



PRODUCT GUIDE

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PRODUCT GUIDE

QCM Distributors – Domestic

ALABAMA

GRC REMESH & SCREEN SUPPLY
85 Harbour Drive
Scottsboro, AL 35769
877-434-1027
Contact: Carolyn Bullard
grcremesh@live.com

ARIZONA

MULTICRAFT
3233 E. Van Buren St.
Phoenix, AZ 85008
800-442-4244
Contact: Keith Engle
multicraftaz@yahoo.com

CALIFORNIA

BEST SUPPLY
1822 S. Hill St.
Los Angeles, CA 90015
213-744-1172
Contact: Han Park / Ron Delgado
bsps1221@sbcglobal.net
ronnie_delgado@hotmail.com

CALIFORNIA

Jantex Inks
7711 Paramount Blvd.
Pico Rivera, CA 90660
562-949-3900
Contact: Jan Springer/Opal Mata
opal@jantexinks.com

ALASKA

IMAGE CONTROL SYSTEMS
552 W. 58th Ave. Ste. G
Anchorage, AK 99518
907-561-1885
Contact: Bob Christoffers
icsak@alaska.net

CALIFORNIA, Escondido

WESTIX
1309 Simpson Way Ste. L
Escondido, CA 92029
800-741-3887
Contact: Dennis Whyte, Matt
dennis@westixonline.com
matt@westixonline.com

CALIFORNIA, Bay Area

RESOURCE GROUP
628 Hi Tech Parkway Ste. A
Oakdale, CA 95361
866-845-8228
Contact: Lori Cowan
lcowan@resourcegrp.net

COLORADO

ROCKSTAR
10515 E.40th Ave. Ste. 104
Denver, CO 80239
303-375-7777
Contact: Randy Cole
randy@Rockstarscreensupply.com

FLORIDA

SunCoast Screen & Ink Inc.
12880 Automobile Blvd. Ste. G
Clearwater, FL 33762
Phone: 727-556-0339
Fax: 727-556-0659
Contact: Rick & Maureen Ramirez
www.suncoastscreen.com

GEORGIA

AMERICAN NIAGARA
6690 Jones Mill Ct. Ste. A
Norcross, GA 30092
800-241-7708
Contact: Scotty Barocas
scott@american-niagara.com

HAWAII

AMERICAN TEE SHIRTS
1217 N. King St.
Honolulu, HI 96817
808-842-4466
Contact: Linda Osborne
info@americant-shirt.com

IDAHO

NORTHWEST SIGN SUPPLY
15916 E. Sprague
Spokane Valley, WA 99037
800-678-7923
Contact: Geoff Witcomb
geoffw@northwestsign.com

ILLINOIS

ATLAS SCREEN SUPPLY
9353 Seymour Ave.
Schiller Park, IL 60176
800-621-4173
Contact: Dave Gayton/Gina
dave@atlasscreensupply.com
gina@atlasscreensupplu.com

INDIANA

ATLAS SCREEN SUPPLY
9353 Seymour Ave.
Schiller Park, IL 60176
800-621-4173
Contact: Dave Gayton
dave@atlasscreensupply.com

IOWA

SPSI

515-964-7777
Contact: Kevin Esselman
kesselman@sps-i.com

KANSAS

SPSI
8302 Hedge Lane Ter. Ste. H
Shawnee, KS 66227
913-422-8304
Contact: Mike Craddick
mcraddick@sps-i.com

LOUISIANA

DENVER SIGN SUPPLY
5787 Pride Port Hudson Rd.
Slaughter, LA 70777
800-735-7446
Contact: Larry Powenski
denver@eatel.net

MASSACHUSETTS

QUALITY SCREEN SUPPLY

30 Wilson Pond Lane

Rowley, MA 01969

978-500-4794

Contact: David Reiniger

davidreiniger@yahoo.com**MINNESOTA**

SPSI

9825 85th Ave. N. Ste. 10

Maple Grove, MN 55369

800-876-7774

Contact: Bret Mattys

bmattys@sps-i.com**MONTANA**

NORTHWEST SIGN SUPPLY

15916 E. Sprague

Spokane Valley, WA 99037

800-678-7923

Contact: Geoff Whitcomb

geoffw@northwestsign.com**NEW YORK, Long Island**

VIKING SOLUTIONS

80 E. Montauk Hwy.

Lindenhurst, NY 11757

800-269-7232

Contact: Peter Buccino

peter.buccino@tv goc.com**NEW YORK, Buffalo**

MULTICRAFT

Buffalo, NY

330-979-1700

800-742-8000

Contact: Ron Wonnacott

rwonnacott@multicraftink.com**OHIO**

MULTICRAFT

4701 Lakeside Ave. E.

Cleveland, OH 44114

800-741-8000

Contact: Ron Davis

rdavis@multicraftink.com**MICHIGAN**

ONE SOURCE

4420 S. Elms Rd.

Swartz Creek, MI 48473

800-241-0453

Contact: Jack Gould

onesourcemichigan@yahoo.com**MICHIGAN**

ONE SOURCE

3240 W St. Joseph

Lansing, MI 48917

517-977-0080

Contact: Jack Gould

onesourcemichigan@yahoo.com**MONTANA**

DIMENSIONAL PRODUCTS

1467 Elliot Ave. W.

Seattle, WA 98119

800-782-3801

Contact: Jim or Brian

dimprod2@msn.com**New Jersey/ New York**

PROSPECT INDUSTRIES

47 Summit Ave.

Central Valley, NY 10917

205-515-2974

Contact: Brian Osborne

bosborne@frontiernet.net**OKLAHOMA**

GRAPHIC SOLUTIONS

10110 E. 55th Place Ste. A

Tulsa, OK 74146

866-664-2226

Contact: Julie Landsberger

julie.landsberger@gogsg.com

OREGON

NORTHWEST SIGN SUPPLY

602 SE. Salmon St.

Portland, OR 97214

800-873-0111

Contact: Steve Anderson

kellys@northwestsign.com**PENNSYLVANIA**

N.B. GARBER

2014 Ford Rd. Ste. J

Bristol, PA 19007

215-826-8060

Contact: David Tyler

dwt Tyler@comcast.net**TEXAS, Lubbock**

ALL AMERICAN TEES

327 E. 74th St.

Lubbock, TX 79404

800-375-0128

Contact: David Foster

sales@allamericantees.com**TEXAS, Houston**

GRAPHIC SOLUTIONS

1293 N. Post Oak Ste.190

Houston, TX 77055

713-957-0850

Contact: Brandon Granberry

houston.sales@gsginet.com**TEXAS, Stafford**

LEE'S SCREEN PROCESS SUPPLY

10440 W. Airport Blvd.

Stafford, TX 77477

800-447-8874

Contact: Robert Roberts

robert@leessupply.com**TEXAS, San Juan**

AMM ENTERPRISES

1101 E. 495 STE.G

SAN JUAN, TX 78589

956-781-1274

Contact: Tony Molinar

sales@amm-enterprises.com**PENNSYLVANIA**

MULTICRAFT

7703 Perry Hwy. Ste. 100

Pittsburg, PA 15237

412 -215-2433

Contact: Dave Kaule

davekaule@gmail.com**SOUTH CAROLINA**

AMERICAN NIAGARA

6690 Jones Mill Rd. Ste. A

Norcross, GA 30092

800-241-7708

Contact: Scotty Barocas

scotty@american-niagara.com**TEXAS, Dallas**

GRAPHIC SOLUTIONS

304 N. Walton St.

Dallas, TX 75226

800-366-1776

Contact: SALES

dallas.sales@gogsg.com**TEXAS, San Antonio**

HERWECKS

300 Broadway St.

San Antonio, TX 78205

800-725-1349

Contact: Scott Rote

shelby@herwecks.com**TEXAS, Arlington**

SPSI

345 Exchange Dr.

Arlington, TX 76011

817-861-3464

Contact: Mike Schiffler

mschiffler@sps-i.com

UTAH

TECHNICAL SERVICE & SUPPLY

2465 S. West Temple

Salt Lake City, UT 84115

801-467-7832

Contact: Skip Marsh

skipmarsh@earthlink.net**WASHINGTON, Burlington**

WESTAR SOLUTIONS

11653 Higgins Airport Way

Burlington, WA 98233

800-574-3477

Contact: Kevin Hartman

kevinh@westarsolutions.com**WASHINGTON, Seattle**

NORTHWEST SIGN SUPPLY

5300 4th Ave. South

Seattle, WA 98108

800-654-0194

Contact: Larry

larryf@northwestsign.com**WISCONSIN**

SPSI

621 W. Farhurst Ln.

Saukville, WI 53080

262-268-9712

Contact: John Albrecht

jalbrecht@sps-i.com**WASHINGTON, Kirkland**

PRINTA SYSTEMS

127 10TH St. S. Ste 600

Kirkland, WA 98033

800-601-6240

Contact: Sales

customercare@printa.com**WASHINGTON, Seattle**

DIMENSIONAL PRODUCTS

1467 Elliot Ave. W.

Seattle, WA 98119

800-782-3801

Contact: Jim or Brian

dimprod2@msn.com**WASHINGTON, Spokane**

NORTHWEST SIGN SUPPLY

15916 E. Sprague

Spokane Valley, WA 99037

800-678-7923

Contact: Geoff Whitcomb

geoffw@northwestsign.com



PRODUCT GUIDE

QCM Distributors – International

Australia/New Zealand

AUSTRALIA

THE INK DUDE

Unit 3, 12 Viewtech Place

Rowville

Victoria, Australia 3178

613-9764-4705

Contact: Glenn Mepstead

sales@theinkdude.com.au

NEW ZEALAND

BLUE PRINT IMAGING

1 Inlet Road

PO Box 1130 Papakura, Takanini

Auckland, NZ

649-299-7770

Contact: Rick Day

Asia

CHINA

EXCELLENCE CHEMICAL

12434 128TH St. Room 1, 13/f Blk 4

Golden Dragon Industrial Center

182-190 Tai Lin Pai Road

N.T. Hong Kong

852-2487-4019

Contact: Owen Li

BANGLADESH

RAFIQ ENT.

184-C-2 Block 2

P.E.C.H.S.

Karachi, Pakistan

9-221-453-22525

Contact: Rafiq Godil

PAKISTAN

M/S KUKDA

E-24, 4th Floor

Montandes Bldg.

Boulton Market

Karachi, Pakistan

9221 660 4049

Contact: Aslam Kukda

PAKISTAN

UNICON INT'L PVT LTD

184-C-2

P.E.C.H.S.

Karachi, Pakistan

9-221-453-22525

Contact: Noureen Lakhani

INDIA

SREE RAM DYES

81 R.K.G. Complex

Valyangadu Main Road

Gandhi Magar Rirupur 641603

Tamil Nadu, India

91 421 247 6405



PRODUCT GUIDE

QCM Distributors – International

Europe

BELGIUM

MINERVA TEXTILE
Naamloze Venootschap
Spanjebergstraat.21
1700 Dilbeek, Belgium
322 569 4269
Contact: Dirk D’Hulster
info@minerva-world.com

QCM INKS EUROPE LTD.

An Den Röderäckern 5
63743 Aschaffenburg,
Germany
0044 1473 828650
Contact: Frank Kaufhold
frank.kaufhold@gcminks.eu

CZECH REPUBLIC

MEDIUM CZECH Ltd.
Kozi 853/19
110 00 Prague 1, CZ
420 731 719 227
Contact: Jakub Meisel
jakub.meisel@gcminks.eu

Central & South America

GUATEMALA

TRIGEN INT’L, INC.
530 E. Euclid Ave
Compton, CA 90222
Contact: Johnny Moon
310-537-8549 / 8568
johnny@trigeninc.com

GUATEMALA

CASA SERIGRAFICA
17 Avenida A 11-15
Apto 6 Col.
Venezuela Zona 21
Guatamala, GT
502-578-40442
Contact: Raul Barahona
casersa@guate.net.gt



PRODUCT GUIDE

QCM Distributors – International

Canada

CANADA, Ontario
TINO SCREENS
18 Crown Steel Drive Ste 101-104
Markham, Ontario L3R 9X8
866-475-8818
Contact: Richard Wong
sales@tinoscreeens.com

CANADA, British Columbia
SUMMIT SCREEN
2322 Hunter Road
Kelowna, BC V1X 6C1
800-665-5345
Contact: Pierre Ouimet

CANADA, Alberta
N.W. SCREEN & SIGN SUPPLY
12434 – 128th St.
Edmonton, AB T5L 1C8
780-451-3192
Contact: Mike Hanzely
sunsigns1@shawbiz.ca

CANADA, British Columbia
INK PLUS
6943 Antrim Ave.
Burnaby, BC V5J 4M5
604-451-4040
Contact: John Prkachin
john@inkplus.ca

CANADA, Alberta
SOURCE ONE GRAPHICS
14423-107A
Edmonton, AB T5N 1G3
780-451-0222
Contact: Ryan Banks



PRODUCT DATA SHEET

WHITE INKS

White Inks

Product Overview of QCM White Inks

COTTON WHITES:

XOLB-108: Cotton White:

XOLB-108 Cotton White is designed for high volume auto printing on cotton fabrics. XOLB-108 is extremely opaque and with excellent mat characteristics, creating the perfect flat base plate and producing prints with outstanding coverage. This smooth, creamy consistency is easy to print with on both manual and automatic presses. The creamy consistency also allows for a very clear screen shear. XOLB-108 is fast flashing, allowing for shorter dwell times and faster production rates. Also works well as a highlight white or a stand-alone white.

XOLB-109: Cotton White:

XOLB-109 Simply White is designed for high volume auto printing on cotton fabrics. XOLB-109 is extremely opaque with excellent mat characteristics, creating the perfect flat base plate, producing prints with outstanding coverage. This smooth, creamy consistency is easy to print with on both manual and automatic presses. This same consistency also allows for a very clear screen shear. XOLB-109 is fast flashing, allowing for shorter dwell times and faster production rates. The XOLB-109 has less "structured rigidity" than the XOLB-108, which means it flows more on press, this is the biggest difference between the two whites. Also works well as a highlight white or a stand-alone white.

XOLB-142: Max. Production White:

XOLB-142 Max Production White is designed for high volume auto printing on cotton fabrics. With an almost Zero dwell flash time, you truly can run as fast as you can flash! XOLB-142 Max Production White is extremely opaque with excellent mat characteristics, creating the perfect flat base plate, producing prints with outstanding coverage. This smooth, creamy consistency is easy to print with on both manual and automatic presses. The creamy consistency also allows for a very clear screen shear. XOLB-142 Max Production White is the fastest flashing white available, allowing for shorter dwell times and faster production rates. Also works well as a highlight white or a stand-alone white.

FOR BOTH COTTON/POLYESTER BLENDS AND 100% COTTON:

XOLB-151: Glacier Max White:

XOLB-151 Glacier Max White is designed for excellent bleed resistance on 50/50 Cotton Polyester blend fabrics. It is extremely opaque with excellent matting characteristics producing prints with outstanding coverage. The smooth, creamy consistency is easy to print with on both manual and automatic presses. XOLB-151 Glacier Max is fast flashing, allowing for shorter dwell times and faster production times. Glacier Max White is ideal for use as a base plate/under-base white or as a bright clean highlight white.

XOLB-158: Creamy Glacier White:

XOLB-158 Creamy Glacier White exhibits a brilliant whiteness, so white it almost glows. XOLB-158 has a soft, creamy consistency that is very easy to print, but also has a very high opacity. It is excellent for printing on most substrates such as 50/50 cotton/poly blends, 100% cotton and fleece. As with all our Glacier Whites, it is soft, creamy, easy to print, has excellent opacity, good flash times and that incredible "whiteness." It exhibits good low-bleed qualities.



PRODUCT DATA SHEET

WHITE INKS

White Inks

Product Overview of QCM White Inks

XOLB-159: Glacier Plus White:

XOLB-159 Glacier Plus White has a soft, creamy consistency that is very easy to print, but also has very high opacity. It is excellent for printing on most substrates, such as 50/50 cotton/poly blends, 100% cotton and fleece. Glacier Plus White is soft, creamy and easy to print. It has excellent opacity, good flash times and that incredible "whiteness." It also holds dot and fine detail that puts its rivals to shame. It exhibits excellent low-bleed qualities.

XOLB-165: Polar White:

XOLB-165 Polar White is designed for maximum bleed resistance on 50/50 Cotton Polyester blend fabrics. It is extremely opaque with excellent matting characteristics producing prints with outstanding coverage. The smooth, creamy consistency is easy to print with on both manual and automatic presses. XOLB-165 Polar White is fast flashing, allowing for shorter dwell times and faster production times. Polar White is ideal for use as a base plate/under-base white or as a bright clean highlight white.

FOR 100% POLYESTER:

PERM-170: Perma-White:

PERM-170 Perma-White was specifically formulated to combat the ever-present bleed problem experienced by those who print on polyester and polyester blended materials. Perma-White exhibits a unique blend of printability, opacity and bleed resistance. The cured finish is a smooth, matte surface. Perma-White has excellent mat characteristics. Perma-White contains bleaching agents to neutralize dye migration.

FOR OTHER PRINTING PURPOSES:

ATP-101: Athletic White:

ATP-101 Athletic White and the ATP ink line is designed specifically for athletic uniforms, athletic bag printing, and difficult to print-on fabrics. This ink may be printed thick for athletic lettering and transfers. ATP-101 has excellent, low bleed characteristics and is recommended for use on nylon and polyester materials including mesh, dazzle cloth, Cordura® and other difficult fabrics. ATP-101 was not formulated for printing on closed weave nylon jackets/shells without the use of MF-66 Nylon Bonding Agent.

TSP-115: Puff White:

TSP-115 Puff White is a plastisol printing ink which has been formulated to produce a high "Puff" effect on a variety of fabrics. This ink prints smooth and has an even rise for a clean, sharp print. The TSP-115 Puff White has some low bleed qualities and is very durable when cured properly.

WOW-101: Wet-On-Wet White:

WOW-101 Wet-On-Wet White is designed as a multipurpose wet-on-wet compatible white. It can be used as both a wet-on-wet white to help control dot gain while increasing the brightness of a design, as a base white, and as a last down highlight white. The smooth, creamy consistency is easy to print with on both manual and automatic presses. The physical properties of the WOW-101 also allow it to keep very clean and open halftone dots, making it an optimal choice for high-end simulated process printing.



PRODUCT DATA SHEET

BLACK INKS

Black Inks

Product Overview of QCM Black Inks

XOLB-911: Jet Black:

XOLB-911 Jet Black is a high opacity black ink that has maximum coverage, yet is very easy to print with on a manual and automatic press. The smooth, firm bodied, yet creamy consistency leaves a smooth uniform print when overprinting other flashed inks, especially white bases. XOLB-911 Jet Black is fast flashing, clears the screen great, and holds amazing detail. For those printers looking for a lower viscosity creamy ink, try our LFP-901 Black.

WOW-901: Wet-On-Wet Black:

WOW-901 Black is a high opacity black ink designed specifically for when Wet-On-Wet printing is needed. It is ideal for high volume print jobs, especially where it is necessary to keep extremely fine detail. The WOW-901 Black maintains a very clean dot and smooth fine lines, reproducing your films with incredible accuracy. WOW-901 Black will not build up on succeeding screens, allowing for longer press runs with fewer interruptions. No build up means no screen blockage, fewer misprints, and less cleaning.

LFP-935: Black:

QCM's LFP-935 Black is an economical plastisol screen printing ink designed for printing on 100% cotton and 50/50 fabric. The printed finish is matte with a nice soft hand. LFP-901 Black is very easy to use on both a manual and automatic press. All of QCM's black inks are the most opaque on the market. For those printers requiring a creamier bodied economical black try our LFP-901.

LFP-901: Black:

QCM's LFP-901 Black is an economical plastisol screen printing ink designed for printing on 100% cotton and 50/50 fabric. The printed finish is matte with a nice soft hand. LFP-901 Black is our creamiest black and is very easy to use on both a manual and automatic press. All of QCM's black inks are the most opaque on the market. For those printers requiring a thicker bodied black try our LFP-935 or the XOLB-911.

WOW-9017: Softee Black:

WOW-9017 Softee Black is a super soft, buildup free jet black ink that can be printed by itself or in sequence/wet-on-wet. It is the black ink of choice where a super soft, water base like print finish is desired.

ATP-901: Black:

ATP-901 and the ATP ink line is designed specifically for athletic uniforms, athletic bag printing, and difficult to print-on fabrics. This ink may be printed thick for athletic lettering and transfers. ATP has excellent, low bleed characteristics and is recommended for use on nylon and polyester materials including mesh, dazzle cloth, Cordura® and other difficult fabrics. ATP inks were not formulated for printing on closed weave nylon jackets/shells without the use of MF-66 Nylon Bonding Additive.

TSP-930: Jet Black:

TSP-930 Puff Jet Black is a plastisol printing ink which has been formulated to produce a high "Puff" effect on a variety of fabrics. This ink prints smooth and has an even rise for a clean, sharp print. The TSP-930 Puff Jet Black is very durable when cured properly.



PRODUCT DATA SHEET

BLACK INKS

Black Inks

Product Overview of QCM Black Inks

WOW-920: Process Black:

QCM's WOW-920 Process Black and Four Color Process Inks are superior quality transparent plastisol inks formulated to achieve the most accurate 4 color process reproductions. These colors are finely milled, allowing the ink to pass easily through 405 TPI (159 TPcm) mesh resulting in minimal ink deposits while maintaining excellent color strength. For best results, print on white garments, cotton or cotton polyester blends of a tight weave. Open weave garments give a washed out appearance with process printing. If printing on colored garments, use a white underlay or base print.



PRODUCT DATA SHEET

XOLB LINE

XOLB

Xtra Opaque, Low Bleed Inks

Product Overview:

XOLB, “Xtra Opaque, Low Bleed” inks are high opacity multi-purpose inks that are designed to produce extremely opaque prints, yet are very easy to print on a manual press. The smooth, creamy consistency leaves an even uniform print on white flash bases and can be opaque on black without a white base with screens as fine as 160 TPI (62 TPcm) mesh. XOLB inks are fast flashing, cure with a non-tack surface, and contain clean bright pigments. The fast flash speed allows for shorter dwell times and faster production output. **Caution:** When printing on any polyester blended garments, always test prior to production for any potential bleed/dye sublimation problems. If you are unsure of the quality or stability of the garment you are decorating, lay down a low bleed white base using our XOLB-158, XOLB-159, or XOLB-151.

Printing:

XOLB inks print well through screen meshes in the range of 83-305 TPI (32-120 TPcm). Screens stretched to a minimum of 25 newtons are recommended. If using lower tension screens, adjust off contact accordingly. Use just enough squeegee pressure to deposit the ink on the surface of the shirt. This will enhance the opacity and also ensure a better cure. Try not to drive the ink into the fabric. A 70 durometer sharp squeegee is recommended.

Stencil:

Use any direct emulsion or capillary film.

Flashing:

Parameters vary between all flash units. Flash for 2-3 seconds with the ink deposit reaching 150-250°F (65-121°C). Ink should be dry and without tack. **Warning:** Over flashing can cure the ink and prevent adhesion between coats of ink.

Curing:

Cure at 325°F (162°C) over a 60-90 second period, depending on oven type and thickness of ink deposit. A thicker deposit will take longer to cure as the heat must penetrate through the entire ink layer.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol ink contains no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.



COLOR LIST

XOLB LINE

XOLB	201	YELLOW
XOLB	202	GOLD
XOLB	205	VEGAS GOLD
XOLB	210	CHROME YELLOW
XOLB	302	ORANGE
XOLB	401	SCARLET
XOLB	402	DARK CARDINAL
XOLB	403	FLUORESCENT PINK
XOLB	405	BLAZE RED
XOLB	408	BRITE RED
XOLB	453	FUCHSIA
XOLB	501	SKY BLUE
XOLB	502	COLUMBIA BLUE
XOLB	503	ROYAL BLUE
XOLB	504	NAVY BLUE
XOLB	505	OPAQUE PROCESS BLUE
XOLB	506	ULTRAMARINE BLUE
XOLB	601	DARK MAROON
XOLB	602	PURPLE
XOLB	607	MAROON
XOLB	701	GRASS GREEN
XOLB	703	KELLY GREEN
XOLB	704	TURQUOISE
XOLB	705	LIME GREEN
XOLB	710	FOREST GREEN
XOLB	801	TAN FLESH
XOLB	803	RUST (TEXAS ORANGE)
XOLB	805	MEDIUM BROWN
XOLB	902	GREY
XOLB	911	JET BLACK



PRODUCT DATA SHEET

WOW LINE

WOW

Wet-On-Wet Inks

Product Overview:

WOW is a high opacity ink line designed specifically for Wet-On-Wet printing. It is ideal for high volume print jobs. WOW inks will not buildup on succeeding screens, allowing for longer press runs with fewer interruptions. These inks are bright, clean, and opaque, containing brilliant colors that last for thousands of prints. No build up means no screen blockage, fewer misprints, and less cleaning.

Printing:

WOW inks print well through screen meshes in the range of 83-305 TPI (32-120 TPcm). Higher mesh counts may be used with a possible loss of opacity. Screens stretched to a minimum of 25 newtons are recommended. If using lower tension screens, adjust off contact accordingly. Use just enough squeegee pressure to deposit the ink on the surface of the shirt. This will enhance the opacity and also ensure a better cure. Try not to drive the ink into the fabric. A 70 durometer sharp squeegee is recommended.

Stencil:

Use any direct emulsion or capillary film.

Additives:

WOW inks are ready to print. Reduce if absolutely necessary with WOW-1015 Softee Base. Reducing the viscosity will also reduce the opacity and coverage of the ink.

Curing:

Cure at 325°F (162°C) over a 60-90 second period, depending on oven type and thickness of ink deposit. A thicker deposit will take longer to cure as the heat must penetrate through the entire ink layer.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol ink contains no leaded pigments, and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.



COLOR LIST

WOW LINE

WOW	201	YELLOW
WOW	202	GOLD
WOW	205	VEGAS GOLD
WOW	210	CHROME YELLOW
WOW	302	ORANGE
WOW	401	SCARLET
WOW	402	DARK CARDINAL
WOW	403	FLUORESCENT PINK
WOW	405	BLAZE RED
WOW	408	BRITE RED
WOW	453	FUCHSIA
WOW	501	SKY BLUE
WOW	502	COLUMBIA BLUE
WOW	503	ROYAL BLUE
WOW	504	NAVY BLUE
WOW	505	OPAQUE PROCESS BLUE
WOW	506	ULTRAMARINE BLUE
WOW	601	DARK MAROON
WOW	602	PURPLE
WOW	607	MAROON
WOW	701	GRASS GREEN
WOW	703	KELLY GREEN
WOW	704	TURQUOISE
WOW	705	LIME GREEN
WOW	710	FOREST GREEN
WOW	801	TAN FLESH
WOW	803	RUST (TEXAS ORANGE)
WOW	805	MEDIUM BROWN
WOW	901	BLACK
WOW	902	GREY

WOW – TEAM COLOR LINE

WOW	2101	TCL - LEMON YELLOW
WOW	3101	TCL - BRIGHT ORANGE
WOW	4101	TCL - NATIONAL RED
WOW	4102	TCL - SCARLET
WOW	4103	TCL - SUPER DRAKE RED
WOW	4105	TCL - BRANDYWINE
WOW	5101	TCL - BEARS NAVY
WOW	5102	TCL - CONTACT BLUE
WOW	5103	TCL - WINTER BLUE
WOW	5104	TCL - LIGHT ROYAL
WOW	6101	TCL - RUSSELL PURPLE
WOW	7101	TCL - DALLAS GREEN

WOW	7102	TCL - KELLEY GREEN
WOW	8101	TCL - SPICE BROWN
WOW	9101	TCL - DARK GREY
WOW	9102	TCL - RUSSELL GREY



PRODUCT DATA SHEET

QMX LINE

QMX

Quick Matching System

Product Overview:

The QMX system consists of 14 total components, 12 colors, a transparent and white base. That is all that is required to mix over 1000 colors. QMX ink is very soft, smooth and exhibits excellent printing characteristics while producing a very nice printed finish. Due to its texture and printability, higher mesh counts may be used, resulting in soft hand finishes. Our formula guide also provides you with the opacity data for each color. This will tell you at a glance whether or not you need to use a base plate.

Printing:

QMX inks print easily through screen meshes in the range of 83-305 TPI (32-120 TPcm). Higher mesh counts may be used with a possible loss of opacity. Screens stretched to a minimum of 25 newtons are recommended. If using lower tension screens, adjust off contact accordingly. Use just enough squeegee pressure to deposit the ink on the surface of the shirt. This will enhance the opacity and also ensure a better cure. Try not to drive the ink into the fabric. A 70 durometer sharp squeegee is recommended.

Stencil:

Use any direct emulsion or capillary film.

Curing:

Cure at 325°F (162°C) over a 60-90 second period, depending on oven type and thickness of ink deposit. A thicker deposit will take longer to cure as the heat must penetrate through the entire ink layer.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol ink contains no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.

QMX



Accuracy worth repeating.

Quick Matching System

“The Most Exact” Pantone® Licensed Ink Matching System Available.





COLOR LIST

QMX LINE

QMX	1030	WET-ON-WET CLEAR BASE
QMX	1130	WET-ON-WET WHITE BASE
QMX	1230	OPAQUE CLEAR BASE
QMX	2001	YELLOW
QMX	3003	ORANGE
QMX	4032	RED (YELLOW SHADE)
QMX	4035	RED (BLUE SHADE)
QMX	5001	BLUE (RED SHADE)
QMX	5002	BLUE (GREEN SHADE)
QMX	5004	ULTRAMARINE BLUE
QMX	6002	CLEAN VIOLET
QMX	6003	DURABLE VIOLET
QMX	6018	MAGENTA
QMX	7002	GREEN
QMX	9001	BLACK

QMX FUORESCENT PLUS SYSTEM

QMX	2007	SATURN YELLOW
QMX	3007	BLAZE ORANGE
QMX	4016	ROCKET RED
QMX	4017	NEON RED
QMX	4022	NEON PINK
QMX	5017	HORIZON BLUE
QMX	7007	SIGNAL GREEN
QMX	9002	SPARKLING SILVER



PRODUCT DATA SHEET

ATP LINE

ATP

A Tough Durable Ink for Athletic Uniforms

Product Overview:

ATP inks are designed specifically for athletic uniforms, athletic bag printing, and difficult to print-on fabrics. This ink may be printed thick for athletic lettering and transfers. ATP has excellent, low bleed characteristics and is recommended for use on nylon and polyester materials including mesh, dazzle cloth, Cordura® and other difficult fabrics. ATP inks were not formulated for printing on closed weave nylon jackets/shells without the use of MF-66 Nylon Bonding Agent.

Printing:

For best results use a flood/print method using a 60 to 70 durometer, squeegee. A print, flash, print is recommended for polyester. 60-110 TPI (23-43 TPcm). Screens stretched to a minimum of 25 newtons are recommended. Coarse meshes are recommended for a thicker ink deposit. The ATP inks have excellent adhesion and will produce a long print life on loosely woven nylon substrates. Closed or tight weave nylon shell fabrics (used in jackets) will still require MF-66 Nylon Bonding Agent.

Warning: Some jackets are waterproofed and may prevent MF-66 from bonding. A solvent wipe of the fabric may be required.

Stencil:

Use any direct emulsion or capillary film.

Additives:

ATP inks are ready to print. Reduce if absolutely necessary using P-5011 Curable Reducer. Reducing the viscosity will also reduce the opacity and coverage of the ink.

Flashing:

Depending on your flash unit, ATP Inks will flash in 3 seconds (10 watts per sq. in./heating area) or 4-5 seconds (6-7 watts per sq. in. /heating area).

Curing:

Cure at 300°F (148°C) over a 60-90 second period, depending on oven type and thickness of ink deposit. A thicker deposit will take longer to cure as the heat must penetrate through the entire ink layer.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol ink contains no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.



COLOR LIST

ATP LINE

ATP	101	ATHLETIC WHITE
ATP	201	YELLOW
ATP	202	GOLD
ATP	205	VEGAS GOLD
ATP	301	ORANGE
ATP	401	SCARLET
ATP	402	CARDINAL
ATP	501	ROYAL BLUE
ATP	502	COLUMBIA BLUE
ATP	503	NAVY BLUE
ATP	601	PURPLE
ATP	701	KELLY GREEN
ATP	703	FOREST GREEN
ATP	704	TURQUOISE
ATP	901	BLACK
ATP	903	GREY



PRODUCT DATA SHEET

AP INKS

AP

Semi-Opaque Fluorescent Inks

Product Overview:

Being both fluorescent and semi-opaque, AP Semi-Opaque Fluorescent inks produce beautiful, even, bright prints. While opaque enough to be printed without the need of an underbase on light and medium grain garments, it is still recommended to print an underbase white on dark colored fabrics.

Printing:

AP Semi-Opaque Fluorescent inks print well through screen meshes in the range of 83-160 TPI (32-62 TPcm). Higher mesh counts may be used with a small loss in opacity. Screens stretched to a minimum of 25 newtons are recommended. If using lower tension screens, adjust off contact accordingly. Use just enough squeegee pressure to deposit the ink on the surface of the shirt. This will enhance the opacity and also ensure a better cure. Try not to drive the ink into the fabric. A 60/90/60 or 70 durometer sharp squeegee is recommended.

Stencil:

Use any direct emulsion or capillary film.

Additives:

N/A.

Curing:

Cure at 325°F (162°C) over a 60-90 second period, depending on oven type and thickness of ink deposit. A thicker deposit will take longer to cure as the heat must penetrate through the entire ink layer.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM Plastisol Ink contains no leaded pigments, and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.



PRODUCT DATA SHEET

Softee Line

WOW-1015 Softee Base

Product Overview:

WOW-1015 Softee Base is a super soft, buildup free mixing base designed specifically for wet-on-wet printing where a soft print finish is desired. Softee Base, when pigmented or mixed with other plastisol inks, will produce an extremely soft print. Ideal for high volume print jobs, it will not buildup on succeeding screens, allowing for longer press runs with fewer interruptions. WOW-1015 Softee Base dramatically improves the wet-on-wet printability of ink systems that will not print wet-on-wet.

Printing:

It is recommended to add up to 75% WOW-1015 Softee Base to your desired ink colors. Test print and cure the mixed ink, checking for desired softness of print. If a softer hand is needed, add up to a total of 90% WOW-1015 to your ink. If pigmenting your inks, add up to 30% pigment by weight. After mixing, the finished inks print well through screen meshes in the range of 83-385. The higher the mesh, the softer the finished print. Screens stretched to a minimum of 25 newtons are recommended. If using lower tension screens, adjust off contact accordingly. Recommend a 70 to 70/90/70 durometer sharp squeegee.

Stencil:

Use any direct emulsion or capillary film.

Additives:

None

Flashing:

Parameters vary between all flash units. Flash for 2-3 seconds with the ink deposit reaching 150-250°F (65-121°C). Ink should be dry and without tack.

Curing:

Cure at 325°F (162°C) over a 60-90 second period, depending on oven type and thickness of ink deposit. A thicker deposit will take longer to cure as the heat must penetrate through the entire ink layer.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol inks contain no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.



PRODUCT DATA SHEET

Softee Line

WOW-1017

Softee Black

Product Overview:

WOW-1017 Softee Black is a super soft, buildup free jet black ink that can be printed by itself or in sequence/wet-on-wet. It is the black ink of choice where a super soft, water base like print finish is desired.

Printing:

WOW-1017 Softee Black will print exceptionally well through screen meshes in the range of 110-435. The higher the mesh, the softer the finished print. Screens stretched to a minimum of 25 newtons are recommended. If using lower tension screens, adjust off contact accordingly. Recommend a 70 to 70/90/70 durometer sharp squeegee. Hard squeegee pressure is recommended to assure the extreme soft hand.

Stencil:

Use any direct emulsion or capillary film.

Additives:

None

Flashing:

Parameters vary between all flash units. Flash for 2-3 seconds with the ink deposit reaching 150-250°F (65-121°C). Ink should be dry and without tack.

Curing:

Cure at 325°F (162°C) over a 60-90 second period, depending on oven type and thickness of ink deposit. A thicker deposit will take longer to cure as the heat must penetrate through the entire ink layer.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol inks contain no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.



PRODUCT DATA SHEET

MTL LINE

MTL

"Precious Metal" Inks

Product Overview:

MTL "Precious Metal" inks are bright, opaque, metallic plastisol screen printing inks. Add pop to your design as either an accent or as a color replacement to jazz up an old design.

Printing:

MTL inks print well through screen meshes in the range of 83-110 TPI (32-120 TPCm) Screens stretched to a minimum of 25 newtons are recommended. If using lower tension screens, adjust off contact accordingly. Use just enough squeegee pressure to deposit the ink on the surface of the shirt. This will enhance the opacity and also ensure a better cure. Try not to drive the ink into the fabric. Squeegee durometers of 60 or 70 and are recommended.

Stencil:

Use any direct emulsion or capillary film.

Substrates:

MTL inks may be printed on 100% cotton, cotton blends, acrylics and polyesters or poly/cotton blends. Pre-production run testing is always recommended to check for adhesion, washability, dye migration problems, amongst other things.

Modifiers:

MTL inks are ready to use. They can be extended using LFP-1002 base, but opacity will be affected. For printing on Nylon shell material waterproofed, use MF-66 Nylon Bonding Agent.

Curing:

Cure at 325°F (162°C) over a 60-90 second period, depending on oven type and thickness of ink deposit. A thicker deposit will take longer to cure as the heat must penetrate through the entire ink layer.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol ink contains no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color.



COLOR LIST

MTL LINE

MTL Standard Color Offerings:

MTL	202	SPARKLING GREEN GOLD
MTL	204	SPARKLING GOLD
MTL	220	METALLIC BRIGHT GOLD
MTL	402	SPARKLING SCARLET
MTL	502	SPARKLING BLUE
MTL	902	SPARKLING SILVER
MTL	905	BRIGHT METALLIC SILVER

MTL Inks Available on Request:

MTL	206	SPARKLING BRONZE
MTL	207	METALLIC GOLD LEAF
MTL	302	SPARKLING COPPER
MTL	403	SPARKLING RUBINE RED
MTL	602	SPARKLING PURPLE
MTL	702	SPARKLING GREEN
MTL	703	SPARKLING TEAL
MTL	903	METALLIC PLATINUM



PRODUCT DATA SHEET

GL LINE

GL-212

Cosmic Crystals

Product Overview:

GL-212 Cosmic Crystals are prism shaped glitter particles that reflect a variety of colors depending on the direction of the light. The Cosmic Crystal particles are mixed into a clear base which makes it best suited for printing over the top of other colors. The Cosmic Crystals themselves will pickup and reflect the color underneath, complimenting any base color and giving you an endless pallet of options. Experiment with different base colors to create new and exciting effects.

Printing:

GL inks can be printed through 25-40 TPI (9-15 TPcm) screens. Screens stretched to a minimum of 25 newtons are recommended. Use a 60-70 durometer squeegee. For best results 2-3 passes may be needed.

Stencil:

Use any direct emulsion or capillary film.

Curing:

Cure at 325°F (162°C) over a 60-90 second period, depending on oven type and thickness of ink deposit. A thicker deposit will take longer to cure as the heat must penetrate through the entire ink layer.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol ink contains no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.



PRODUCT DATA SHEET

GL LINE

GL

Glitters

Product Overview:

Glitter inks are made with QCMs high performance clear glitter base to result in easy printing and high brightness. The particle size allows for good printing through 40 TPI (15 TPcm) mesh screens. Each color is also available in powder for sprinkle or dry print applications.

Printing:

GL inks can be printed through 25-40 TPI (9-15 TPcm) screens. Screens stretched to a minimum of 25 newtons are recommended. Use a 60-70 durometer squeegee. For best results 2-3 passes may be needed.

Stencil:

Use any direct emulsion or capillary film.

Substrates:

GL Inks can be printed on all garments. Test for adhesion and bleed on poly and poly blends.

Modifiers:

Extend with LFP-1002 base and/or P-5011 curable reducer.

Curing:

Cure at 325-350°F (162-176°C) for approximately 60-90 seconds. This is a thick ink deposit. Check for proper cure before production.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol ink contains no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color.



COLOR LIST

GL LINE

GL Standard Color Offerings:

GL	202	GOLD
GL	212	COSMIC CRYSTALS
GL	403	VALENTINE RED
GL	408	PINK
GL	504	MEDIUM BLUE
GL	901	SILVER
GL	903	GUNMETAL

GL Inks Available on Request:

GL	201	YELLOW
GL	203	DARK GOLD
GL	301	LIGHT ORANGE
GL	401	FUCHSIA
GL	402	ROSE
GL	404	LIGHT SAND
GL	406	RED-ORANGE
GL	409	CABERNET
GL	501	ROYAL BLUE
GL	502	AQUA
GL	503	PEACOCK
GL	505	SKY BLUE
GL	506	SILVER-BLUE
GL	601	PURPLE
GL	602	LILAC
GL	701	SHAMROCK
GL	703	LIME GREEN
GL	704	MOSS
GL	705	PALE GREEN
GL	801	DARK SAND
GL	802	COPPER
GL	803	BRONZE
GL	804	SILVER-BROWN
GL	805	CINNAMON
GL	903	GUNMETAL
GL	906	HOLOGRAPHIC
GL	911	BLACK



PRODUCT DATA SHEET

ADDITIVES, REDUCERS, MODIFIERS

ATP-1001

Adhesive Gel (High Density Glue)

Overview:

ATP-1001 Adhesive Gel is a high density plastisol ink that is used to bond decorative materials such as sequins, glitter flakes, sugar, caviar beads, foil and flock to garments. It provides a clear base with exceptional adhesion to most types of decorative materials.

Printing:

Print through a 60-110 TPI (23-43 TPcm) mesh tightened to a minimum of 25 newtons. A 60-70 durometer squeegee is recommended. 1-2 strokes maybe necessary for the best deposit. To adhere sequins, beads or glitter, either sprinkle on top of wet ink or remove shirt from platen and press into decorated product. For foil application, cure garment as normal. Set your heat press to 375°F (190°C) and press for 15-20 seconds at moderate pressure. Check your foil manufacturer's specs for more detailed info on the specific heat your foil can withstand.

Stencil:

Use any direct emulsion or capillary film.

Curing:

Cure at 325°F (162°C) over a 60-90 second period, depending on oven type and thickness of ink deposit. A thicker deposit will take longer to cure as the heat must penetrate through the entire ink layer.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol inks contain no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.



PRODUCT DATA SHEET

ADDITIVES, REDUCERS, MODIFIERS

LFP-1060 Crystal Gel

Product Overview:

LFP-1060 Crystal Gel is a “high gloss” plastisol for printing thickly over other colors to create a raised and/or wet effect. It has the same effect as clear coating the paint on your car. Glitters are commonly added to provide sparkle on girls’ or women’s apparel.

Printing:

Use between a 60 mesh and 160 mesh screen, depending on how thick of a deposit is required. Screens stretched to a minimum of 25 newtons are recommended. If using lower tension screens, adjust off contact accordingly.

Stencil:

Use any direct emulsion or capillary film.

Curing:

Recommended cure temperature is 340-360°F (171-182°C). This temperature is required for the ink to become optically clear.

Special Effects:

Glitter is frequently sprinkled over the wet ink to give that extra special look, or mix in glitter pigments (e.g. crystallina) at 5 to 10%. Also, bright transparent pigment concentrates (see our PPRs) can be added to this clear gel base in very low concentrations (1 to 2 %) to give a colored transparent gel. Most printers just overprint over a base color to make it look like the gel is colored. This ink is also commonly used to create tone-on-tone effects by direct printing the clear ink onto the shirt. Up to 10% black may be used to create a greater tonal variance.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol inks contain no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.



PRODUCT DATA SHEET

FOIL ADHESIVE

ATP-190

Foil Adhesive

Overview:

ATP-190 Foil Adhesive is a plastisol ink that is used to adhere foil to garments.

Printing:

Print through an 80-110 TPI (30-43 TPcm) mesh tightened to a minimum of 25 newtons. A 60/90/60 or 70 durometer squeegee is recommended. 1-2 strokes may be necessary for the best deposit. For foil application, cure garment as normal. Set your heat press to 375°F (190°C) and press for 10-20 seconds at moderate pressure. Check your foil manufacturer's specs for more detailed info on the specific heat your foil can withstand. Some foil on the market will adhere to the ATP-190 faster than others. Always test your shops parameters before beginning production runs.

If printing a multicolor design with a foil accent, QCM recommends printing our WBX discharge or standard waterbase inks instead of plastisol. Print your waterbase/discharge inks as normal (following recommendations found in the WBX datasheets) then print the ATP-190 last. Cure as normal for waterbase inks and apply foil following the directions above.

Stencil:

Use any direct emulsion or capillary film.

Curing:

Cure at 325°F (162°C) over a 60-90 second period, depending on oven type and thickness of ink deposit. A thicker deposit will take longer to cure as the heat must penetrate through the entire ink layer.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM Plastisol Ink contains no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.



PRODUCT DATA SHEET

ADDITIVES, REDUCERS, MODIFIERS

LFP-1002 Halftone Base

Product Overview:

LFP-1002 Halftone Base is an economically priced clear extender that has exceptional adhesive properties. Use to either extend out your inks or add your favorite glitters and shimmers to create your own custom effects. The LFP-1002 Halftone Base cures out exceptionally clear and has very smooth printing characteristics. It does not print wet-on-wet.

Printing:

You may add 10%-25% to your desired ink colors to extend their life on press. For certain colors you may add up to 50%. If pigmenting your inks, add up to 30% pigment by weight. If adding flake to your ink, add up to 30% by weight as well. After mixing, the finished inks print well through screen meshes in the range of 83-385 (for inks with flakes added – consult your flake supplier for recommended mesh counts). Screens stretched to a minimum of 25 newtons are recommended. If using lower tension screens, adjust off contact accordingly. A 70 to 70/90/70 durometer sharp squeegee is recommended.

Stencil:

Use any direct emulsion or capillary film.

Additives:

None

Flashing:

Parameters vary between all flash units. Flash for 2-3 seconds with the ink deposit reaching 150-250°F (65-121°C). Ink should be dry and without tack.

Curing:

Cure at 325°F (162°C) over a 60-90 second period, depending on oven type and thickness of ink deposit. A thicker deposit will take longer to cure as the heat must penetrate through the entire ink layer.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol inks contain no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.



PRODUCT DATA SHEET

ADDITIVES, REDUCERS, MODIFIERS

WOW-1001 Halftone Base

Product Overview:

WOW-1001 Halftone Base is designed as both a stand-alone clear ink and as a mixing base created specifically for wet-on-wet printing. WOW-1001 Halftone Base, when pigmented or mixed with other plastisol inks, will produce an exceptionally clean ink that will print wet-on-wet forever, making this an ideal ink for high volume print jobs.

Printing:

You may add 10%-25% to your desired ink colors to enhance their printability and extend their life on press. For certain colors you may add up to 50%. If pigmenting your inks, add up to 30% pigment by weight. After mixing, the finished inks print well through screen meshes in the range of 83-385. Screens stretched to a minimum of 25 newtons are recommended. If using lower tension screens, adjust off contact accordingly. Recommend a 70 to 70/90/70 durometer sharp squeegee.

Stencil:

Use any direct emulsion or capillary film.

Additives:

None

Flashing:

Parameters vary between all flash units. Flash for 2-3 seconds with the ink deposit reaching 150-250°F (65-121°C). Ink should be dry and without tack.

Curing:

Cure at 325°F (162°C) over a 60-90 second period, depending on oven type and thickness of ink deposit. A thicker deposit will take longer to cure as the heat must penetrate through the entire ink layer.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol inks contain no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.



PRODUCT DATA SHEET

STRETCH BASE

STR-100

Stretch Base

Product Overview:

STR-100 is a ready-to-use plastisol ink that is used to improve strength and elongation of standard plastisol inks (XOLB, LFP and WOW etc.). It can also be pigmented or used as a clear overprint.

Mixing:

Recommended mixing percentages are:

Colors: 70% Color – 30% STR 100
White: 55% White – 45% STR-100

A higher level of STR-100 is possible, but can create a loss of opacity in your colors and whites.

Printing:

Recommend 83-110 TPI (32-43 TPcm) for best results. Screens stretched to a minimum of 25 newtons are recommended. A thicker deposit is better. The thicker the deposit, the longer the print will last. In lab testing, we have found that a print-flash-print held up the longest in comparison tests.

Stencil:

Use any direct emulsion or capillary film.

Substrates:

STR-100 is designed for 100% cotton, cotton/poly blends and Lycra®. It has moderate bleed resistant qualities. STR-100 will decrease opacity of your standard inks.

Curing:

Recommended cure temperature is 340-360°F (171-182°C) for 60-90 seconds, depending on the curing unit and thickness of ink deposit. The ink film must be heated throughout to thoroughly cure. When thoroughly cured, the ink is 100% washable. Wash test the garment to verify your curing is adequate.

It is strongly recommended that the garment is not stretch tested until the garment has cooled and set for a full 24 hours. If the garment is stretched before cooling and setting, the ink is much more likely to crack and break.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM Plastisol Ink contains no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.



PRODUCT DATA SHEET

FOUR COLOR PROCESS INKS

Four Color Process Inks

Product Overview:

QCM Four Color Process inks are superior quality transparent plastisols formulated to achieve the most accurate 4 color process reproductions. These colors are finely milled, allowing the ink to pass easily through 405 TPI (159 TPcm) mesh resulting in minimal ink deposits while maintaining excellent color strength. For best results, print on white garments, cotton or cotton polyester blends of a tight weave. Open weave garments give a washed out appearance with process printing. If printing on colored garments, use a white underlay or base print.

Available in Colors:

WOW-219	PROCESS YELLOW
WOW-492	PROCESS MAGENTA
WOW-523	PROCESS CYAN BLUE
WOW-920	PROCESS BLACK

Related Items:

WOW-1001	HALFTONE BASE
LFP-429	HALFTONE RED (STRONG RED)

Artwork & Separations:

A good finished product starts with the original artwork. *Know the limitations of process printing on garments.* While it is impossible to exactly reproduce a photograph or full color piece of artwork, you can achieve a very good, even excellent representation, but it will never exactly match the original. This is due to limitations of line/dot size and density minimums required to screen print on garments. Be sure your customer is aware of that.

QCM Textile Inks now offers Art Separation Services.

Call now for more information: (800) 321-0170 or email us at colin.huggins@qcminks.com.

Screen Frames:

Variables in the four color process printing project must be kept under control. A very important part of this is controlling mesh tension, keeping it consistent. Retensionable frames allow you to control this very important aspect, whether you're printing four color process or standard printing. They are an excellent investment to ensuring quality.

Screen Mesh:

The recommended mesh for process printing is 355 TPI (139 TPcm). As low as 305 TPI (80 TPcm) or as high as 380 TPI (149 TPcm) is acceptable.

Pre-testing is imperative. Tension should be between 25-35 newtons.

Stencil:

Direct or indirect stencils.

Exposure:

A single point light source of 3K to 5K or above is recommended to ensure your finest halftones are represented. Always use an exposure calculator. Use clear film for the best D-min to D-max ratio for a clean burn – inkjet or silver-based film work great.

Squeegee:

A sharp, nearly straight up, triple durometer blade of 70-90-70 is recommended. Many printers still use 80 durometer blades, while others are experimenting with 90 durometer blades. Be sure your squeegee is the proper length for the image area. Squeegee angle and pressure must remain consistent.

Your Press:

Your press, whether manual or automatic, should be "dead on." If you have a four color process job pending, this is a good time for a tune up. Make certain your press can hold tight registration. Are your platens level? Are your print heads level, front to rear and side to side? If using retensionable frames, set your off contact to 1/16" (1.5mm) or less.

Important Notes:

Always pre-test process inks; remember - they are transparent. Inks are a variable in process printing. Different manufacturers' products appear "different" in the "wet" or container form. Some appear gelatinous while others, like QCMs, appear more like standard plastisol. The "wet" appearance is not an indicator of the ink's transparent value. Process inks are designed to be printed on white garments or printed on a white base on dyed garments. The ink, being transparent, will allow the under color of the garment to affect the color of the printed image.

Printing:

Use minimal pressure when flooding. If manual printing, maintain consistent squeegee pressure and angle. If all of the variables listed prior are addressed properly, one pass of each color will give you the best results. Added strokes will result in heavier deposits, increasing dot gain and compromising the quality of the print.

Ink Modification:

QCM Process inks are ready to use out of the container. If reducing strength of any one of the four colors is necessary, use QCM WOW-1001 Halftone Base to cut the intensity of the ink without altering color value.

Curing:

QCM Process inks cure at 310-330°F (154-165°C). Oven duration depends on your individual dryer and ink deposit. Test your dryer for temperature consistency daily. We recommend wash testing.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol inks contain no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination



PRODUCT DATA SHEET

PUFF INKS

EHP-1000 Puff Base

Product Overview:

EHP-1000 is a base puff ink designed to be pigmented at up to 30% or added at up to 50% to a finished ink. The EHP-1000 has been formulated to produce a high “Puff” effect on a variety of fabrics. This ink prints smooth and has an even rise for a clean, sharp print. It has low bleed qualities and is very durable when cured properly.

Printing:

Puff inks are generally printed through coarse meshes, 60-80 TPI (23-31 TPcm) and as high as 110-160 TPI (43-62 TPcm). Screens stretched to a minimum of 25 newtons are recommended. This allows you to lay the ink on the surface of the shirt using minimal squeegee pressure and minimal off contact.

Stencil:

Use any water resistant direct emulsion or capillary film.

Substrates:

EHP-1000 may be printed on 100% cotton, cotton/poly blends, acrylics and polyesters. Pre-production run testing is always recommended to ensure adhesion, washability and dye migration, amongst other things.

Curing:

Recommended cure temperature is 320-340°F (160-171°C) for 60-90 seconds, depending on curing unit and thickness of ink deposit. Lower temperatures may not produce adequate puffing and higher temperatures or excessive duration in the dryer may cause ink to over-puff and collapse.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol inks contain no leaded pigments and, when properly disposed of has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.



PRODUCT DATA SHEET

PUFF INKS

EHP-2001

Galactic Glow

Product Overview:

EHP-2001 Galactic Glow is a white puff ink that glows in the dark. Add an extra dimension to all night time designs by printing the stars and other night time objects with EHP-2001 Galactic Glow.

Printing:

Puff inks are generally printed through coarse meshes, 60-80 TPI (23-31 TPcm) and as high as 110-160 TPI (43-62 TPcm). Screens stretched to a minimum of 25 newtons are recommended. This allows you to lay the ink on the surface of the shirt using minimal squeegee pressure and minimal off contact.

Stencil:

Use any water resistant direct emulsion or capillary film.

Substrates:

EHP-2001 may be printed on 100% cotton, cotton/poly blends, acrylics and polyesters. Pre-production run testing is always recommended to ensure adhesion, washability and dye migration, amongst other things.

Curing:

Recommended cure temperature is 320-340°F (160-171°C) for 60-90 seconds, depending on curing unit and thickness of ink deposit. Lower temperatures may not produce adequate puffing and higher temperatures or excessive duration in the dryer may cause ink to over-puff and collapse.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol inks contain no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color.



PRODUCT DATA SHEET

SUEDE BASE

ESP-3001

Suede Base

Product Overview:

ESP-3001 Suede Base is a plastisol base that when mixed with colorant (finished ink or pigments) is used to create a variety of simulated suede leather finishes. If adding to a finished ink, use 3 parts ESP-3001 and 1 part finished ink. If adding pigments, add 20%-30% by weight. Test for proper suede effect. If, after full cure, flaking occurs add either colored finished ink (if you started with a finished ink color) or a clear ink (if you started with pigments). Again test for proper suede effect.

Printing:

ESP-3001 mixes are generally printed through 110-160 TPI (43-63 TPcm) and as high as 195 TPI (77 TPcm). Screens stretched to a minimum of 25 newtons are recommended. This allows you to lay the ink on the surface of the shirt using minimal squeegee pressure and minimal off contact. Print deposit will affect the final result of the suede finish. A thick deposit will give a spongy, heavy texture looking suede effect, while a thin deposit will give a very smooth finish.

Stencil:

Use any high solids direct emulsion or capillary film.

Substrates:

ESP-3001 may be printed on 100% cotton, cotton/poly blends, acrylics and polyesters. Pre-production run testing is always recommended to ensure adhesion, washability and dye migration, amongst other things.

Curing:

Recommended cure temperature is 320-340°F (160-171°C) for 90-120 seconds, depending on curing unit and thickness of ink deposit. Lower temperatures may not produce adequate puffing/suede effects.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM Plastisol Ink contains no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color.



PRODUCT DATA SHEET

GLOW INKS

LFP-1007

Glow

Product Overview:

LFP-1007 Glow ink contains maximum levels of phosphorescent pigments that store light energy when exposed to a natural or artificial light source

Printing:

For best results, flood the image and print using a sharp 70 durometer squeegee. A 65-90-65 durometer squeegee may be used when a very heavy deposit is required. 80-160 TPI (32-120 TPcm) monofilament polyester tightened to manufacturer's specs is recommended. It is strongly recommended that a white base be used when printing on colored shirts. While the LFP-1007 can be printed over colors, the darker the under color, the less glow you will see.

Stencil:

Use any direct emulsion or capillary film.

Modifiers:

While we do not recommend modifying the ink, you can use our LFP-1002 Base and/or WOW-1015.

Curing:

Cure at 325°F (162°C) over a 60-90 second period, depending on oven type and thickness of ink deposit. A thicker deposit will take longer to cure as the heat must penetrate through the entire ink layer.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol inks contain no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.



PRODUCT DATA SHEET

GLOW INKS

LFP-1028

Super Glow

Product Overview:

LFP-1028 Super Glow ink contains maximum levels of phosphorescent pigments that store light energy when exposed to a natural or artificial light source.

Printing:

For best results, flood the image and print using a sharp 70 durometer squeegee. A 65-90-65 durometer squeegee may be used when a very heavy deposit is required. 80-160 TPI (32-120 TPcm) monofilament polyester tightened to manufacturer's specs is recommended. It is strongly recommended that a white base be used when printing on colored shirts. While the LFP-1028 can be printed over colors, the darker the under color, the less glow you will see.

Stencil:

Use any direct emulsion or capillary film.

Modifiers:

While we do not recommend modifying the ink, you can use our LFP-1002 Base and/or WOW-1015.

Curing:

Cure at 325°F (162°C) over a 60-90 second period, depending on oven type and thickness of ink deposit. A thicker deposit will take longer to cure as the heat must penetrate through the entire ink layer.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol inks contain no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.



PRODUCT DATA SHEET

PUFF INKS

MF-167

Puff Additive

Product Overview:

MF-167 is a concentrated plastisol printing ink which has been formulated so that when added to a finished ink, it produces a high "Puff" effect on a variety of fabrics. These finished inks print smooth and have an even rise for a clean, sharp print. Add at 5-15% by weight and test for desired puff effect. Depending on mesh count used and print technique, you may add up to 20% by weight.

Printing:

Puff inks are generally printed through coarse meshes, 60-80 TPI (23-31 TPcm) and as high as 110-160 TPI (43-62 TPcm). Screens stretched to a minimum of 25 newtons are recommended. This allows you to lay the ink on the surface of the shirt using minimal squeegee pressure and minimal off contact.

Stencil:

Use any direct emulsion or capillary film.

Substrates:

MF-167 may be printed on 100% cotton, cotton/poly blends, acrylics and polyesters. Pre-production run testing is always recommended to ensure adhesion, washability and dye migration, amongst other things.

Curing:

Recommended cure temperature is 320-340°F (160-171°C) for 60-90 seconds, depending on curing unit and thickness of ink deposit. Lower temperatures may not produce adequate puffing and higher temperatures or excessive duration in the dryer may cause ink to over-puff and collapse.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol inks contain no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.



PRODUCT DATA SHEET

DP-100

DP-100

Ink Relaxer

Product Overview:

DP-100 is a low viscosity proprietary product designed to relax, thick/stiff/tacky ink and make it printable again. It is recommended to be used at 0.5%-3% by weight. **Most ink will see optimal print properties restored with no more than an 1% add of DP-100.** Although with some older and thicker inks, you may need to add up to 5%. Please refrain from adding more than 5% DP-100 to your ink. If you must do so, please mix a sample batch in a smaller container first and perform a test print for printability and cure of ink.

Printing:

Following the directions above, add the DP-100 to your ink. Mix thoroughly for up to 5 minutes, either on a turnabout or with a moderate speed drill (be careful not to get the ink hot while stirring). Test your finished product for opacity and adhesion.

Warning: Do not over add. Adding too much will cause the ink to take longer to cure and may even lead to an incurable product.

Stencil:

N/A

Additives:

N/A

Flashing:

May change flashing parameters. Test before you put the mixed ink into production.

Curing:

Should not change cure parameters of ink.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM Plastisol Ink contains no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.



PRODUCT DATA SHEET

ADDITIVES, REDUCERS, MODIFIERS

RD-55

Reducer #55

Product Overview:

RD-55 is a low viscosity plasticizer designed to soften your final print. It is normally used at up to 5% without losing opacity; it can be used at up to 10%. The more you use, the softer the ink will become.

Printing:

Following the directions above, add the RD-55 to your ink. Mix thoroughly for 5 minutes, either on a turnabout or with a moderate speed drill (be careful not to get the ink hot while stirring). Test your finished product for opacity and adhesion.

Warning: Do not over add. Adding too much will cause the ink to take longer to cure and may even lead to an incurable product.

Stencil:

Use any direct emulsion or capillary film.

Additives:

None

Flashing:

May change flashing parameters. Test before you put the mixed ink into production.

Curing:

Cure at 325°F (162°C) over a 60-90 second period, depending on oven type and thickness of ink deposit. A thicker deposit will take longer to cure as the heat must penetrate through the entire ink layer.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.

Environmentally Friendly:

QCM plastisol inks contain no leaded pigments and, when properly disposed of, has no environmental impact. Use a screen wash for plastisols for cleanup. Scrape screens carefully and store ink for reuse. Minimize unusable scrap ink by segregating ink by color. QCM PPR-901 Black pigment can be used to convert old ink into black ink for waste elimination.



PRODUCT DATA SHEET

ADDITIVES, REDUCERS, MODIFIERS

MF-66

Nylon Bonding Agent

Product Overview:

MF-66 Nylon Bonding Agent is an additive to plastisol inks for printing on shell or treated Nylon substrates. These substrates generally appear in the form of waterproofed jackets. Since each jacket manufacturer determines the type and amount of waterproofing chemical they apply to their garments, it is recommended that each batch of garments be tested prior to production.

Printing:

Add MF-66 to un-modified plastisol ink at a ratio of 10-12% by weight (1 Part MF-66 to 7 Parts of Ink). The mix is critical to success. Mix thoroughly. The addition of MF-66 generally "thins" the ink. Nylon substrates do not absorb ink. Rather, it lays on the surface. A heavy deposit is generally not necessary for opacity. The use of higher mesh counts maintains edge definition and prevents wicking.

Formula for adding 12% of MF-66 into a certain **Amount of Ink** by weight:

Amount of MF-66 to add = (**Amount of Ink**) x (0.136)

Make sure your container of MF-66 is tightly sealed after each use.

All other printing procedures are standard, such as stencil system, squeegee durometer and screen tension. We recommend using a jacket clamp or other hold down device and pre-shrinking the jacket with your flash cure unit before printing. This is particularly important if printing multi colors to ensure registration.

Stencil:

Use any direct emulsion or capillary film.

Pot Life:

Mixtures of MF-66 and plastisol result in a 4-6 hour pot life. It is recommended that you mix only what you intend to use during this period. Do not put unused mixture back into the original ink container as it will affect the ink that is already in the container. Properly dispose of unused, mixed ink.

Flashing:

Parameters vary between all flash units. Flash for 2-3 seconds with the ink deposit reaching 150-250°F (65-121°C). Ink should be dry and without tack.

Curing:

Cure at 325°F (162°C) over a 60-90 second period, depending on oven type and thickness of ink deposit. A thicker deposit will take longer to cure as the heat must penetrate through the entire ink layer.

Cleanup:

Use any of the commercially available products for the cleanup of plastisol inks.



PRODUCT DATA SHEET

WBX

WBX

Water Base Pigment Mixing System

Product Overview:

Accurately mix your own Pantone colors using only a scale, WBX bases and WBX pigments. Formulas are available in the WBX Matching System Software which is available for download on our website www.qcminks.com. Weigh in pigments and bases per formula instructions and mix well. Remember, this is an air-dry product, so keep containers covered. Then print per directions below.

Printing:

All WBX Bases print the same. However, each one has subtle nuances. QCM encourages you to read the data sheets on the **DIS-SWBS Sweet Discharge Base**, **DIS-BSE Discharge Base**, and the **RFU-EXT Extender Base**. When mixed the WBX Pantone mixes have excellent screen open times. See the data sheet for the base you are using for more detailed information.

Remember to finish your print with a flood of your image. This will help keep the image area from drying out. The QCM WBX inks have excellent anti-crocking properties when fully cured. Test for crocking after curing by wetting and rubbing printed surfaces with a white piece of shirt material. If crocking (rubbing off) is happening, more drying time may be required. Machine wash to determine the long term durability of the print. Each fabric will be somewhat different.

Stencil:

Use any water resistant direct emulsion or capillary film.

Additives and Modifiers:

WB-BNDR: An additive meant to be used whenever adding extra pigment to an existing formula is needed. Binder is used to promote adhesion of the pigment to the finished ink layer. Use WB-BNDR at a 2:1 ratio with the pigment you are adding to your ink.

WB-FIX: An additive used to insure proper adhesion of the ink to the substrate/garment. Use WB-FIX by adding 2-4% by weight to the ink to be used. Do not exceed 4%.

WB-LUB: An additive that promotes the retention of water in water base inks, creating longer screen open times. Use WB-LUB at up to 5% by weight. Do not exceed 5%.

WB-PEN: An additive that promotes ink flow in water base inks. WB-PEN allows the water base ink to penetrate deeper into the fabric you are printing on. Use WB-PEN Penetrant at 1-3% by weight into your finished ink. Do not add more than 3%.

WB-SFT: An additive designed to increase the soft hand feel of finished water base prints. Use WB-SFT Softener at 2-4% by weight to your finished ink and test. Do not exceed 4%.

Flashing:

Follow the flash instructions from the data sheet for the base you are using.

Curing:

Consult the data sheet for the base you are using for proper cure instructions.

Cleanup:

Use any of the commercially available products for the cleanup of water base inks. Warm water and soap works as well.



PRODUCT DATA SHEET

WB BASES

DIS-SWBS

Ready For Use Sweet Discharge Base

Product Overview:

DIS-SWBS Ready For Use Sweet Discharge Base is a dischargeable water base clear designed to be used as a base for pigments (WBX color matching) and as a standalone clear discharge ink. DIS-SWBS has a sweet smell. DIS-SWBS is ideal for use on all colored garments including cottons, terry cloth, towels and some 50/50 blends. Do not leave DIS-SWBS sitting in your screen for long periods of time as it can dry out. When activated with DIS-ACT Activator, your mixed/activated ink will have an 8 hour shelf life. It is strongly recommended to only add DIS-ACT to what you will use for that job, during that shift.

Printing:

DIS-SWBS can be run on both manual and automatic presses. Pigment loading should not exceed 5% by weight with the WBX Mixing System pigments. If you do exceed 5% please follow directions in the WB-BNDR data sheet. Also, if using the WBX mixing system software, follow the directions under color boost for the appropriate amount of additives needed for proper ink balance.

To activate the discharge ability of the ink, add **6% by weight** of DIS-ACT Activator to your final mixed product. DIS-SWBS will print well through screen meshes in the range of 60-160 TPI (23-63 TPcm). DIS-SWBS will print through higher mesh counts, however, the screen will be more prone to having the ink "dry in" and the fine details and dots will be lost. Screens stretched to a minimum of 25 newtons are recommended. If using lower tension screens, adjust off contact accordingly. If drying occurs when printing, follow the directions on the WB-LUB to increase screen open time. Also if needed, to make sure enough ink penetrates the shirt fibers, follow the directions in the WB-PEN data sheet.

Depending on the dye quality of your garments, you will use one of two print techniques. If the dyes in your garment are easily dischargeable (you know this because you tested your garment, right?) then print as normal with no modifications to your flood or print stroke. If the dyes in your garment are more difficult to discharge, then you want to really drive the ink into the garment using a hard print/flood technique. This way the water base ink actually penetrates deeper inside the fibers, guarantying a better discharge of the garment. A 60/90/60 or 70 durometer sharp squeegee is recommended; test what type of blade gives you the best result. Always print with a print/flood technique, keeping your image area wet. This will assure your screens stay clear as long as possible. **Warning:** Always pre-test the dischargeability of your garments by printing a small swatch near the hem on the inside of the garment. Not all garments that are sold as dischargeable will discharge completely.

Stencil:

Any high solids water resistant/discharge ready liquid emulsion or capillary film will work.

Flashing:

N/A

Curing:

Cure for 3-5 min at 320 degrees Fahrenheit. Make sure the ink is still wet going into the dryer chamber. This will assure the best discharge possible. ALL the water must evaporate from the ink before it will cure. Always test prior to production.

Cleanup:

Use any of the commercially available products for the cleanup of water base inks. Warm water and soap works as well.



PRODUCT DATA SHEET

WB BASES

DIS-BSE

Ready For Use Discharge Base

Product Overview:

DIS-BSE Ready For Use Discharge Base is a water base clear designed to be used as a base for pigments (WBX color matching) and as a standalone clear discharge ink. DIS-BSE is ideal for use on all colored garments including cottons, terry cloth, towels and some 50/50 blends. Do not leave DIS-BSE sitting in your screen for long periods of time as it can dry out. When activated with DIS-ACT Activator, your mixed/activated ink will have an 8 hour shelf life. It is strongly recommended to only add DIS-ACT to what you will use for that job, during that shift.

Printing:

DIS-BSE can be run on both manual and automatic presses. Pigment loading should not exceed 5% by weight with the WBX Mixing System pigments. If you do exceed 5% please follow directions in the WB-BNDR data sheet. Also, if using the WBX mixing system software, follow the directions under color boost for the appropriate amount of additives needed for proper ink balance.

To activate the discharge ability of the ink, add **6% by weight** of DIS-ACT Activator to your final mixed product. DIS-BSE will print well through screen meshes in the range of 60-160 TPI (23-63 TPcm). DIS-BSE will print through higher mesh counts, however, the screen will be more prone to having the ink “dry in” and the fine details and dots will be lost. Screens stretched to a minimum of 25 newtons are recommended. If using lower tension screens, adjust off contact accordingly. If drying occurs when printing, follow the directions on the WB-LUB to increase screen open time. Also if needed, to make sure enough ink penetrates the shirt fibers, follow the directions in the WB-PEN data sheet.

Depending on the dye quality of your garments, you will use one of two print techniques. If the dyes in your garment are easily dischargeable (you know this because you tested your garment, right?) then print as normal with no modifications to your flood or print stroke. If the dyes in your garment are more difficult to discharge, then you want to really drive the ink into the garment using a hard print/flood technique. This way the water base ink actually penetrates deeper inside the fibers, guarantying a better discharge of the garment. A 60/90/60 or 70 durometer sharp squeegee is recommended; test what type of blade gives you the best result. Always print with a print/flood technique, keeping your image area wet. This will assure your screens stay clear as long as possible. **Warning:** Always pre-test the dischargeability of your garments by printing a small swatch near the hem on the inside of the garment. Not all garments that are sold as dischargeable will discharge completely.

Stencil:

Any high solids water resistant/discharge ready liquid emulsion or capillary film will work.

Flashing:

N/A

Curing:

Cure for 3-5 min at 320 degrees Fahrenheit. Make sure the ink is still wet going into the dryer chamber. This will assure the best discharge possible. ALL the water must evaporate from the ink before it will cure. Always test prior to production.

Cleanup:

Use any of the commercially available products for the cleanup of water base inks. Warm water and soap works as well.



PRODUCT DATA SHEET

WB BASES

RFU-EXT

Ready For Use Extender Clear

Product Overview:

RFU-EXT Ready For Use Extender Clear is a soft hand water base clear designed to be used as a base for pigments (WBX color matching) or to add to existing RFU inks as necessary. RFU-EXT is ideal for use on light colored garments including cottons, 50/50 blends, terry cloth or polyester and lycra when modified for those fabric types. Do not leave RFU-EXT sitting in your screen for long periods of time as it can dry out.

Printing:

RFU-EXT can be run on both manual and automatic presses. Pigment loading should not exceed 5% by weight with the WBX Mixing System pigments. If you do exceed 5% please follow directions in the WB-BNDR data sheet. Also, if using the WBX mixing system software, follow the directions if applicable under color boost for the appropriate amount of additives needed for proper ink balance.

RFU-EXT will print well through screen meshes in the range of 60-160 TPI (23-63 TPcm). RFU-EXT will print through higher mesh counts, however, the screen will be more prone to having the ink “dry in” and the fine details and dots will be lost. When printing through higher mesh counts follow the directions on the WB-LUB to increase screen open time. If you want improved ink penetration, follow the directions in the WB-PEN data sheet. Screens stretched to a minimum of 25 newtons are recommended. If using lower tension screens, adjust off contact accordingly.

With water base inks you actually want to drive the ink into the garment. A 60/90/60 or 70 durometer sharp squeegee is recommended; test what type of blade gives you the best result. Always print with a print/flood technique. This will assure your screens stay clear as long as possible.

Stencil:

Any high solids water resistant liquid emulsion or capillary film will work.

Flashing:

N/A

Curing:

Cure for 3 min at 320 degrees Fahrenheit. ALL the water must evaporate from the ink before it will cure. Always test prior to production.

Cleanup:

Use any of the commercially available products for the cleanup of water base inks. Warm water and soap works as well.



PRODUCT DATA SHEET

WB ADDITIVES

DIS-ACT Activator

Product Overview:

DIS-ACT Activator is an oxidizing agent for use in our **DIS-SWBS** and **DIS-BSE**. It is what “strips or removes” the color dyes from the garment.

Printing:

N/A

Stencil:

N/A

Directions on use:

Use DIS-ACT Activator by adding 6% by weight to the ink to be activated. Do not activate more ink than you will use in an 8 hour period. If you are mixing enough ink for several days’ production, only activate what is needed for that shifts production.

When adding pigments into the ink, add your colors and any additives first, then tally your total weight. Calculate the percentage of WB-ACT you need and add that last. Use some form of strong stirring/homogenization (a small hand held drill works well) to ensure the WB-ACT is fully dissolved. Hand stirring is NOT recommended.

Curing is extremely important in assuring the evaporation of the WB-ACT. If recommended cure time or temperature is not achieved, washing may be recommended to remove any activator. Always use proper safety gear when handling WB-ACT which includes goggles and gloves.

Flashing:

N/A

Curing:

N/A

Cleanup:

Use any of the commercially available products for the cleanup of water base inks. Warm water and soap works as well.



PRODUCT DATA SHEET

WB ADDITIVES

WB-BNDR Binder

Product Overview:

WB-BNDR Binder is an additive meant to be used when adding extra pigment to an existing formula. Binder is used to promote adhesion of the pigment to the garment/fabric. Proper use of WB-BNDR will impart excellent color and crock fastness.

Printing:

N/A

Stencil:

N/A

Directions on use:

Use WB-BNDR at a 2:1 ratio with the extra pigment you are adding to your ink. Example: If you add 25 grams of extra pigment to a WBX formula or to a finished ink add 50 grams of WB-BNDR to assure additional adhesion. Please test finished ink for cure before going into production.

Flashing:

N/A

Curing:

N/A

Cleanup:

Use any of the commercially available products for the cleanup of water base inks. Warm water and soap works as well.



PRODUCT DATA SHEET

WB ADDITIVES

WB-FIX Fixer

Product Overview:

WB-FIX Fixer is a crosslinking additive used to improve fastness of the ink to the garment and accelerate its curing properties. WB-FIX will post cure for up to 72 hours, which allows for the air drying of water base inks.

Printing:

N/A

Stencil:

N/A

Directions on use:

Use WB-FIX by adding 3% by weight to the ink to be used. Use as soon as possible after addition of the WB-FIX as the strength diminishes within a 12 hour period. It can be re-added for continued printing without a negative effect on the ink. Please test finished ink for cure before going into production.

Flashing:

N/A

Curing:

N/A

Cleanup:

Use any of the commercially available products for the cleanup of water base inks. Warm water and soap works as well.



PRODUCT DATA SHEET

WB ADDITIVES

WB-LUB Lubricant

Product Overview:

WB-Lub Lubricant is an additive that promotes the retention of water in a water base ink system. WB-LUB is also known as a humectant. When added to your water base ink, the ink will stay “wetter” for a longer period of time. This will allow you to print for longer periods of time before needing to “re-wet” or mist water on your screens.

Printing:

N/A

Stencil:

N/A

Directions on use:

Add WB-LUB at up to 5% by weight. **Caution:** Understand that the more you add to your finished ink, the longer it will take to cure the finished print. The WB-LUB promotes a slower evaporation of the water in the dryer chamber and it is only when the water is completely evaporated that the ink deposit can fully cure. Please test finished ink for cure before going into production.

Flashing:

N/A

Curing:

N/A

Cleanup:

Use any of the commercially available products for the cleanup of water base inks. Warm water and soap works as well.



PRODUCT DATA SHEET

WB ADDITIVES

WB-PEN Penetrant

Product Overview:

WB-PEN Penetrant is an additive that promotes ink flow in water base inks. WB-PEN allows the water base ink to penetrate deeper into the fabric you are printing on. While the printer will use WB-PEN primarily on thicker fabrics, it can be used on all fabric types to promote a much softer feel. When added at the proper ratio, your finished ink will have improved printability, reduced grinning/wicking (ink spread) and improved ink penetration on difficult substrates like terry cloth (bath robes), towels, and other thick fabrics.

Printing:

N/A

Stencil:

N/A

Directions on use:

Use WB-PEN Penetrant at 1-3% by weight into your finished ink. Do not add more than 3%. Please test finished ink for cure before going into production.

Flashing:

N/A

Curing:

N/A

Cleanup:

Use any of the commercially available products for the cleanup of water base inks. Warm water and soap works as well.

Environmentally Friendly:

QCM water base inks contain no leaded pigments and, when properly disposed of, has no environmental impact. Use water emulsifying screen cleaners for cleanup. Scrape screens carefully and store ink for reuse.



PRODUCT DATA SHEET

WB ADDITIVES

WB-SFT Softener

Product Overview:

WB-SFT Softener is designed to increase the soft hand feel of finished water base prints. This is especially desirable when doing fashion prints and printing on super light weight fabrics.

Printing:

N/A

Stencil:

N/A

Directions on use:

Use WB-SFT Softener at 2-4% by weight to your finished ink and test. **Warning:** Do not exceed 4% as you may have problems achieving a full cure of your ink.

Flashing:

N/A

Curing:

N/A

Cleanup:

Use any of the commercially available products for the cleanup of water base inks. Warm water and soap works as well.



CERTIFICATE OF COMPLIANCE

QCM Company Textile Screen Printing Inks Specification for the Absence of Harmful Substances in Textiles and Clothing.

QCM Company uses exacting internal quality control standards to ensure the compliance of all products manufactured by QCM Company. All product lines have been tested by 3rd party testing facilities to verify compliance with regulations set forth by various public entities.

QCM Product Series XOLB, MTL, HP, TSP, WOW, QMX, AP, HS, WB, RB, EHP, DT, OPC, GL and LFP:

- Are formulated to meet specifications of California Assembly Bill AB-1108.
- Are formulated to meet specifications of Consumer Products Safety Improvement Act HR-4040.
- Are formulated to contain no substances listed under State of Washington House Bill E2SHB 2647.
- Are formulated to contain no substances listed under State of California Bill Proposition 65.
- Are formulated to contain no substances listed in the Canadian CEPA Environmental Registry.
- Are formulated to contain no di-(2-ethylhexyl) phthalate (DEHP), dibutyl phthalate (DBP), benzyl butyl phthalate (BBP), diisononyl phthalate(DINP), diisodecyl phthalate (DIDP), di-n-octyl phthalate (DnOP).
- Are formulated to contain no cadmium, azo, formaldehyde, chromium, lead, tin, nickel, trichloro-phenols, chlorinated organic solvents, tetra-chlorophenols, penta-chlorophenols or disperse dyes.
- Are formulated as nonflammable and do not require a flammability certificate / 1610 wearing apparel.

Barry Williams
Technical Director

Quality Controlled Manufacturers of INKS, COATINGS, ADHESIVES & MOLDING VINYLs AND EPOXIES

Recommendations for the use of this product are based on tests believed to be reliable. However, since the use of this product is beyond our control, no guarantee or warranty of any kind, expressed or implied, is made with respect to information presented, and QCM Company assumes no responsibility for the results of the use of this product and processes described.

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