

10645W1UBG WILFLEX ONE UNDERBASE GRAY

Wilflex™ Underbase Gray is a non-PVC, non-phthalate premium plastisol ink designed to block dye migration on 100% polyester and polyester blends. Wilflex One Underbase Gray has high-performance bleed resistance properties and excellent fiber matte down to achieve a smooth and dye-free surface even on the toughest fabrics. The gray color provides a good neutral foundation to aid subsequent layers in quickly achieving opacity for an overall efficient process on the press.



Highlights

- ▶ Non-PVC, Non-phthalate
- ▶ High-performance, bleed resistance properties
- ▶ Good fiber matte-down
- ▶ Matte finish
- ▶ Smooth surface
- ▶ Excellent stretch



Printing Tips

- ▶ For best results, Print - Flash - Print followed by color
- ▶ Alternate process, Print - Flash followed by color
- ▶ Allow ink to cool prior to printing subsequent layers
- ▶ Use consistent, high-tensioned screen mesh to optimize performance properties
- ▶ To optimize bleed resistance, set the dryer belt at the highest possible speed while still ensuring that the ink film reaches 300°F (149°)



Compliance

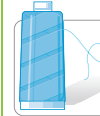
- ▶ Non-PVC, Non-phthalate
- ▶ Passes major brand restricted substance list (RSL) and manufacture restricted substance list (MRSL) requirements
- ▶ For individual compliance certifications, please visit www.wilflex.com/compliance



Precautions

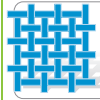
- ▶ Do not dry clean, bleach or iron printed area
- ▶ Stir plastisols before printing
- ▶ Avoid over flashing as it can result in poor intercoat adhesion of colors.
- ▶ Perform fusion tests before production. Failure to cure ink properly may result in poor wash fastness, inferior adhesion and unacceptable durability. Ink flash and cure temperatures should be measured using a thermoprobe placed directly in the wet ink film 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.
- ▶ Adjust the time and temperature settings for the flash station and dryer to reach minimal flash and full cure temperatures respectively.
- ▶ Wilflex products have been carefully designed to perform within a given viscosity range and any dramatic change in viscosity may result in a change in printing characteristics
- ▶ **AVOID CONTAMINATION OF NON-PVC INKS:** Do not add or mix other inks, additives or extenders with Wilflex One 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 or PVC contamination in violation of consumer protection laws, regulations or brand specifications
- ▶ 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

Recommended Parameters



Fabric Types

100% polyester, cotton/polyester blends



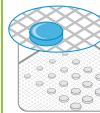
Mesh

Counts: 86 - 156 t/in (34 - 61 t/cm)
Tension: 25-45 n/cm²



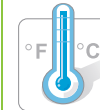
Squeegee

Durometer: 60-90, 70/90, 70/90/70
Edge: Sharp
Stroke: Hard flood, fast stroke
**Do not use excess squeegee pressure.*



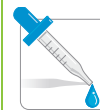
Non-Phthalate Stencil

Direct: 2 over 2
Capillary/Thick Film: N/A
Off Contact: 1/16" (.2cm)



Flash & Cure Temperatures

Flash: 220°F (105°C) for 3 - 5 seconds
Cure: 300°F (149°C)



Additives

Reducer: Wilflex One Viscosity Buster
- 1% max
**All percentages listed at % by weight.*



Shipping & Storage

65°F - 90°F (18°C - 32°C)
Avoid direct sunlight
Use within one year of receipt



Clean Up

Ink degradant or press wash



Health & Safety

SDS: www.polyone.com or
Contact your local CSR.