

10000WDB Wilflex Oasis™ Discharge Base

20000WDA Wilflex Oasis™ Discharge Activator

Wilflex™ Oasis Discharge Base is a neutral water-based binder that is activated with Oasis Discharge Activator. Oasis Discharge inks can be used on dischargeable cotton fabrics to produce excellent results with bright color development and superior soft hand feel.

Highlights

- ▶ Super soft hand feel with good color fastness and durability.
- ▶ Excellent discharge with bright color results.
- ▶ Can be used with Oasis Hydrate inks to yield soft prints with vibrant long-lasting color.
- ▶ 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.
- ▶ Print with no off-contact for enhanced soft hand feel.
- ▶ Use wet-on-wet printing application.
- ▶ Stir in pigments (up to 8% max by weight) before adding Oasis Discharge Activator powder.
- ▶ Mix Discharge Activator (up to 6% max by weight) with Oasis Discharge products to create finished discharge ink.
- ▶ Completely dissolve activator powder into Oasis Discharge products with a constant stirring action. Allow mixed product to “rest” 10-15 minutes before use. To avoid waste of activated product, only mix quantities which can be consumed in a 4 hour period.
- ▶ If flash curing is required, the discharge effect will not be completely visible until the ink has been fully cured.
- ▶ Longer oven exposure times will improve discharge 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.

Precautions

- ▶ **Carefully read MSDS before attempting to mix any Oasis Discharge inks.**
- ▶ Textiles printed with a ZFS (Zinc Formaldehyde Sulfoxylate) activator should either be washed before packaging, or labeled accordingly to alert the buyer of the presence of Formaldehyde on the garment.
- ▶ 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 350°F (175°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.
- ▶ Test all fabrics for discharge reaction and wash fastness before starting any production runs, including different lot numbers and different colored fabrics. Some dyes may not be dischargeable and variable results may be found between dye lots. Contact your garment supplier(s) for recommendations on garments that are known to discharge with consistent results.
- ▶ 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



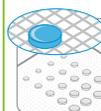
Fabric Types
100% dischargeable cotton



Mesh
Counts: 110-230 t/in (43-91 t/cm)
Tension: 20-35 n/cm²



Squeegee
Durometer: 60-70, 60/90/60
Edge: Square, Sharp
Stroke: Medium-Fast
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: 180-200°F (80-95°C) ink temp
Cure: 1 minute @ 350°F (175°C)



Pigment Loading
WPC: 8% max
**All percentages listed at % by weight.*



Oasis Additives
Oasis Discharge Activator: 6% 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
***Carefully read MSDS to ensure proper disposal of activated products.**



Health & Safety
MSDS: www.polyone.com or
Contact your local CSR.
***Carefully read MSDS to ensure proper disposal of activated products.**