

10100WOI Wilflex Oasis™ Intense Base

Wilflex™ Oasis Intense Base is a high solids water-based printing ink designed to provide maximum opacity with brilliant color saturation and a soft-dry hand feel. Oasis Intense Base cures at lower processing temperatures to provide increased print volume throughput with reduced energy consumption.

Highlights

- ▶ Smooth, matte surface with minimal tack.
- ▶ Soft finish with excellent color fastness and durability.
- ▶ Flashes dry and fast.
- ▶ Good screen “open” time.
- ▶ High strength, designed for bright color development and greater ease in achieving colors on press.
- ▶ Low viscosity ink that will print easily on manual and automatic presses.
- ▶ Exceptional opacity.
- ▶ Excellent wash fastness.

Printing Tips

- ▶ Intense Base can be used as a flash and as a clear under base. Utilize a white under base for increased opacity and bright color development on dark garments.
- ▶ Use 86-160 t/in (34-62 t/cm) screen mesh for large coverage areas and non-detailed graphics. Print detailed images with 180-280 t/in (70-110 t/cm) screen mesh.
- ▶ For increased opacity, substitute Oasis Extra White PC with Oasis Hydrate HO White as pigment concentrate when mixing custom colors.
- ▶ Intense inks will re-wet and flow when printed a few times after a break. Keep the flood bar down and clear from the image. Flooding over the image will cause more drying, as more surface area is exposed to the air.
- ▶ 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 information, please visit www.wilflex.com/compliance.

Precautions

- ▶ Perform fusion tests before production. Failure to cure ink properly may result in poor wash fastness, inferior adhesion, and unacceptable durability. Ink gel 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 and specifications.
- ▶ 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.
- ▶ 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. Use Oasis Bleed Blocker Black or Oasis Bleed Blocker Gray as an underbase when printing on polyester to avoid dye migration issues.
- ▶ Excess additions of Oasis additives into Oasis inks may adversely affect ink properties.
- ▶ Infrared dryers may affect curing times. Carefully test and monitor different heat capacities to ensure full cure of inks.
- ▶ Ink cure temperature is recommended at 320°F (160°C) for 1 minute(s). Check the cure temperature at the ink surface.
- ▶ 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% cotton, some synthetic, polyester substrates (with Oasis Bleed Blocker Gray or Bleed Blocker Black)



Mesh

Counts: 86-280 t/in (34-110 t/cm)

Tension: 18-35 n/cm²



Squeegee

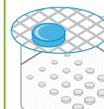
Durometer: 60, 60/90/60, 70, 70/90/70

Edge: Sharp, Square

Stroke: Medium-Fast

Angle: Steep (15-20%)

**Do not use excess squeegee pressure.*



Water-Resistant Stencil

Direct: N/A

Capillary/Thick Film: N/A

Off Contact: 1/16" (.2cm) or lower

Emulsion-over-Mesh: 15-20%



Flash & Cure Temperatures

Flash: 250-300°F depending on flash type

Cure: 1 minute @ 320°F (160°C)



Pigment Loading

WPC: 8%- Colors, 15%- Fluorescents

**All percentages listed at % by weight.*



Oasis Additives

Oasis Softener: 0.5% rate, 3% max.

Oasis Retarder: 1% rate, 3% max.

Oasis Thickener: 0.1% rate, 1% 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



Health & Safety

MSDS: www.polyone.com or

Contact your local CSR.