



# PRODUCT DATA SHEET

## POLAR WHITE

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### XOLB-165

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#### Product Overview:

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. 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.

#### Printing:

Polar White prints 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. Recommend a 70 durometer sharp squeegee.

#### Stencil:

Use any direct emulsion or capillary film.

#### Additives:

Polar White is a ready-to-print ink. Reduce, only if necessary, using P-5011 curable reducer. Reducing the viscosity can also reduce the opacity and coverage of the ink. Please test before production run. For printing on nylon, mix with MF-66 Nylon Bonding Agent.

#### 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.