, fabric and the type of heat source used. Plastisols achieve proper fusion when the entire ink film reaches the prescribed temperature. Test dryer temperatures before a production run. Wash test printed product before production run.</p>                                                                                                                                                                                                                                                                                                                                                                                                               |
| <b>CLEAN-UP</b>                  | <p>Environmentally friendly plastisol screen wash or mineral spirits.</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |
| <b>STORAGE OF INK CONTAINERS</b> | <p>Keep inks indoor and store in a cool area. Recommend storage at <b>65°F to 90°F (18°C to 32°C)</b>. Avoid storage in direct sunlight or in extreme temperature conditions.</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |