



**Technical Bulletin**  
**# 2973**  
***Special 5-Year Clear***  
**UV Curable Screenprinting Inks**

This special product was designed to provide additional protection in the form of UV resistance and chemical protection to our Duraflex DF Series on pressure sensitive vinyl. It can also be used to protect and prolong the life (up to 3 years) of Renegade GP Series inks.

This clear is the final component in the application to produce a printed graphic with outstanding fade and chemical resistance. In order to achieve the extended durability performance it is necessary to use a pressure sensitive vinyl that is rated for 5 year or longer life. Duraflex DF Series inks should be used for all colors if a full 5-year exposure time is required. For shorter-term applications Renegade GP Series is acceptable.

The #2973 Special 5-Year Clear cannot be used as a substitute for #6918 Solar Shield Clear when working under Polymeric Imaging warranty. Solar Shield has UV inhibitors that boost the protective quality of the overprint.

**APPLICATION:**

<b><i>Mixing:</i></b>	Stir well before use
<b><i>Mesh:</i></b>	355 plain weave (140 cm) is best
<b><i>Squeegee:</i></b>	Sharp 80 durometer polyurethane blade
<b><i>Cure Parameters:</i></b>	1 200 watt per inch mercury vapor lamp minimum with belt speed of 50 fpm (approximately 225 Mj). Reading should be based on a radiometer measuring the range of 260-320 nanometers.
<b><i>Adhesion:</i></b>	The cured ink film should have 95% adhesion to the stock after being cured; the ink will require a 4 hour post cure for complete polymerization and resulting performance properties.

*Note: When matching colors for greatest lightfastness, pigment load should be maximized while white and clear is minimized. Avoid using small amounts of a single color, as it will fade at an accelerated rate. Consult Polymeric Imaging if you have questions concerning the appropriate formulas for custom 5-year colors.*

*Effective 04/25/05*

**More than a shade superior**

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