



Wilflex™ Oasis Formulation Guidelines

Wilflex Oasis Hydrosoft, Hydrate, Intense, Discharge Series

The Wilflex Color Design Lab has added first phase of our Pantone® simulations in the Wilflex Oasis module in the IMS software and now available for download at www.wilflex.com. Wilflex Oasis Color Mixing System has been Pantone licensed and certified. Included in IMS3.0 formulation database are starting formulations for Pantone® simulations (Coated) using 10500WSB Wilflex Oasis Hydrate Neutral.

Color Evaluation Specifications

- The following printing parameters were used in the Pantone certification.

Substrate:	White 100% cotton	Durometer:	60-70 shore, 60/90/60
Mesh:	156 thr/in. (61 thr/cm)	Squeegee Edge:	Square, Sharp
Light Source:	Cool White Fluorescent 4100 ⁰ illuminant	Squeegee Angle:	Steep (15-20°)
Screen Tension:	20-35 n/cm ²	Manual Application:	Double Stroke. Medium speed, Minimal pressure
Off Contact:	1/16" (.2cm) or lower	Cure:	2 minutes @ 340°F (171°C)

- Formulations have been produced using a spectrophotometer. Using input values of our Oasis pigments and bases, this instrument can read and predict color value.
- Oasis low formaldehyde (LF) pigments are intended for low formaldehyde applications (infant and children wear) requiring stringent compliance standards. (LF) pigments offer better heat stability and improved wash results.

Pigment Palette

Wilflex Oasis Colorant	Description
41011WPCFS Oasis Extra White PC	Medium strength white dispersion.
41030WPCFS Oasis Bright Orange PC	Strong red-shade orange dispersion
41045WPCFS Oasis Maroon PC	Very strong maroon dispersion. Tint is very blue and not as clean as Magenta. Excellent for making maroon or burgundy colors requiring a blue undertone.
41047WPCFS Oasis Magenta PC	Strong, clean magenta dispersion. Blue undertone with a clean tint and excellent for making fuchsia and rhodamine colors.
41057WPCFS Oasis Violet PC	Strong blue-shade purple dispersion. Color and tinting strength product effective color with very small amounts. Excellent for making purples and royals.
41065WPCFS Oasis Marine Blue PC	Strong red-shade blue dispersion. Excellent for making dark blues with red undertone.
41068WPCFS Oasis Blue G/S PC	Strong green-shade blue dispersion. Excellent for making dark blues with green undertone.
41070WPCFS Oasis Green PC	Strong blue-shade green dispersion. Excellent for creating turquoise and aqua inks.
41083WPCFS Oasis Blaze Gold PC	Strong red- shade yellow dispersion. Not as clean as 41087 in tint value. Excellent for making golds, oranges and some reds.
41087WPCFS Oasis Bright Yellow PC	Strong bright yellow dispersion with clean mass and tint tones.
41094WPCFS Oasis Black PC	Strong black dispersion with bluish tint. Excellent for making blue tinted grays and black.
41165WPCFS Oasis Ultramarine PC	Clean red-shade blue dispersion. Excellent toner when small additions of blue are required.
41001WPCFS Oasis LF Electron Yellow PC	Very clean bright fluorescent yellow dispersion. Weak tinting strength with a green undertone.
41003WPCFS Oasis LF Elec. Blue PC	Fluorescent blue dispersion. Dullest of all the fluorescent colorants. Weak tinting strength with a green undertone
41004WPCFS Oasis LF Fluo. Pink PC	Bright fluorescent pink dispersion. Weak tinting strength with a blue undertone.
41005WPCFS Oasis LF Fluo. Purple PC	Bright fluorescent purple-violet dispersion. Weak tinting strength with a red- blue undertone. Excellent for making difficult clean purple and magenta colors.
41006WPCFS Oasis LF Elec. Red PC	Bright fluorescent red dispersion. Weak tinting strength. Excellent for making clean bright red and orange colors.



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Q & A

Color matching with Wilflex Oasis water based pigments

1. How important is the print application in color evaluation?
 - Water base color matching is more sensitive and less forgiving than plastisol.
 - Color evaluation should be conducted under exact production job specifications.
 - Formulations should be verified prior to production as substrate, mesh count, squeegee profile, and pressure can alter color appearance.
2. What are recommended pigment loadings for custom blends?
 - Oasis Hydrosoft (Regular and Express)
 - i. 6% all pigments
 - Oasis Hydrate (Regular and Express)
 - i. 6% all pigments
 - Oasis Discharge
 - i. 8% all pigments
 - Oasis Intense
 - i. 8% maximum for regular pigments, 15% maximum for fluorescent pigments.
3. How do I convert a Hydrate formula to another Oasis Mixing Base?
 - Light Substrates: Begin with starting formula from IMS3.0 and substitute alternate Oasis mixing base 1:1.
 - Dark Substrates using White base plate: Use a 25:40 Blend of Oasis Mixing Base and 11015WOW Wilflex Oasis Mixing White when matching pastels and mid tone colors. Not recommended for discharge base.
4. I've noticed that 2 pigments have been added. Why and when should they be used?
 - 41083WPCFS Blaze Gold
 - 41083WPCFS Blaze Gold is designed to achieve bright gold color when printing over a base plate white where color shifts are more prevalent.
 - Gold values have been created using 41087WPCFS Bright Yellow plus tinting pigments. These formulas are intended for direct printing applications where color value is not as sensitive to ink deposit.
 - 41165WPCFS Ultramarine is a clean, red shade blue value. Ultramarine is a complement to our 41065WPCFS Marine pigment and should be used when small amounts of blue are needed.
5. What are the best practices for color blending using water based pigments?
 - We recommend a balance with .01 g accuracy. Precision weighing of the pigments is necessary. With a 6% maximum total pigment loading, many of the components are small and should be weighed carefully and accurately. If your scale weighs to the .1 g, we recommend a minimum of 2000 gram batch.
 - Always stir before using to ensure there is no settling in the bottom of the container
 - When adding the pigments to the base, it is important that the pigment does not dry out. Best practice is to deliver the pigments directly into the base, as opposed to the side of the mixing container.

WE'RE LISTENING

We are committed to providing you the best in color mixing systems. Should you have questions on color mixing or formulas, please contact via [email](#).



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