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## 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
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## General Info:

The W.M. Plastics "PIM" system consists of 18 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).

**Caution:** Modification of the inks could increase the gel point.

**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:** 270°F/132°C to 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-65-3000	PIM Lemon Yellow	I-65-7000	PIM Orange
I-65-4000	PIM Green (YS)	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 (GS)	I-65-8005	PIM Fls Blue
I-65-5500	PIM Violet	I-65-8006	PIM Fls Orange
I-65-2000	PIM Black	I-65-6002	PIM Magenta