

## 0 14250WOS Wilflex Oasis™ Suede Base

Wilflex™ Suede Base is a water-based specialty ink designed to produce multiple textured effects based on the stencil thickness. Lower stencil thickness will yield a smooth, velvety texture, while high density screens produce an expanding foam effect. Wilflex Oasis Suede Base is easy to print, has excellent wash fastness and can be pigmented with Oasis WPC pigments.

### Highlights

- ▶ Soft velvety texture.
- ▶ Excellent color fastness and durability.
- ▶ Exceptional opacity.
- ▶ Low cure temperature allowing for reduced energy consumption.

### Printing Tips

- ▶ Stir in Wilflex Oasis pigments, up to 6% max by weight. Expansion effect may alter color intensity. Check color after cure.
- ▶ Printing through high mesh counts (160 t/in, 62 t/cm) with low stencil thickness (15-20% emulsion-over-mesh) will yield a smooth, velvety texture. Use low mesh counts (86 t/in, 34 t/cm) with high density screens (200-400 microns) to produce expanding foam effect.
- ▶ 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

- ▶ 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 320°F (160°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.
- ▶ 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.
- ▶ Printing through capillary films may affect wash properties. Ensure full cure throughout ink film.
- ▶ 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)



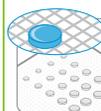
**Fabric Types**  
100% cotton, cotton/poly blends



**Mesh**  
Counts: 86-305 t/in (34-120 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



**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: 200 microns  
Off Contact: 1/16" (.2cm) or lower  
Emulsion-over-Mesh: 15-20%



**Flash & Cure Temperatures**  
Flash: N/A  
Cure: 1 minute @ 320°F (160°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](http://www.polyone.com) or  
Contact your local CSR.