



# AXEON™ Crystal Clear Gel Gloss™ 1807



## RECOMMENDED FABRICS

100% Cotton  
50/50 Cotton/Polyester Blends  
Some Nylon and Polyester Fabrics  
All base coat dependent



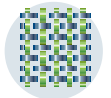
## INK APPLICATION

AXEON™ Crystal Clear Gel Gloss™ should be used right from the container. You **MUST STIR** prior to printing



## ADDITIVES

Not recommended



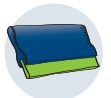
## SCREEN MESH

110 t/in (43 t/cm) monofilament



## EMULSION

Any direct or indirect emulsion or capillary film in the 400 micron range



## SQUEEGEE

60 Durometer  
Set at a 20° angle



## CURE TEMPERATURES

320°F to 330°F (160°C to 165°C)  
For one minute entire ink film



## CLEAN-UP

Any eco-friendly plastisol screen wash



## PRODUCT PACKAGING

Quart, 1 gallon, 5 gallon, 30 gallon or 50 gallon containers



## STORAGE OF INK CONTAINERS

65°F to 90°F (18°C to 32°C)  
Avoid storage in direct sunlight.  
Keep containers well sealed



## SDS

Refer to SDS prior to use

## FEATURES

AXEON™ Crystal Clear Gel Gloss™ 1807 is a non-PVC, non-phthalate acrysol based product that produces a "wet" look when printed on top of other flashed acrysol inks.

AXEON™ Crystal Clear Gel Gloss™ can be used as an over-print coat to create clear, glossy designs which is ideal for adding accents, dimension and interest to a print.

AXEON™ Crystal Clear Gel Gloss™ can also be used as a clear carrier/adhesive for PVC or glass caviar beads.

## GENERAL GUIDELINES FOR APPLICATION:

AXEON™ Crystal Clear Gel Gloss™ 1807 works best when printed on small areas versus large block areas.

AXEON™ Crystal Clear Gel Gloss™ should be printed through a 400 micron capillary film with a 110 mesh screen, using a 60 Durometer squeegee set at a 20° angle, with a double print at a fast stroke speed.

## IMPORTANT INFORMATION

Since acrysol 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. Acrysol actually achieve the proper fusion point as soon as the innermost section of the ink film reaches the prescribed cure temperature. Test dryer temperatures before a production run. Wash test printed product before production run.

Make sure the AXEON™ Crystal Clear Gel Gloss™ 1807 is completely cured for best appearance. To maintain maximum gloss level when using Crystal Clear Gel Gloss, 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.

AXEON™ Crystal Clear Gel Gloss™ 1807 is not a low bleed product. Not recommended to be printed over some inks or low bleed underbases that contain blowing agents.

AXEON™ Crystal Clear Gel Gloss™ 1807 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.

**Do not add** any reducers or additives to Crystal Clear Gel Gloss™ as it will greatly affect the performance of this product. You **MUST STIR** the ink prior to printing, as it is thick straight out of the container.

Test dryer temperatures and wash test printed product before and during a production run.

**Care should be taken to not cross-contaminate the AXEON™ products with PVC or phthalate containing products.** Do not use standard plastisol curable reducers with this or any of the AXEON™ products.

## LEGAL DISCLAIMER

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