

## 10500WSB Wilflex Oasis™ Hydrosoft Base

Wilflex™ Oasis Hydrosoft is a water-based printing ink designed to produce superb soft hand prints with excellent fine detail for halftone graphics. The addition of Oasis water-based pigments (WPC) will result in strong color development, excellent hand, and good wash and crock fastness on white and light fabric grounds.

### Highlights

- ▶ Super soft hand with excellent color fastness and durability.
- ▶ Excellent fine detail for halftone graphics.
- ▶ Wet-on-wet printing capabilities.
- ▶ WPC color mixing system support.
- ▶ Low viscosity ink that will print easily on manual and automatic presses.

### Printing Tips

- ▶ Use 110-160 t/in (43-62 t/cm) screen mesh for large coverage areas and non-detailed graphics. Print detailed images with 180-230 t/in (70-91 t/cm) screen mesh.
- ▶ Use wet-on-wet printing application.
- ▶ Print with no off-contact for enhanced soft hand feel.
- ▶ Stir in Wilflex Oasis pigments up to 6% max by weight.
- ▶ 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](http://www.wilflex.com/compliance).

### Precautions

- ▶ Completely mix pigments before any printing.
- ▶ Excess additions of Oasis additives or WPCs into Oasis inks may adversely affect ink properties.
- ▶ 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 (170°C) for 1 full minute. 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.
- ▶ Avoid synthetic fabrics where dye migration will occur.
- ▶ 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](mailto:techserviceswilflex@polyone.com)



#### Fabric Types

100% cotton, some synthetics, some blends



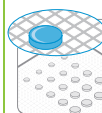
#### Mesh

Counts: 110-230 t/in (43-91 t/cm)  
Tension: 20-35 n/cm<sup>2</sup>



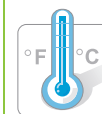
#### Squeegee

Durometer: 60-70, 70/90/70  
Edge: Square, Sharp  
Stroke: Hard Stroke, Medium Speed  
Angle: Slight (<10°)  
*\*Do not use excess squeegee pressure.*



#### Water-Resistant Stencil

Direct: 2 over 2  
Capillary/Thick Film: N/A  
Off Contact: Print on-contact  
Emulsion-over-Mesh: 15-20%



#### Flash & Cure Temperatures

Flash: N/A  
Cure: 1 minute @ 340°F (170°C)



#### Pigment Loading

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



#### Oasis Additives

Oasis Thickener: 0.1% rate, 1% max.  
Oasis Saturate: 0.1% rate, 1% max  
*\*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](http://www.polyone.com) or  
Contact your local CSR.