

## 10008WOX Wilflex Oasis™ Special Effects Clear

Wilflex™ Oasis Special Effects Clear is a waterbase ink designed to create high gloss “gel” effects with a virtually tack-free dry surface.

### Highlights

- ▶ Good wash fastness and durability.
- ▶ Good elongation.
- ▶ Smooth, gloss surface with minimal tack.
- ▶ Prints easily on manual and automatic presses.
- ▶ Can also be utilized as a carrier for metallic pigments and particles.

### Printing Tips

- ▶ To achieve a clear, gel finish, the prints will require a secondary heat stamp process.

### Compliance

- ▶ Non-PVC, non-phthalate.
- ▶ For compliance certifications, please visit [www.wilflex.com/compliance](http://www.wilflex.com/compliance).

### Precautions

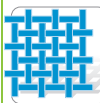
- ▶ Perform fusion tests before production. Failure to cure ink properly may result in poor wash fastness, inferior adhesion and unacceptable durability. Ink flash temperatures should be measured on the ink surface using an infrared thermometer sensor. Ink cure temperatures should be measured using a 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.
- ▶ 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.
- ▶ Excess additions of Oasis additives into Oasis inks may adversely affect ink properties.
- ▶ Ink cure temperature is recommended at 320°F (160°C) for 1 full minute. Check the cure temperature at the ink surface.
- ▶ 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](mailto:techserviceswilflex@polyone.com)

## Recommended Parameters



### Fabric Types

100% cotton, cotton blends, Lycra, uncoated nylon. \*Not suitable for all nylon substrates. Pre-test prior to production.



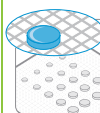
### Mesh

Counts: 60-156 t/in (24-62 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



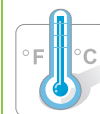
### Squeegee

Durometer: 60, 60/90/60, 70  
Edge: Square, Sharp  
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: 180-200°F 3-5 seconds  
Cure: 1 minute @ 320°F (160°C)



### Pigment Loading

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



### Oasis Additives

Oasis Softener: 0.5% rate, 3% max.  
Oasis Retarder: 1% rate, 3% max.  
Oasis Thickener: 0.1% rate, 1% max.  
Refer to Oasis base PIB  
*\*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.  
Insulate product to avoid extreme hot or cold temperatures.



### Clean Up

Warm Soap Water (Tap)  
Gentle Pressure



### Health & Safety

MSDS: [www.polyone.com](http://www.polyone.com) or  
Contact your local CSR.