

WILFLEX® ROCK BASE 10670RB

DESCRIPTION

Use Rock Base alone or in combination with other products to create super textured effects, such as solid rock, coarse rope or fabric-textured surfaces.

PRINTER'S PARAMETERS

Substrates	100% cotton, cotton blends, acrylic, lycra, uncoated nylon
Bleed resistance	Good
Mesh	24-230 t/in (10-90 t/cm)
Tension	25 newtons
Stencil emulsion	Direct, indirect & capillary
Fat films for HD printing	200-600 microns
Squeegee type	75 durometer- (60/90/60) triple durometer
Squeegee blade	Sharp
Squeegee angle	45 degrees
Squeegee speed	Medium
Off-contact	1/16"
Gel temp	220 F (104 C)
Cure temp	350 F (171 C) entire film
Extender	None
Reducer	3% max (by weight) Reducer #11
Storage	65-90 F (18-32 C). Avoid direct sun. Use within one year of receipt.
Wash-up	Wilflex Screen Wash. Be sure not to scrub HD images when cleaning.
Health & Safety data	Available upon request

FEATURES

- Tough, stretchable textured surface
- Excellent adhesion to fabrics
- Excellent washability
- For light or dark fabrics
- Use as stand alone base or with additions of other additives to achieve many textured surface finishes
- Part of the "Wilflex First Base" program

SCREEN PREPARATION

- Use screens meshes from 83 to 230 threads/in.
- Stretch screen to 25 newtons tension.
- Can be used with High Density films such as 200-400 micron film.

SPECIAL RECOMMENDATIONS

- Can be used as a conventional flat print ink.
- Can be used as a High Density Ink.
- Addition of pigments and other additives to the base should not exceed 15 percent by weight.
- To gain higher ink yields, use a print/flash/print method for both flat and high density printing.
- Complete curing is important. Multiple dryer passes may be necessary to ensure total cure.
- Perform fusion tests before production. Failure to cure ink properly can result in poor wash fastness, inferior adhesion, unacceptable durability, and increased likelihood of dye migration. Testing procedures for plastisol fusion are outlined in the Wilflex User's Manual.
- Stir plastisols prior to printing.
- Do not dry clean, bleach or iron printed area.
- Any application not referenced in this product information bulletin should be pre-tested or consultation sought with Wilflex Technical Services Department prior to printing (US - 800-735-4353).

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