

C One-Step Nylon

Wilflex One-Step Nylon Ink is formulated to print onto “untreated” nylon. The ink can be used like a standard plastisol ink and will not dry in the screen or harden in the container. OSN inks flash quickly and allow multi-ink production, with cure/gel temperatures of 300 F (149 C).

Highlights

- ▶ Compliant with CPSIA (Consumer Product Safety Improvement Act) 2008
 - ▶ Section 101, Lead Content in Substrates (<300 ppm lead);
 - ▶ 16 CFR, Part 1303, Lead in Paint (<90 ppm lead).
- ▶ Excellent for printing untreated nylon fabrics ranging from coarse deniers used in backpacks and luggage to finer deniers used in garments/umbrellas.
- ▶ Can be used with or without the Hugger Catalyst.
- ▶ Good opacity.



Printing Tips

- ▶ One-Step Nylon inks should NOT be used on waterproofed satin jackets or when printing onto waterproofed nylon materials. If the nylon material has been treated to repel water, the waterproofing must be removed, and the addition to ink of Hugger Catalyst at 10% by weight will be necessary. Wipe down the print area with rubbing alcohol or acetone if printing on a tightly woven jacket material.
- ▶ The Hugger Catalyst chemistry activates upon exposure to moisture in the air. The amount of moisture exposure determines the shelf life of the mixed ink. Pot life generally ranges from 4-8 hours.
- ▶ Use consistent, high tension screen mesh to optimize performance properties.



Precautions

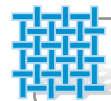
- ▶ Perform fusion tests before production. Failure to cure ink properly may result in poor wash fastness, inferior adhesion and unacceptable durability. Ink gel and cure temperatures should be measured using a Thermoprobe placed directly in the wet ink film and verified on the production run substrate(s) 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 or specifications.
- ▶ Ink mixed with Hugger Catalyst must be removed from the screen immediately following printing with cleaning solvents to prevent permanent mesh damage. Squeegees and any other printing apparatus must also be cleaned immediately.
- ▶ Hot cleaning solvents (containing Toluene, Xylene, and Acetone etc.) will react with this ink causing hardening in the screen.
- ▶ Avoid excessive overflashing, as it can result in poor inter-coat adhesion of overprint colors.
- ▶ Gently stir plastisol prior to printing.
- ▶ Do not dry clean, bleach or iron the printed area.
- ▶ Any application not referred in this product bulletin should be pre-tested or consultations sought with Technical Services Department prior to printing.
- ▶ Email: techserviceswilflex@polyone.com

Printing Parameters

Opacity	7	
Bleed Resistance	n/a	
Smooth Surface	9	
Flash	7	
Gloss	5	
Printability	8	



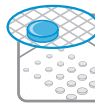
Fabric Types
Untreated 100% Nylon



Mesh
Counts: 60-195t/in (24-77 t/cm) recommended
Tension: 25-35 n/cm² recommended



Squeegee
Durometer: 60-90
Edge: Straight edge
Stroke: Medium



Stencil
Direct: 2 over 2
Capillary/
thick film: n/a
Off contact: 1/16"



Gel/Cure Temperatures
Gel Temp: 155 F (116 C)
Cure Temp: 300 F (149 C) entire film



Pigment Loading
PC: n/a
EQ: n/a
MX: n/a



Additives
Extender: n/a
Reducer: n/a



Storage
65-90 F (18-32 C). Avoid direct sun. Use within one year of receipt.



Clean Up
Wilflex Screen Wash



Health & Safety
MSDS: www.polyone.com