wilflex™

Product Information Bulletin

WILFLEX™ ONE MX COLOR MATCHING

Wilflex™ One MX Colors are non-PVC, non-phthalate mixing colors engineered to accurately match Pantone PMS and major brand colors. Wilflex One offers the most extensive color range in the market. The MX colors are balanced for opacity and accuracy to optimize performance on press while giving color vibrancy that the consumer demands. Wilflex One MX colors are lasting with excellent crock and wash resistance to meet the most stringent brand requirements

Highlights

- Non-PVC, Non-phthalate
- Creamy, consistent viscosity
- Matte finish
- Smooth surface
- Excellent stretch
- Vector or half-tone capable
- 17 intermixable colors
  - 11888W1MX Wilflex One Mixing White
  - 19888W1MX Wilflex One Black
  - 38888W1MX Wilflex One Orange
  - 48887W1MX Wilflex One Red
  - 48889W1MX Wilflex One Magenta
  - 58888W1MX Wilflex One Violet
  - 68887W1MX Wilflex One Bright Blue
  - 68888W1MX Wilflex One Marine
  - 68889W1MX Wilflex One Blue
  - 78888W1MX Wilflex One Green
  - 88881W1MX Wilflex One Yellow NM
  - 88889W1MX Wilflex One Gold
  - 98880W1MX Wilflex One Fluorescent Pink
  - 98883W1MX Wilflex One Fluorescent Orange
  - 98884W1MX Wilflex One Fluorescent Red
  - 98885W1MX Wilflex One Fluorescent Purple
  - 98888W1MX Wilflex One Fluorescent Yellow

Printing Tips

- Print - Flash
- Allow ink to cool prior to printing subsequent layers
- Use consistent, high-tensioned screen mesh to optimize performance properties

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

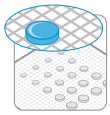
- Do not dry clean, bleach or iron printed area
- Stir plastisols before printing
- Avoid over flashing as it can result in poor intercoat adhesion of colors.
- Perform fusion tests before production. Failure to cure ink properly may result in poor wash fastness, inferior adhesion and unacceptable durability. 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, 100% cotton

Mesh
Counts: Vector (typical):
110 - 156 t/in (43 - 61 t/cm)
Fine line (typical):
180 - 230 t/in (70 - 90 t/cm)
Half-tone (typical):
230 - 305 t/in (90 - 120 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 degradent or press wash

Health & Safety
SDS: www.polyone.com or
Contact your local CSR.