



**HYDRA**

**Clear 77 E** Very transparent flexible base designed to be pigmented, excellent for flat colors.

- Maximum screen: 77 (195) mesh. 48s (123) suggested.

- Becomes a foil-off resistant ink just adding 20-60% of HYDRA FOIL-OFF ADDITIVE and 3% of FLOCK CATALYST.

(Cure at 160°C/3 min. - 320°F x 3 minutes).

**CLEAR 77 E**



## technical sheet

RECIPE nr.1	%	SCREEN	RECIPE nr.2	%	SCREEN	RECIPE nr.3	%	SCREEN
HYDRA FIRST WHITE E	100	48/123	HYDRA CLEAR 77 E	50	77/195	HYDRA CLEAR 77 E	34	77/195
		GEL 3	HYDRA FIRST WHITE E	50	GEL 3	HYDRA FIRST WHITE E	66	GEL 3
		Standard	AQUATINT PIGMENT	5	Standard	AQUATINT PIGMENT	5	Standard
		<b>SQUEEGEE</b>			<b>SQUEEGEE</b>			<b>SQUEEGEE</b>
		60 SHORE			65-90-65			65-90-65
RECIPE nr.4	%	SCREEN	RECIPE nr.5	%	SCREEN	RECIPE nr.6	%	SCREEN
HYDRA CLEAR 77 E	50	77/195	HYDRA CLEAR 77 E	65	77/195	HYDRA CLEAR 77 E	70	77/195
HYDRA FIRST WHITE E	50	GEL 3	HYDRA FIRST WHITE E	35	GEL 3	HYDRA FIRST WHITE E	30	GEL 3
AQUATINT PIGMENT	5	Standard	AQUATINT PIGMENT	5	Standard	AQUATINT PIGMENT	5	Standard
		<b>SQUEEGEE</b>			<b>SQUEEGEE</b>			<b>SQUEEGEE</b>
		65-90-65			65-90-65			65-90-65
PRINTING PARAMETER		PRINTING PROCEDURE				SUITABLE ADDITIVES		
DRYER TEMPERATURE	150°C - 305°F	1	PRINT DOUBLE STROKE - FLASH		<b>HYDRA JET REDUCER:</b>			
CURING TIME	1,5 MIN	2	PRINT DOUBLE STROKE - FLASH		viscosity reducer add 1-3% to the ink.			
SQUEEGEE ANGLE	80°	3	PRINT DOUBLE STROKE - FLASH		In comparison to the other reducers, HYDRA JET REDUCER decreases viscosity especially when the ink is extremely thick.			
PRINTING SPEED	MEDIUM	4	PRINT DOUBLE STROKE - FLASH		<b>Formaldehyde free.</b>			
<b>SCREEN CLEAN UP</b>		5	PRINT DOUBLE STROKE - FLASH		<b>HYDRA RETARDER:</b>			
USE WATER		6	CURE		retarder designed to further improve the HYDRA screen ink stability.			
<b>COMMENTS</b>					Add 3-5% of HYDRA RETARDER to the inks.			
					<b>Formaldehyde free.</b>			
					<b>HYDRA REDUCER 77:</b>			
					To reduce viscosity, just add 3% of HYDRA REDUCER 77.			
					<b>Formaldehyde and phthalate free.</b>			

