



# PRODUCT DATA SHEET

## XOLB LINE

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### XOLB

### Extra Opaque, Low Bleed Inks

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#### 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.