

10920WPB Oasis™ Pearl Base

Wilflex™ Pearl Base is a water-based specialty ink designed to produce brilliant, metallic pearlescent finishes. Wilflex Oasis Pearl Base is easy to print, produces a soft hand feel with excellent wash fastness.

Highlights

- ▶ Brilliant metallic effect.
- ▶ Excellent color fastness and durability.
- ▶ Exceptional opacity.
- ▶ Can be pigmented with Oasis WPCs.

Printing Tips

- ▶ Stir in Wilflex Oasis pigments, up to 6% max by weight. Pearlescent effect may alter color intensity. Check color after cure.
- ▶ Keep the stencil in the unflooded position when printing stops. To avoid “drying-in” of stencil, cover the screen with a moist towel during any break lasting more than a few minutes. Avoid leaving ink in the screen for prolonged periods.

Compliance

- ▶ Non-PVC, non-phthalate.
- ▶ For compliance certifications, please visit www.wilflex.com/compliance.

Precautions

- ▶ Screens must be prepared with water-resistant emulsion to prevent stencil breakdown on press. Some emulsions will require a hardener to further prevent the printing process from degrading the stencil.
- ▶ To avoid ink interaction in the image area, verify that the screen mesh is clean of previous ghost images. The image area must be clean and de-hazed.
- ▶ Ink cure temperature is recommended at 340°F (171°C) for 2 full minutes. Check the cure temperature at the ink surface.
- ▶ Infrared dryers may affect curing times. Carefully test and monitor different heat capacities to ensure full cure of inks.
- ▶ Most substrates are suitable for printing; however, fibers which possess a low surface adhesion (e.g. polypropylene, silk, polyamide or wool) will require special care during drying and cure processes. Test all fabrics for color fixation and wash fastness before starting any production runs.
- ▶ Perform fusion tests before production. Failure to cure ink properly may result in poor wash fastness, inferior adhesion and unacceptable durability. Ink flash temperatures should be measured on the ink surface using an infrared thermometer sensor. Ink cure temperatures should be measured using a Thermoprobe placed directly in the wet ink film (printed) and verified on the production run substrate(s) and production equipment. It is the responsibility of the printer to determine that the correct ink has been selected for a specific substrate and the application processes meet your customer's standards or specifications.
- ▶ Containers must maintain air-tight seal when not in use.
- ▶ **NON-CONTAMINATION OF OASIS INKS:** Do not add or mix non-Oasis inks, additives or extenders with Oasis inks. All buckets, palette knives, stirring apparatus, squeegees, flood bars and screens must be cleaned properly and free of phthalates and PVC containing inks. Non-phthalate emulsions and pallet adhesives must be used. Failure to follow these precautions may cause phthalate contamination in violation of consumer protection laws and regulations.
- ▶ Any application not referred in this product information bulletin should be pre-tested or consultation sought with Wilflex Technical Services Department prior to printing.
- ▶ Email: techserviceswilflex@polyone.com

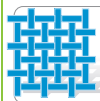
Opacity	8	
Bleed Resistance	N/A	
Smooth Surface	N/A	
Flash	7	
Gloss	N/A	
Printability	9	

*Values listed 1-9, with 9 being the best rating.



Fabric Types

100% cotton, cotton/poly blends



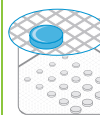
Mesh

Counts: 61-110 t/in (24-43 t/cm)
Tension: 25-35 n/cm²



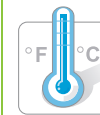
Squeegee

Durometer: 60-70, 60/90/60
Edge: Square, Sharp
Stroke: Soft Stroke, Medium Speed
Angle: Steep (15-20°)
**Do not use excess squeegee pressure.*



Water-Resistant Stencil

Direct: 2 over 2
Capillary/Thick Film: N/A
Off Contact: 1/16" (.2cm) or lower
Emulsion-over-Mesh: 15-20%



Flash & Cure Temperatures

Flash: N/A
Cure: 2 minute @ 340°F (171°C)



Pigment Loading

WPC: 6% max
**All percentages listed at % by weight.*



Oasis Additives

N/A
**All percentages listed at % by weight.*



Storage

37-104°F (3-40°C)
Use within one year of manufacture date.
Keep containers sealed at all times.



Clean Up

Warm Soap Water (Tap)
Gentle Pressure



Health & Safety

MSDS: www.polyone.com or
Contact your local CSR.