Product Guide

Midori NPT Series

WM PLASTICS INC®

Servicing The Industry Since 1983

INK MANUFACTURING COMPANY

Service Driven, Quality Focused & Economically Priced

www.wmplasticsinc.com

What We Do:

WM Plastics has been a leading manufacturer of quality textile inks since 1983. For nearly 30 years WM Plastics has catered to the screen printing industry by providing a variety of products which include: top of the line whites, blacks, special effect inks, mixing systems, additives, bases and the ability to match any color possible in the spectrum. WM Plastics has grown tremendously over the years through dedication to customer service, quality of products and economical pricing, all key areas enabling us to reach customers throughout the United States, China & India.

Service Driven, Quality Focused, and **Economically priced** (three reasons to trust us with your business), says it all!!! From placing an order to receiving your order in a timely fashion, as the customer, WM Plastics is dedicated to you. We stand behind our business and products with a team that is devoted to making your experience a pleasant one, enticing you to come back again and again.

WM PLASTICS INC®

Servicing The Industry Since 1983

4237 Raleigh St.
Charlotte, NC 28213
1-800-535-4657 (Inks)

www.wmplasticsinc.com

Distributor List

Alabama
Magic City Sportswear
3131 4th Ave. South
Birmingham, AL 35233
205-871-9100

Arizona
Advanced Screen Technologies
619 S. Hacienda Dr.
#1-2, Tempe, AZ 85281
1-877-509-7600
www.advancedscreenprintsupply.com

California
Ink It
4320 Anthony Ct. #1
Rocklin, CA 95677
916-331-5210

SDMI, Inc.
6800 Orangethorpe Ave
Unit B
Buena Park, CA 90620
714-670-7411

Florida
Florida Flex
2671 West 76 St.
Hialeah, FL 33016
305-512-2222
www.floridaflex.com

National UV
549 W 13th St.
Apopka, FL 32703
800-940-6887
www.nationaluvsupply.com

Tubelite
102 Semoran Commerce Place
Apopka, FL 32703
800-505-4900
www.tubelite.com

Georgia
S Cooper Stanley Sales
Griffin, GA 30224
770-227-6138

Zim International
1828 S. Cobb Industrial Blvd.
Smyrna, GA 30082
800-241-8181
www.zim-intl.com

Hawaii
American T-Shirt Co
1217 North King St.
Honolulu, HI 96817
808-842-4466

Michigan
One Source
4420 Elms Rd.
Swartz Creek, MI 48473
810-635-8844

T. Rosema & Associates
3824 44th Street SE
Grand Rapids, MI 49512
616-698-8810
www.gatewayscreenproducts.com

Missouri
Gateway Screen Supply
1806 W. Osage
Pacific, MO 63069
636-271-8391
www.gatewayscreenproducts.com

New York
Prospect Industries
47 Summit Ave
Central Valley, NY 10917
845-928-7998

Viking Solutions
47 Summit Ave
80 East Montauk Highway
Lindenhurst, NY 11757
800-269-7232

Ohio
Richardson Supply
2080 Hardy Parkway St.
Grove City, OH 43123
614-539-3033
www.richardsonsupply.com

Pennsylvania
Wildside North
107 Arrowhead Drive
PO Box 339
Slippery Rock, PA 16057
888-245-3810
www.wildsidenorth.com

Tennessee
Tennessee Screen Supply
1709 Oakway Circle
Columbia, TN 38401
931-486-2072

Texas
Lees Screen Process Supply
10440 W. Airport Blvd
Stafford, TX 77477
800-447-8874
www.leessupply.com

Washington
Dimensional Products Corp.
1467 Elliot Ave. W.
Seattle, WA 98119
206-352-9065
www.Dimensionalproducts.com

Canada

Quebec
Graphic Textile Supply (GTS)
145 Barr Street, Unit 5
St-Laurent, Quebec
H4t 1W6
877-804-4657
www.graphictextilesupply.ca

Central America

El Salvador
Distinta
+503-2515-0900 Ext. 5

Guatemala
Distinta
+502-5519-0000

Honduras
Distinta
+504-2509-8041

Nicaragua
Distinta
+504-2509-8041

ECO Aqua Pura Series (Water-Based)
A "True Environmentally Friendly Ink"

Applications
-Direct Printing
-Light & Dark Colored Garments
-Cotton, Cotton/Polyester, Acrylic & 100% Polyester garments

Features
-Free From: PVC, Phthalates & APEO
-Conforms to EC guidelines
-Lowest dye migration properties on the market
-Soft feel
-Stretch properties over 300%
-Can be air-dried
-Cleans up with water

General Info:

The Eco Aqua system is a newly developed water-based polymer system that provides the printer with a broader range of curing temperatures. These inks require no heat to cure, giving the printer the option to air dry or use a low heat air assist method to speed up the drying process. The use of high heat is not recommended for these ink; therefore, making this series the most bleed resistant ink on the market. This system is PVC and Phthalate free, conforming to all EC guidelines for non-PVC and non-Phthalates in the production of textile screen printing inks. Eco Aqua Inks can be used as direct print inks or for color-matching Pantones®, based on our PIM matching system.

Mesh: 40-240

Stencil: Any water-resistant direct emulsion or capillary film.

Wet on Wet Printing: Depending on design, it may be best to dry after each color.

Screen Preparation: Screen must be wiped down with 69-0011 Eco Aqua Screen Prep Spray. This step is very important, it keeps the screen from choking.

Ink in screen: Requires large amounts of ink in screen.

Printing: Screen must be heavily flooded after each stroke to prevent choking.

Flashing: Use low temperature (160^0 F) with a lot of air volume.

Heat Assist: Set the oven temperature to 160^0 F with a lot of air volume. The printed area should be dry to the touch. Once dry to the touch, garments can be stacked and packaged.

Printing Procedures: Ink & screen should be misted with 66-0011 Prep Spray periodically, rate of misting depends on speed and temperature of printing conditions.

Break in Production: It is best to finish run before breaking, but if this is not possible then heavily flood the screen and spray heavily with 69-0111 Prep Spray.

Clean-up: Should be cleaned immediately after printing with soapy water. If screens can't be cleaned immediately after printing, the screens can be stored in a tank with water and a small amount of ammonia based cleaner for a short period of time.

Ink Ghosting: Any strong Dehaze will work.

ECO Aqua Pura Series (Water-Based)

A “True Environmentally Friendly Ink”

Basic Colors

Standard Colors:

(Refer to PIM Color-card for color reference)

69-0003	ECO Aqua Pura Foil Adhesive	69-3000	ECO Aqua Pura Lemon
69-0050	ECO Aqua Pura 4/C Process Cyan	69-3001	ECO Aqua Pura Gold
69-0060	ECO Aqua Pura 4/C Process Magenta	69-4000	ECO Aqua Pura Green
69-0070	ECO Aqua Pura 4/C Process Yellow	69-5000	ECO Aqua Pura Blue GS
69-0080	ECO Aqua Pura 4/C Process Black	69-5001	ECO Aqua Pura Marine
69-0011	ECO Aqua Pura Prep Spray	69-5500	ECO Aqua Pura Violet
69-1000	ECO Aqua Pura Clear	69-6000	ECO Aqua Pura Scarlet
69-1500	ECO Aqua Pura Printable Adhesive	69-6001	ECO Aqua Pura Red
69-2000	ECO Aqua Pura Black	69-9000	ECO Aqua Pura White

Enhance Additives (ENAD)

Part Number	Description	Effect
69-0000	Aqua Pura Reducer	Reduces Viscosity Add up to 20%
69-0011	Aqua Pura Screen Prep	Slows Drying Time
69-0013	Aqua Pura Retarder	Slows Drying Time Add 1 to 3%

Special Effects

Printing on White Fabrics	**Parts**
ECO Aqua Color	**40**
69-0000 ECO Aqua Pura Reducer	**20**
69-1000 ECO Aqua Pura Clear	**40**

Pultra Soft Colors for White Fabrics	**Parts**
ECO Aqua Color	**25**
69-0000 ECO Aqua Pura Reducer	**50**
69-1000 ECO Aqua Pura Clear	**25**

Metallic or Glitter Inks	**Parts**
69-1000 ECO Aqua Pura Clear	**45**
69-0003 ECO Aqua Pura Foil Adhesive	**40**
Metallic or Glitter Pigment for water inks	**25**

Transfer Printing

69-1500 ECO Aqua Pura Printable Adhesive
-Adhesive to be printed last

Stretch Fabrics

69-1000 ECO Aqua Pura Clear
-Print clear as underlay or seal coat on fabric

Gloss Top Coat

69-1000 ECO Aqua Pura Clear
-Print over desired area for high gloss effect

Flock Printing

69-0003 ECO Aqua Foil Adhesive
-Print an underlay, flash then print 2nd layer of adhesive
-Print flock on top of second layer before it dries

Non-Phthalate Plastisol Inks (Midori Series)

All Purpose (AP)

Applications

-Direct printing
-White or light colored garments
-100% Cotton garments
-Cotton/Polyester, Acrylic & Polyester garments (with LB underlay)

Features

-Low build-up
-Easily releases from the screen
-Very soft hand

General Info:

All Purpose (AP) inks are formulated to be directly printed onto white or light colored, 100% cotton garments. AP inks can also be used on dark colored garments if an underlay is used; this is the suggested method for dark colored shirts to achieve a soft hand.

Bleed Resistance: None

Opacity: Low to Medium

Storage: Ideally 65° to 80°F. Keep out of direct sunlight.

Mesh: 110-305 (43 to 120 threads per cm)

Stencil: Any direct emulsion or capillary film.

Wet on Wet Printing: Can be printed wet-on-wet to increase production.

Modifications: To reduce viscosity use Curable Reducer (I10-9906), improve stretch use G&S Base (I10-1020), puff use Puff Additive (I10-9903), extend color use Soft-hand Base (I10-0111) & for suede puff or dulling use Suede Additive (I10-9907).

Squeegee Hardness & Angle: Medium to hard at a 45 degree angle.

Flashing: 700ºF for 3-5 seconds, just enough for the surface to be tack free.

Squeegee Blade: Sharp.

Fusion/Curing: 325°F/163°C for 1 to 1 ½ minutes. Oven temperature can be increased and dwell time decreased. For heat presses use 390°F/195°C for 8 seconds.

Wash-up: Any plastisol cleaner.

Special Notes: PVC inks are thermoplastic compounds that require heat to fuse or cure. If ink rubs off on a white cloth or cracks, temperature and/or dwell time should be increased. Do not dry clean and always test on fabric to be printed.

Standard Colors:

(Refer to Standard Color-card for color reference)

JB-3125-AP	Dallas Gold
JB-3135-AP	Primrose
JB-3122-AP	Lemon
JB-3209-AP	Yellow Gold
JB-3303-AP	Gold
JB-7109-AP	Brite Orange
JB-6056-AP	Brite Red
JB-6420-AP	Scarlet
JB-6247-AP	Cardinal
JB-6251-AP	Maroon
JB-5525-AP	Violet
JW-5666-AP	Russell Purple
JB-5011-AP	Navy
JR-5332-AP	Lt Navy
JN-5001-AP	Royal
JB-5013-AP	Marine Blue
JW-5273-AP	Lt Royal
JB-5042-AP	Brite Royal
JB-5104-AP	Lt Reflex Blue
JB-5048-AP	Sky Blue
JB-5120-AP	Lt Blue
JB-5040-AP	Turquoise
JB-4030-AP	Dallas Green
JB-4053-AP	Kelly Green
JB-4238-AP	Forrest Green

Non-Phthalate Plastisol Inks (Midori Series)

High Opacity (HO)

Applications

-Direct printing
-Medium to dark colored garments
-100% Cotton garments
-Cotton/Polyester, Acrylic & Polyester garments (with LB underlay)

Features

-Low build-up
-Easily releases from the screen
-Very soft hand
-High opacity for great coverage

General Info:

High Opacity (HO) inks are formulated to be directly printed onto medium to dark colored, 100% cotton garments. These inks provide great coverage and have a creamy body unlike most High Opacity inks, therefore making the ease of printing more simple.

Bleed Resistance: None

Opacity: High

Storage: Ideally 65° to 80°F. Keep out of direct sunlight.

Mesh: 86-240 (34 to 110 threads per cm)

Stencil: Any direct emulsion or capillary film.

Wet on Wet Printing: Can be printed wet-on-wet to increase production.

Modifications: To reduce viscosity use Curable Reducer (I10-9906), improve stretch use G&S Base (I10-1020), puff use Puff Additive (I10-9903), extend color use Soft-hand Base (I10-0111) & for suede puff or dulling use Suede Additive (I10-9907).

Squeegee Hardness & Angle: Medium to hard at a 45 degree angle.

Flashing: 700°F for 9 seconds, just enough for the surface to be tack free.

Squeegee Blade: Sharp.

Fusion/Curing: 325°F/163°C for 1 to 1 ½ minutes. Oven temperature can be increased and dwell time decreased. For heat presses use 390°F/195°C for 8 seconds.

Wash-up: Any plastisol cleaner.

Special Notes: PVC inks are thermoplastic compounds that require heat to fuse or cure. If ink rubs off on a white cloth or cracks, temperature and/or dwell time should be increased. Do not dry clean and always test on fabric to be printed.

Standard Colors:

(Refer to Standard Color-card for color reference)

JB-7109-HO	HO Brite Orange	JB-4053-HO	HO Kelly Green
JB-6056-HO	HO Brite Red	JW-6008-HO	HO Drake Red
JB-5013-HO	HO Marine Blue	I-11-8520	HO Fls Lemon
JB-5042-HO	HO Brite Royal	I-11-8536	HO Fls Yellow
JB-5048-HO	HO Sky Blue	I-11-8515	HO Fls Magenta
JB-5120-HO	HO Lt Blue	I-11-8534	HO Fls Pink
JB-5040-HO	HO Turquoise	I-11-8530	HO Fls Red
JB-2250-HO	HO Lt Gray	I-11-8532	HO Fls Green
JB-2065-HO	HO Dk Brown	I-11-8531	HO Fls Blue
JB-2050-HO	HO Lt Brown	I-11-8533	HO Fls Violet
JB-4030-HO	HO Dallas Green		

Non-Phthalate Plastisol Inks (Midori Series)

Low Bleed (LB)/Poly

Applications

-Direct printing
-Medium to dark colored garments
-Cotton/polyester, 100% polyester & Nylon garments

Features

-Great body
-Made with non-migrating pigments
-Maintains viscosity during runs
-High opacity for great coverage

General Info:

Low Bleed (LB) inks are formulated to be directly printed onto medium to dark colored, cotton/polyester blends,100% polyester & nylon garments. These inks provide great coverage and have a creamy body unlike most bleed resistant inks, therefore making the ease of printing more simple. Please note that tightly woven nylon garments will require a nylon additive for adhesion.

Bleed Resistance: Great

Opacity: High

Storage: Ideally 65˚ to 80˚F. Keep out of direct sunlight.

Mesh: 86-160 (34 to 62 threads per cm)

Stencil: Any direct emulsion or capillary film.

Wet on Wet Printing: Can be printed wet-on-wet to increase production.

Modifications: To reduce viscosity use Curable Reducer (I10-9906), improve stretch use G&S Base (I10-1020), puff use Puff Additive (I10-9903), extend color use Soft-hand Base (I10-0111) & for suede puff or dulling use Suede Additive (I10-9907).

Squeegee Hardness & Angle: Medium to hard at a 45 degree angle.

Flashing: 700˚F for 9 seconds, just enough so the surface is tack free.

Squeegee Blade: Sharp.

Fusion/Curing: 325˚F/163˚C for 1 to 1 ½ minutes. Oven temperature can be increased and dwell time decreased. For heat presses use 390˚F/195˚C for 8 seconds.

Wash-up: Any plastisol cleaner.

Special Notes: PVC inks are thermoplastic compounds that require heat to fuse or cure. If ink rubs off on a white cloth or cracks, temperature and/or dwell time should be increased. Do not dry clean and always test on fabric to be printed.

Standard Colors:

(Refer to Standard Color-card for color reference)

I-10-3014	Poly Primrose	JW-3040-LB	Poly Vegas Gold
I-10-3002	Poly Lemon	JB-2250-LB	Poly Gray
I-10-3006	Poly Yellow Gold	JR-5332-LB	Poly Lt Navy
I-10-3001	Poly Lt Gold	JN-5001-LB	Poly Royal
I-10-3372	Poly Gold	JW-5666-LB	Poly Purple
I-11-6438	Poly Scarlet	JB-6247-LB	Poly Cardinal
JB-6056-LB	Poly Brite Red	JB-6251-LB	Poly Maroon
JB-5048-LB	Poly Sky Blue	JB-2050-LB	Poly Lt Brown
JB-4053-LB	Poly Kelly Green	JB-7096-LB	Poly Orange

Non-Phthalate Plastisol Inks (Midori Series)

Poly White I-10-9589

Applications

-Direct printing
-Medium to dark colored garments
-Cotton/polyester & 100% polyester

Features

-Great body
-Fast flashing
-Super bright
-Outstanding opacity for great coverage
-Extreme bleed resistant

General Info:

Poly White is our premium, high-opaque, low-bleed white formulated to reduce dye migration on 100% polyester garments. This white provides the highest bleed resistance and outstanding coverage of all of our whites, while maintaining a soft body that makes it extremely easy to print compared to most other whites manufactured to this day.

Bleed Resistance: Extreme

Opacity: Extreme

Storage: Ideally 65° to 80°F. Keep out of direct sunlight.

Mesh: 86-260

Stencil: Any direct emulsion or capillary film.

Wet on Wet Printing: Can be printed wet-on-wet to increase production.

Modifications: To reduce viscosity use Curable Reducer (I10-9906), improve stretch use G&S Base (I10-1020), puff use Puff Additive (I10-9903), extend color use Soft-hand Base (I10-0111) & for suede puff or dulling use Suede Additive (I10-9907).

Squeegee Hardness & Angle: Medium to hard at a 45 degree angle.

Flashing: 700°F for 2 seconds, just enough so the surface is tack free.

Squeegee Blade: Sharp.

Fusion/Curing: 325°F/175°C for 1 to 1 ½ minutes. Oven temperature can be increased and dwell time decreased. For heat presses use 390°F/195°C for 8 seconds.

Wash-up: Any plastisol cleaner.

Special Notes: PVC inks are thermoplastic compounds that require heat to fuse or cure. If ink rubs off on a white cloth or cracks, temperature and/or dwell time should be increased. Do not dry clean and always test on fabric to be printed.

Non-Phthalate Plastisol Inks (Midori Series)

Ultimate White I-10-9568

Applications

-Direct printing
-Light, Medium & dark colored garments
-Cotton/polyester & 100% polyester

Features

-Great body
-Fast flashing
-Super bright
-High opacity for great coverage
-Great bleed resistance

General Info:

Ultimate White is our top selling, high-opaque, low-bleed white. It was formulated to be extremely bright and provide the ultimate ease of printing through mesh counts up to 300, while at the same time providing unmatched bleed resistance and body characteristics that other manufactures have failed to duplicate.

Bleed Resistance: Great

Opacity: High

Storage: Ideally 65° to 80°F. Keep out of direct sunlight.

Mesh: 86-300

Stencil: Any direct emulsion or capillary film.

Wet on Wet Printing: Can be printed wet-on-wet to increase production.

Modifications: To reduce viscosity use Curable Reducer (I10-9906), improve stretch use G&S Base (I10-1020), puff use Puff Additive (I10-9903), extend color use Soft-hand Base (I10-0111) & for suede puff or dulling use Suede Additive (I10-9907).

Squeegee Hardness & Angle: Medium to hard at a 45 degree angle.

Flashing: 700°F for 2 seconds, just enough so the surface is tack free.

Squeegee Blade: Sharp.

Fusion/Curing: 325°F/175°C for 1 to 1 ½ minutes. Oven temperature can be increased and dwell time decreased. For heat presses use 390°F/195°C for 8 seconds.

Wash-up: Any plastisol cleaner.

Special Notes: PVC inks are thermoplastic compounds that require heat to fuse or cure. If ink rubs off on a white cloth or cracks, temperature and/or dwell time should be increased. Do not dry clean and always test on fabric to be printed.

Non-Phthalate Plastisol Inks (Midori Series)

Brite White I-10-9521

Applications

-Direct printing
-Light, Medium & dark colored garments
-Cotton/polyester blends

Features

-Great body
-Fast flashing
-Super bright
-Good opacity for coverage
-Good bleed resistance

General Info:

Brite White is our economical, general purpose white that provides good coverage and some bleed resistance on those pesky cotton/polyester blends. Even though this white is categorized as economical, its soft body still allows it to be printed as easily as our premium whites.

Bleed Resistance: Good

Opacity: High

Storage: Ideally 65° to 80°F. Keep out of direct sunlight.

Mesh: 86-300

Stencil: Any direct emulsion or capillary film.

Wet on Wet Printing: Can be printed wet-on-wet to increase production.

Modifications: To reduce viscosity use Curable Reducer (I10-9906), improve stretch use G&S Base (I10-1020), puff use Puff Additive (I10-9903), extend color use Soft-hand Base (I10-0111) & for suede puff or dulling use Suede Additive (I10-9907).

Squeegee Hardness & Angle: Medium to hard at a 45 degree angle.

Flashing: 700°F for 3 seconds, just enough so the surface is tack free.

Squeegee Blade: Sharp.

Fusion/Curing: 325°F/175°C for 1 to 1 ½ minutes. Oven temperature can be increased and dwell time decreased. For heat presses use 390°F/195°C for 8 seconds.

Wash-up: Any plastisol cleaner.

Special Notes: PVC inks are thermoplastic compounds that require heat to fuse or cure. If ink rubs off on a white cloth or cracks, temperature and/or dwell time should be increased. Do not dry clean and always test on fabric to be printed.

Non-Phthalate Plastisol Inks (Midori Series)

Sun White I-10-9501

Applications

-Direct printing
-Light, Medium & dark colored garments
-Cotton

Features

-Creamy body
-Fast flashing
-Bright
-Excellent printability
-Soft hand

General Info:

Sun White is our premium cotton white, formulated for the printers who require the best cotton white on the market. The combination of opacity and ease of printing makes this white stand above all other cotton whites in today's industry.

Bleed Resistance: None

Opacity: High

Storage: Ideally 65° to 80°F. Keep out of direct sunlight.

Mesh: 86-280

Stencil: Any direct emulsion or capillary film

Wet on Wet Printing: Can be printed wet-on-wet to increase production.

Modifications: To reduce viscosity use Curable Reducer (I10-9906), improve stretch use G&S Base (I10-1020), puff use Puff Additive (I10-9903), extend color use Soft-hand Base (I10-0111) & for suede puff or dulling use Suede Additive (I10-9907).

Squeegee Hardness & Angle: Medium to hard at a 45 degree angle.

Flashing: 700°F for 6 seconds, just enough so the surface is tack free.

Squeegee Blade: Sharp.

Fusion/Curing: 325°F/160°C for 1 to 1 ½ minutes. Oven temperature can be increased and dwell time decreased. For heat presses use 390°F/195°C for 8 seconds.

Wash-up: Any plastisol cleaner.

Special Notes: PVC inks are thermoplastic compounds that require heat to fuse or cure. If ink rubs off on a white cloth or cracks, temperature and/or dwell time should be increased. Do not dry clean and always test on fabric to be printed.

Non-Phthalate Plastisol Inks (Midori Series)

Black Cream I10-2280

Applications

-Direct printing
-Light to dark colored garments
-Cotton, cotton blends & polyester

Features

-Creamy body
-Soft hand
-Excellent printability
-No build-up

General Info:

Black Cream is a premium high performance black ink that is formulated with a super creamy texture that will not water down like most blacks. This black has the softest hand and highest mat down properties of all our blacks.

Bleed Resistance: None

Opacity: High

Storage: Ideally 65° to 80°F. Keep out of direct sunlight.

Mesh: 86-300

Stencil: Any direct emulsion or capillary film.

Wet on Wet Printing: Can be printed wet-on-wet to increase production.

Modifications: To reduce viscosity use Curable Reducer (I10-9906), improve stretch use G&S Base (I10-1020), puff use Puff Additive (I10-9903), extend color use Soft-hand Base (I10-0111) & for suede puff or dulling use Suede Additive (I10-9907).

Squeegee Hardness & Angle: Medium to hard at a 45 degree angle.

Flashing: 700°F for 8 seconds, just enough so the surface is tack free.

Squeegee Blade: Sharp.

Fusion/Curing: 325°F/160°C for 1 to 1 ½ minutes. Oven temperature can be increased and dwell time decreased. For heat presses use 390°F/195°C for 8 seconds.

Wash-up: Any plastisol cleaner.

Special Notes: PVC inks are thermoplastic compounds that require heat to fuse or cure. If ink rubs off on a white cloth or cracks, temperature and/or dwell time should be increased. Do not dry clean and always test on fabric to be printed.

Non-Phthalate Plastisol Inks (Midori Series)
Spec Black I10-2001

Applications
-Direct printing
-Light to dark colored garments
-Cotton, cotton blends & polyester

Features
-Smooth body
-Great coverage
-Clears well
-No build-up

General Info:
Spec Black is our intermediate black that contains a soft creamy body, though not as creamy as our Black Cream.This black is very popular with manual and automatic printers.

Bleed Resistance: None

Opacity: High

Storage: Ideally 65° to 80°F. Keep out of direct sunlight.

Mesh: 86-300 (Ideal 160)

Stencil: Any direct emulsion or capillary film.

Wet on Wet Printing: Can be printed wet-on-wet to increase production.

Modifications: To reduce viscosity use Curable Reducer (I10-9906), improve stretch use G&SBase (I10-1020), puff use Puff Additive (I10-9903), extend color use Soft-hand Base (I10-0111) & for suede puff or dulling use Suede Additive (I10-9907).

Squeegee Hardness & Angle: Medium to hard at a 45 degree angle.

Flashing: 700°F for 8 seconds, just enough so the surface is tack free.

Squeegee Blade: Sharp.

Fusion/Curing: 325°F/160°C for 1 to 1 ½ minutes. Oven temperature can be increased and dwell time decreased. For heat presses use 390°F/195°C for 8 seconds.

Wash-up: Any plastisol cleaner.

Special Notes: PVC inks are thermoplastic compounds that require heat to fuse or cure. If ink rubs off on a white cloth or cracks, temperature and/or dwell time should be increased. Do not dry clean and always test on fabric to be printed.

Non-Phthalate Plastisol Inks (Midori Series)
Majestic Black I-10-2195

Applications
-Direct printing
-Light to dark colored garments
-Cotton, cotton blends & polyester

Features
-Smooth body
-Great coverage
-Clears well
-No build-up

General Info:
Majestic Black is our economical black that works great for manual or automatic printers. This particular black holds good edge definition while providing a soft hand. Though the body of this black is slightly stiffer than our higher quality blacks, it still prints just as easily.

Bleed Resistance: None

Opacity: High

Storage: Ideally 65° to 80°F. Keep out of direct sunlight.

Mesh: 86-300 (Ideal 160)

Stencil: Any direct emulsion or capillary film.

Wet on Wet Printing: Can be printed wet-on-wet to increase production.

Modifications: To reduce viscosity use Curable Reducer (I10-9906), improve stretch use G&S Base (I10-1020), puff use Puff Additive (I10-9903), extend color use Soft-hand Base (I10-0111) & for suede puff or dulling use Suede Additive (I10-9907).

Squeegee Hardness & Angle: Medium to hard at a 45 degree angle.

Flashing: 700°F for 8 seconds, just enough so the surface is tack free.

Squeegee Blade: Sharp.

Fusion/Curing: 325°F/160°C for 1 to 1 ½ minutes. Oven temperature can be increased and dwell time decreased. For heat presses use 390°F/195°C for 8 seconds.

Wash-up: Any plastisol cleaner.

Special Notes: PVC inks are thermoplastic compounds that require heat to fuse or cure. If ink rubs off on a white cloth or cracks, temperature and/or dwell time should be increased. Do not dry clean and always test on fabric to be printed.

Non-Phthalate Plastisol Inks (Midori System)

Printer's Ink Matching System (PIM)

Applications

-Black, colored or white garments
-For accurate color matching
-Cotton
-Cotton/Polyester, Acrylic & Polyester garments (with LB underlay)

Features

-Extremely opaque
-PANTONE® approved
-Low build-up
-Intense color

General Info:

The W.M. Plastics "PIM" system consists of 17 colors, including fluorescents, that can be used to match PANTONE® colors or as direct print inks. All colors have great wet-on-wet print properties and contain a creamy body making them easy to print with. All colors are evaluated by our stringent QC process to ensure the colors are consistent from one batch to the next so your PANTONES® match every time.

Bleed Resistance: None

Opacity: High

Storage: Ideally 65° to 80°F. Keep out of direct sunlight.

Mesh: 86-305

Stencil: Any direct emulsion or capillary film.

Wet on Wet Printing: Can be printed wet-on-wet to increase production.

Modifications: To reduce viscosity use Curable Reducer (I10-9906), improve stretch use G&S Base (I10-1020)), extend color use Soft-hand Base (I10-0111) & for dulling use Suede Additive (I10-9907).

Squeegee Hardness & Angle: Medium to hard at a 45 degree angle.

Flashing: 700°F for 9 seconds, just enough so the surface is tack free.

Squeegee Blade: Sharp.

Fusion/Curing: 325°F/160°C for 1 to 1 ½ minutes. Oven temperature can be increased and dwell time decreased. For heat presses use 390°F/195ºC for 8 seconds.

Wash-up: Any plastisol cleaner.

Special Notes: PVC inks are thermoplastic compounds that require heat to fuse or cure. If ink rubs off on a white cloth or cracks, temperature and/or dwell time should be increased. Do not dry clean and always test on fabric to be printed.

Standard Colors:

(Refer to Standard Color-card for color reference)

I-65-3000	PIM Yellow	I-65-7000	PIM Orange
I-65-4000	PIM Green	I-65-9000	PIM White
I-65-5001	PIM Marine	I-65-8001	PIM Fls Pink
I-65-6001	PIM Red	I-65-8002	PIM Fls Magenta
I-65-6000	PIM Scarlet	I-65-8003	PIM Fls Yellow
I-65-3001	PIM Gold	I-65-8004	PIM Fls Purple
I-65-5000	PIM Blue	I-65-8005	PIM Fls Blue
I-65-5500	PIM Violet	I-65-8006	PIM Fls Orange
I-65-2000	PIM Black		

Non-Phthalate Plastisol Inks (Midori Series)

Bases & additives

General Info:

Bases and additives are designed to allow a printer to modify a standard ink to achieve a specific effect or characteristic.

Name	Effect	Color	Curable	Base/Additive	Max PC	To Achieve Effect
Soft Hand Base 10-0111	Softening viscosity & Hand	Transparent	Yes	Base	20%	10%
Opaque Base 12-1002	Mixing colors from PC	Filled	Yes	Base	28%	15%
G & S Base 10-1020	Stretch for lycra and gloss coatings Creates a super high gloss textured effect or wet effect for a clear gel top coating	Clear	Yes	Base	15%	Up to 50%
Gel clear 10-9910		Clear	Yes	Base	10%	Up to 50%
G & S Base 10-1020	Foil Printing / Foil Adhesive	Clear	Yes	Base	15%	Up to 50%
Puff Base 10-9950	Mixing puff colors from PC	Non pigment	Yes	Base	25%	15%
Suede Base 10-9958	Mixing puff suede color from pc	Non pigment	Yes	Base	20%	80%
Curable Reducer 10-9906	For reducing viscosity	Clear	Yes	Additive	15%	Up to 15%
Hot Split Base 41-1004	Mixing Hot Split color from PC	Opaque	Yes	Base	20%	80%
Nylon Additive YAL-200	Bond to nylon & similar fabrics	N/A	No	Additive	N/A	10 to 15%
Hotsplit Additive 10-9908	For making hotsplit inks	N/A	No	Additive	N/A	10%
Suede Additive 10-9907	Creates a soft velvet puff ink	N/A	No	Additive	N/A	10%
Puff Additive 10-9903	Creates a puff ink. Surface is rougher than a suede puff	N/A	No	Additive	N/A	10 to 15%
Powder Thickner 56-1002	Increases viscosity of inks.	N/A	No	Additive	N/A	Up to 2%
Dulling Additive 10-9907	Dulls the gloss of inks	N/A	No	Additive	N/A	Up to 5%

Special Effects

Flat High Density Color	**Parts**
Ink Color	**45**
I-10-1020	**45**
I-10-9910	**5**
I-56-1002	**1**
I-10-9958	**4**

Gloss High Density with Stretc	**Parts**
Ink Color	**49.5**
I-10-1020	**49.5**
I-56-1002	**1**

Stretch Inks	**Parts**
Ink Color	**70**
I10-9910/10-1020	**30**

Note: For maximum stretch, print I-10-9910 down first, flash, then print color on top

Non-Phthalate Plastisol Inks (Midori Series)

Lustre, Glitter & Metallic Inks

Applications

-Black, colored or white garments
-Unique effects
-Cotton
-Cotton/Polyester, Acrylic & Polyester garments (with LB underlay)

Features

-Easy to print
-Bright and outstanding effects
-Great coverage

General Info:

These inks are designed to stand out on garments by providing a unique appearance that will catch anyone's eye. Available in an array of colors and contains great opacity to cover the dark garments.

Bleed Resistance: None

Opacity: High

Storage: Ideally 65° to 80°F. Keep out of direct sunlight.

Mesh: Lustres 86, Glitters 40, Crystalina 40 & Metallics 110

Stencil: Any direct emulsion or capillary film.

Wet on Wet Printing: Can be printed wet-on-wet to increase production.

Modifications: To reduce viscosity use Curable Reducer (I10-9906), improve stretch use G&S Base (I10-1020), extend color use Soft-hand Base (I10-0111) & for dulling use Suede Additive (I10-9907).

Squeegee Hardness & Angle: Medium to hard at a 45 degree angle.

Squeegee Blade: Sharp.

Fusion/Curing: 325°F/160°C for 1 to 1 ½ minutes. Oven temperature can be increased and dwell time decreased. For heat presses use 390°F/195°C for 8 seconds. Because metallics and lustres reflect it may be necessary to increase temperature and dwell time.

Wash-up: Any plastisol cleaner.

Special Notes: PVC inks are thermoplastic compounds that require heat to fuse or cure. If ink rubs off on a white cloth or cracks, temperature and/or dwell time should be increased. Do not dry clean and always test on fabric to be printed.

Standard Colors:

I-10-1116	Lustre Silver
I-10-1115	Lustre Gold
I-10-1113	Lustre Copper
I-10-1107	Lustre Green
I-10-1105	Lustre Purple
I-10-1102	Glitter Gold
I-10-1103	Glitter Silver
I-10-1104	Glitter Crystalina
I-10-1100	Metallic (Handwash) Silver
I-10-1101	Metallic Gold

Note: I-10-1101 Metallic Gold will tarnished in the container over time, therefore it should be used immediately and ordered only as needed.

Non-Phthalate Plastisol Inks (Midori Series)

Glow-in-the Dark

Applications

-Direct printing
-White garments
-Cotton
-Cotton/Polyester, Acrylic & Polyester garments (with LB underlay)

Features

-Ready to use
-Extremely bright
-Long lasting
-Glows a brilliant green

General Info:

Great for novelty items. Our glow-in-the-dark ink has an extremely high pigment loading, compared to other manufactures, therefore providing a brighter and more long lasting glow. I-10-9965 is ready to print, but WM does offer the powder and base for sale so the printer can mix his own glow ink at any strength he wishes.

Bleed Resistance: None

Opacity: Medium

Storage: Ideally 65° to 80°F. Keep out of direct sunlight.

Mesh: 86-110

Stencil: Any direct emulsion or capillary film.

Wet on Wet Printing: Can be printed wet-on-wet to increase production.

Modifications: Reduce viscosity use Curable Reducer (I10-9906), improve stretch use G&S Base (I10-1020), puff use Puff Additive (I10-9903), extend color use Soft-hand Base (I10-0111) & for suede puff or dulling use Suede Additive (I10-9907).

Squeegee Hardness & Angle: Medium to hard at a 45 degree angle.

Flashing: 700°F for 9 seconds, just enough for the surface to be tack free.

Squeegee Blade: Sharp.

Fusion/Curing: 325°F/160°C for 1 to 1 ½ minutes. Oven temperature can be increased and dwell time decreased. For heat presses use 390°F/195°C for 8 seconds.

Wash-up: Any plastisol cleaner.

Special Notes: PVC inks are thermoplastic compounds that require heat to fuse or cure. If ink rubs off on a white cloth or cracks, temperature and/or dwell time should be increased. Do not dry clean and always test on fabric to be printed.

Non-Phthalate Plastisol Inks (Midori Series)

Hotsplits

Applications

-Black, colored or white garments
-Transfers
-Cotton
-Cotton/Polyester, Acrylic & Polyester garments (with LB underlay or if formulated as LB)

Features

-Easy to print
-Soft, creamy body
-Great coverage
-Wide range of colors

General Info:

Our hotsplit series is designed to achieve a direct print look with a soft hand and superior detail. Compared to conventional transfer inks, this series has a nice body making it easy to print.

Bleed Resistance: Low

Opacity: High

Storage: Ideally 65˚ to 80˚F. Keep out of direct sunlight.

Mesh: Light color garment 100-195, Dark color garment 60-86

Stencil: Any direct emulsion or capillary film.

Paper: Must use hotsplit transfer paper. Always pre-shrink the paper by running it through the dryer prior to printing.

Modifications: To reduce viscosity use Curable Reducer (I10-9906), improve stretch use G&S Base (I10-1020), extend color use Soft-hand Base (I10-0111).

Squeegee Hardness & Angle: Medium to hard at a 45 degree angle.

Squeegee Blade: Sharp.

Fusion/Curing: 210ºF for 30 seconds in dryer, then transfer onto garment at 360F at 40 psi for 8 seconds. Each color is printed then cured.

Print Order: Print colors in reverse order (last color first).

Wash-up: Any plastisol cleaner.

Special Notes: PVC inks are thermoplastic compounds that require heat to fuse or cure. If ink rubs off on a white cloth or cracks, temperature and/or dwell time should be increased. Do not dry clean and always test on fabric to be printed.

Standard Colors:

(Most colors are represented on the standard color-card)

JB-9009	HS White	I-41-6003	HS Brite Red
I-41-2000	HS Black	I-41-6079	HS Scarlet
I-41-2001	HS Pantone 429	I-41-9003	HS Puff White
I-41-3006	HS Gold	I-41-1001	HS Neutral Base
I-41-3015	HS Yellow Gold	I-41-9005	HS Litho White
I-41-4038	HS Kelly Green	I-41-9910	HS Printable Adhesive
I-41-5002	HS Navy	ADT-8000	Transfer Powder
I-41-5054	HS Royal	I-10-9908	HS Additive

Non-Phthalate Plastisol Inks (Midori Series)

4-Color Process Inks

Applications

-Direct printing
-White garments
-Cotton
-Cotton/Polyester, Acrylic & Polyester garments (with LB underlay)

Features

-Ready to use
-Extra creamy body
-Brilliant colors

General Info:

4-Color Process inks were designed to allow the printer to achieve a multitude of colors within the color spectrum by using a minimal number of inks.

Bleed Resistance: None

Opacity: None

Storage: Ideally 65°to 80°F. Keep out of direct sunlight.

Mesh: 280 and up

Stencil: Any direct emulsion or capillary film.

Artwork: Separations are critical to the success of printing these inks.

Modifications: To reduce viscosity use Curable Reducer (I10-9906) & to extend color use Soft-hand Base (I10-0111).

Squeegee Hardness & Angle: Medium to hard at a 45 degree angle.

Flashing: Not recommended.

Squeegee Blade: Sharp.

Fusion/Curing: 325°F/160°C for 1 to 1 ½ minutes. Oven temperature can be increased and dwell time decreased. For heat presses use 390°F/195°C for 8 seconds.

Wash-up: Any plastisol cleaner.

Special Notes: PVC inks are thermoplastic compounds that require heat to fuse or cure. If ink rubs off on a white cloth or cracks, temperature and/or dwell time should be increased. Do not dry clean and always test on fabric to be printed.

Standard Colors:

I-10-8903	4/C Yellow	I-10-8906	4/C Magenta
I-10-8902	4/C Cyan	I-10-8902	4/C Black

Recommended Procedures for Process Colors

1:Set machine pressure just enough to achieve good coverage. Once set do not adjust pressure or it will alter the final shades

2: Print each of the four colors separately, preferably on the same type of fabric to be used for production. If each color appears strong and vibrant, proceed to the next step, if not, repeat step one.

3: Print Yellow and Magenta together and evaluate the resulting orange tones against the color key provided by the separator. If the oranges are too yellow add I-10-0111to the yellow to weaken the color strength. If the orange is too red, add the I-10-0111 to the magenta to weaken the color strength.

4: Print Magenta and Cyan together and evaluate the purple tone to the color key. If the purple is too blue add I-10-0111 to the Cyan. If the purple is too red add I-10-0111 to the Magenta. If the Magenta is adjusted in this stepyou must repeat step one.

5. Now print all colors together and evaluate the Black. If the Black is too strong add I-10-0111

6. Now print all colors, lightest to darkest, together and compare to the color key.

7. Once the color key has been matched production may begin. Keep the setup as stable as possible. Increasing or decreasing squeegee pressure or the number of strokes will change a color's value and alter the overall print.

Ink Values for Adobe Photoshope

Color	Y	X	Y
Cyan	5.7830	0.2362	0.2634
Magenta	9.1300	0.4994	0.3262
Yellow	70.0110	0.4681	0.4827
Cyan Yellow	9.1710	0.2647	0.4429
Magenta Yellow	11.3340	0.5097	0.3351
Cyan Magenta	4.6290	0.3148	0.3242
Cyan Magenta Yellow	5.6270	0.3110	0.3470
Black	4.1770	0.3102	0.3279
White	96.6640	0.3163	0.3361

Non-Phthalate Plastisol Inks (Midori Series)

Athletic Inks

Applications

-Athletic uniforms
-Mesh jerseys
-Lycra/Spandex

Features

-Extremely durable
-Glossy Finish
-Super Opaque
-Available in any color

General Info:

Formulated to provide an opaque, glossy and durable print for athletic applications. Great for printing large letters, numbers and designs on cotton & nylon mesh, that require a heavy ink deposit. This ink can also be printed onto Lycra/Spandex garments with the use of our I-10-1020 base/additive.

Bleed Resistance: None

Opacity: Excellent

Storage: Ideally 65° to 80°F. Keep out of direct sunlight.

Mesh: 86-110

Stencil: Any direct emulsion or capillary film.

Wet on Wet Printing: Can be printed wet-on-wet to increase production.

Modifications: To reduce viscosity use Curable Reducer (I10-9906), improve stretch use G&S Base (I10-1020) & extend color use Soft-hand Base (I10-0111)

Squeegee Hardness & Angle: Medium to hard at a 45 degree angle.

Flashing: 700°F for 9 seconds, just enough for the surface to be tack free.

Squeegee Blade: Sharp.

Fusion/Curing: 325°F/160°C for 1 to 1 ½ minutes. Oven temperature can be increased and dwell time decreased. For heat presses use 390°F/195°C for 8 seconds. Because athletic inks have a heavier ink deposit, it may be necessary to increase temperature and dwell time.

Wash-up: Any plastisol cleaner.

Special Notes: PVC inks are thermoplastic compounds that require heat to fuse or cure. If ink rubs off on a white cloth or cracks, temperature and/or dwell time should be increased. Do not dry clean and always test on fabric to be printed.

Non-Phthalate Plastisol Inks (Midori Series)

Direct Print Reflective Ink

Applications

-E.M.S uniforms
-Novelty garments
-100% cotton

Features

-Excellent print & wash properties
-Ready to print
-Available as a base, Silver or Gold

General Info:

Designed as a ready-to-use ink that reflects with most light sources. This series has a very smooth body allowing it to easily release from the screen unlike most other reflective inks. This product is great for construction crews, fire departments or any niche market that needs a print that reflects when exposed to light.

Bleed Resistance: None

Opacity: Low

Storage: Ideally 65° to 80°F. Keep out of direct sunlight.

Mesh: 86

Stencil: Any direct emulsion or capillary film.

Wet on Wet Printing: Should be printed wet-on-wet.

Modifications: To reduce viscosity use Curable Reducer (I10-9906).

Squeegee Hardness & Angle: Medium to hard at a 45 degree angle.

Flashing: DO NOT FLASH

Squeegee Blade: Sharp.

Fusion/Curing: 325°F/160°C for 1 to 1 ½ minutes. Oven temperature can be increased and dwell time decreased. For heat presses use 390°F/195°C for 8 seconds.

Wash-up: Any plastisol cleaner.

Special Notes: PVC inks are thermoplastic compounds that require heat to fuse or cure. If ink rubs off on a white cloth or cracks, temperature and/or dwell time should be increased. Do not dry clean and always test on fabric to be printed.

Standard Colors:

I-62-1010 Reflective Silver
I-62-1013 Reflective Base
I-62-1011 Reflective Gold

STANDARD COLORS

Dallas Gold
JB-3125-AP

Primrose
JB-3135-AP
10-3014LB

Lemon
JB-3122-AP
10-3002LB

Yellow Gold
JB-3209-AP
10-3006LB

Lt Gold
10-3001-LB

Gold
JB-3303-AP
10-3372-LB

Brite Orange
JB-7109-AP
JB-7109-HO

Brite Red
JB-6056-AP
JB-6056-HO
JB-6056-LB

Scarlet
JR-6420-AP
I-11-6438LB

Drake Red
JW-6008-HO

Cardinal
JB-6247-AP
JB-6247-LB

Maroon
JB-6251AP
JB-6251-LB

Violet
JB-5525-AP

Russell Purple
JW-5666-AP
JW-5666-LB

Navy
JB-5011-AP

Lt Navy
JR-5332-AP
JR-5332-LB

Royal
JN-5001-AP
JN-5001-LB

Marine Blue
JB-5013-AP
JB-5013-HO

Lt Royal
JW-5273-AP

Brite Royal
JB-5042-AP
JB-5042-HO

Lt Reflex Blue
JB-5104-AP

Sky Blue
JB-5048-AP
JB-5048-HO
JB-5048-LB

Lt Blue
JB-5120-AP
JB-5120-HO

Turquoise
JB-5040-AP
JB-5040-HO

Lt Gray
JB-2250-HO
JB-225O-L

Dk Brown
JB-2065-HO

Lt brown
JB-2050-HO
JB-2050-LB

Dallas Green
JB-4030-AP
JB-4030-HO

Kelly Green
JB-4053-AP
JB-4053-HO
JB-4053-LB

Forrest Green
JB-4238-AP

FLUORESCENTS

165C
JC-1650

200C
JC-2000

Lemon
11-8250-HO

Yellow
11-8536-HO

Orange
11-8535-HO

Yellow 4/C
10-8903

186C
JC-1860

162C
JC-1620

Magenta
11-8515-HO

Pink
11-8534-HO

Red
11-8530-HO

Cyan Blue 4/C
10-8902

187C
JC-1870

286C
JC-2860

Green
11-8532-HO

Blue
11-8531-HO

Violet
11-8533-HO

Magenta 4/C
10-8906

PIM COLOR CARD

Printers Ink Matching System

Pim Yellow 100% Pim White 0%	Pim Yellow 90% Pim White 10%	Pim Yellow 50% Pim White 50%	Pim Yellow 10% Pim White 90%	Pim Yellow 1% Pim White 99%
Pim Green 100% Pim White 0%	Pim Green 90% Pim White 10%	Pim Green 50% Pim White 50%	Pim Green 10% Pim White 90%	Pim Green 1% Pim White 99%
Pim Marine 100% Pim White 0%	Pim Marine 90% Pim White 10%	Pim Marine 50% Pim White 50%	Pim Marine 10% Pim White 90%	Pim Marine 1 % Pim White 99%
Pim Red 100% Pim White 0%	Pim Red 90% Pim White 10%	Pim Red 50% Pim White 50%	Pim Red 10% Pim White 90%	Pim Red 1% Pim White 99%
Pim Scarlet 100% Pim White 0%	Pim Scarlet 90% Pim White 10%	Pim Scarlet 50% Pim White 50%	Pim Scarlet 10% Pim White 90%	Pim Scarlet 1% Pim White 99%
Pim Gold 100% Pim White 0%	Pim Gold 90% Pim White 10%	Pim Gold 50% Pim White 50%	Pim Gold 10% Pim White 90%	Pim Gold 1% Pim White 99%
Pim Orange 100% Pim White 0%	Pim Orange 90% Pim White 10%	Pim Orange 50% Pim White 50%	Pim Orange 10% Pim White 90%	Pim Orange 1% Pim White 99%
Pim Blue 100% Pim White 0%	Pim Blue 90% Pim White 10%	Pim Blue 50% Pim White 50%	Pim Blue 10% Pim White 90%	Pim Blue 1% Pim White 99%
Pim Violet 100% Pim White 0%	Pim Violet 90% Pim White 10%	Pim Violet 50% Pim White 50%	Pim Violet 10% Pim White 90%	Pim Violet 1% Pim White 99%
Pim Black 100% Pim White 0%	Pim Black 90% Pim White 10%	Pim Black 50% Pim White 50%	Pim Black 10% Pim White 90%	Pim Black 1% Pim White 99%

Certificate of Compliance

This is to certify that W.M. Plastics screen inks are in compliance with Consumer Products Safety Act, Title 16, Part 1303 and Federal Hazardous Substance Act Part 16 regarding banning of lead content and certain phthalate plasticizers.

Embodied in these regulations is The Product Consumer Safety Act of 2008 (HR4040) regarding further stringent requirements regarding lead reduction in children's toys, and child care products. The federal regulations apply to toys and/or children care products that are placed in direct contact of the mouth. W.M. Plastics screen inks comply with the spirit of these regulations and are intended to be used in textile applications.

W.M. Plastics a screen ink were manufactured by W.M. Plastics in the United States and does not contain:

di-2-ethylhexyl phthalate (DEHP), CAS Registry number 117-81-7
di-butyl phthalate (DBP), CAS registry number 84-74-2
butyl benzyl phthalate (BBP) CAS registry number 85-68-7
di-iso decyl phthalate (DIDP) CAS registry number 68-515-49-1
di-iso nonyl phthalate (DINP) CAS number 28553-12-0
di-n-octyl phthalate (DnOP) CAS number 68-515-45-7

None of the screen printing inks contain nor were manufactured with class I or class II ozone depleting substances.

SGS

Test Report

No.2540089-CH01-R1 Date: October 14, 2011

W.M. Plastics, Inc
4237 Raleigh Street
Charlotte, NC 28213
United States

This report supersedes all previous documents bearing the test report number 2540089-CH01.

The following sample(s) was/were submitted and identified by/on behalf of the client as: Screen Inks
Color: Various
Sample/style #: 66; 68 Series Inks, Plus (3) unknowns

Sample Received Date: **9/30/2011**

Testing Period **10/11/2011 – 10/12/2011**

Test Requested : Please refer to the result summary.

Test Method & Results : Please refer to next page(s).

Result Summary :

Test Requested	Conclusion
CPSIA Section 101(f) – Lead in paint/similar surface coating materials	PASS
CPSIA Section 108 – Phthalates	PASS

Signed for and on behalf of SGS North America

Christina Crimi
Assistant Laboratory Manager, Chemistry Laboratory

Prepared By:

Veronica Marrero
Report Writer, Chemistry Laboratory

1) **Lead in paint/similar surface coating material**

Method: CPSC Test Method: CPSC-CH-E1003-09.1 'Standard Operating Procedure for Determining Lead (Pb) in Paint and Other Similar Surface Coatings' (or accredited test method)

Test item	1	2	3	Permissible Limit
Lead (Pb)	ND	ND	ND	0.009 %
Conclusion	**PASS**	**PASS**	**PASS**	---

Test item	4	5	Permissible Limit
Lead (Pb)	ND	ND	0.009 %
Conclusion	**PASS**	**PASS**	---

Sample Description :

1. 66 Series Black
2. 66 Series White
3. 66 Series HP2
4. 68 Series Base
5. 65/66 Series PIM

Note: 1. % = percentage by weight
2. 1% = 10000ppm (mg/kg)
3. ND = not detected
4. Method Detection Limit = 0.002 %

2) **Phthalates**

Method: With reference to CPSC-CH-C1001-09.3. Analysis was performed by Gas Chromatography / Mass Spectrometry.

Test item	1	2	3	Permissible Limit per component
Dibutyl Phthalate (DBP)	ND	ND	ND	0.1 %
Benzylbutyl Phthalate (BBP)	ND	ND	ND	0.1 %
Bis-(2-ethylhexyl) Phthalate (DEHP)	ND	ND	ND	0.1 %
Diisononyl Phthalate (DINP)	0.030 %	0.029 %	0.026 %	0.1 %
Di-n-octyl Phthalate (DNOP)	ND	ND	ND	0.1 %
Diisodecyl Phthalate (DIDP)	ND	ND	0.018 %	0.1 %
Conclusion	**PASS**	**PASS**	**PASS**	--

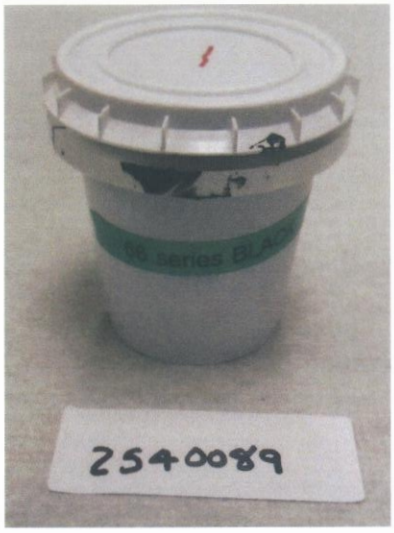
Test item	4	5	Permissible Limit per component
Dibutyl Phthalate (DBP)	ND	ND	0.1 %
Benzylbutyl Phthalate (BBP)	ND	ND	0.1 %
Bis-(2-ethylhexyl) Phthalate (DEHP)	ND	ND	0.1 %
Diisononyl Phthalate (DINP)	0.024 %	0.028 %	0.1 %
Di-n-octyl Phthalate (DNOP)	ND	ND	0.1 %
Diisodecyl Phthalate (DIDP)	ND	0.015 %	0.1 %
Conclusion	**PASS**	**PASS**	--

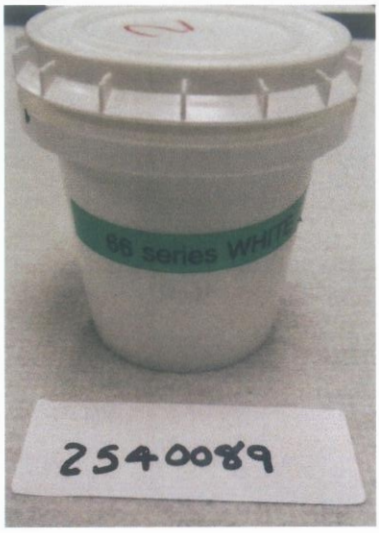
Sample Description :

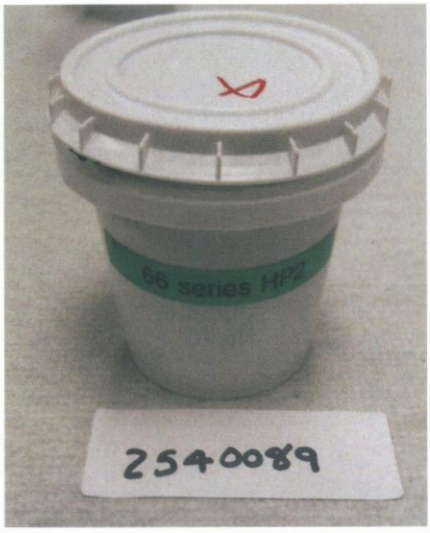
1. 66 Series Black
2. 66 Series White
3. 66 Series HP2
4. 68 Series Base
5. 65/66 Series PIM

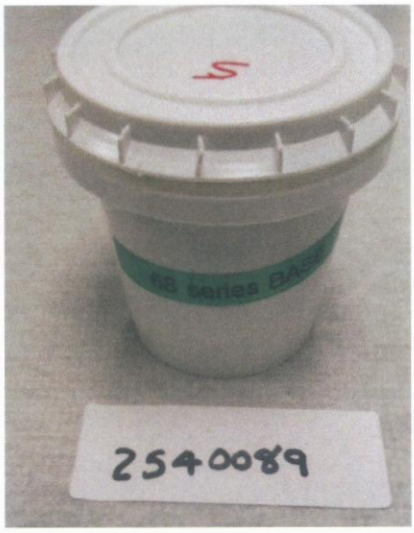
Note : 1. % = percentage by weight
2. ND = not detected
3. Method Detection Limit = 0.015 %

Sample Photo:









SGS authenticates the photo on the original report only

*** End of Report ***

Laboratory Summary Information for Certificate of Compliance (COC)

I (we) hereby confirm based on the test results in this report, that the product or components described below were tested and comply with the applicable rules, bans, regulations and standards under the CPSIA (Consumer Product Safety Improvement Act) or any other Act enforced by the CPSC and checked on the list below.

Product/Component description provided by submitter: Screen Inks
Color: Various
Sample/style #: 66; 68 Series Inks, Plus (3) unknowns

Safety Regulation Citations

☐ Wearing Apparel Flammability 16 CFR 1610
☐ Flammability Standard for Children's Sleepwear 16CFR 1615 and 1616
☐ Small Parts 16 C.F.R Part 1501 and 1500.50 - 53
☐ Sharp Points and Edges 16CFR 1500.48 and 49
☒ Lead Paint Ban 16 C.F.R. 1303
☐ Lead in substrate CPSIA Section 101
☐ Federal Hazardous Substances Act 15 U.S.C 1261
☒ Phthalates CPSIA Section 108
☐ Flammability of Carpets and Rugs (16 CFR1630 and1631)
☐ Flammability of Mattress Pads (16 CFR 1632)

Date of testing:

Date of TP testing: **10/11/2011 – 10/12/2011**

TPCA (Third Party Conformity Assessment Body):

Place of TP testing: USA

Test Report Number: 2540089-CH01-R1

TPCA name: SGS Consumer Testing Company

TPCA address: 291 Fairfield Ave., Fairfield, NJ 07004

TPCA Contact Person: Christina Crimi

The information on this sheet is ONLY applicable for the item tested in this report and only reflects confirmation of items covered under CPSIA regulation.

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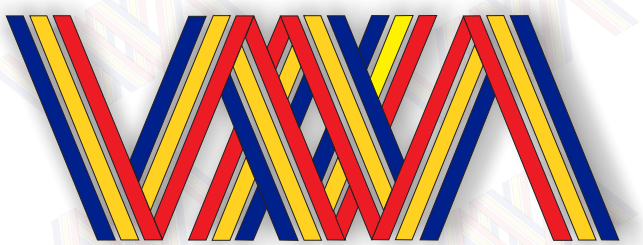

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