



Originals #0005

## Wilflex Originals #005 Inspiration

Our first nPVC Original! Original #5 features Wilflex One, our nPVC, non-phthalate plastisol ink using both vector and halftone design work. The bright Cotton white uses a first down print-flash-print, along with a highlight white to emphasize the optically bright appearance. One stroke coverage on the colors produces a smooth, vivid print with minimal after flash tack.

## Print Sequence

Epic	Ink	Mesh (US/Metric)	New-tons	Stencil Dual Cure	Squeegee	Angle	Stroke
Step 1	Wilflex One Cotton White	195/77	45	15% EOM	65/90/65	15°	2
Step 2	Flash @ 225F/107C						
Step 3	Smoothing Screen	125/49					
Step 4	Wilflex One Cotton White	280/110	45	15% EOM	65/90/65	15°	2
Step 5	Flash @ 225F/107C						
Step 6	Smoothing Screen	125/49					
Step 7	Wilflex One PANTONE® CI Gray 10 C	280/110	45	15% EOM	75/90/75	15°	1
Step 8	Flash @ 225F/107C						
Step 9	Wilflex One Super Purple	280/110	45	15% EOM	75/90/75	15°	1
Step 10	Flash @ 225F/107C						
Step 11	Cool Down Station						
Step 12	Wilflex One Super Drake Red	280/110	45	15% EOM	75/90/75	15°	1
Step 13	Flash @ 225F/107C						
Step 14	Cool Down Station						
Step 15	Wilflex One Kelly Green	280/110	45	15% EOM	75/90/75	15°	1
Step 16	Flash @ 225F/107C						
Step 17	Cool Down Station						
Step 18	Wilflex One Light Royal	280/110	45	15% EOM	75/90/75	15°	1
Step 19	Flash @ 225F/107C						
Step 20	Cool Down Station						
Step 21	Wilflex One Yellow	280/110	45	15% EOM	75/90/75	15°	1
Step 22	Flash @ 225F/107C						
Step 23	Cool Down Station						
Step 24	Wilflex One Cotton White	280/110	45	15% EOM	75/90/75	15°	1

## Specifications

- Garment  
Garment: District® Young Mens The Concert Tee™ DT5000, Black, 4.3-ounce, 100% soft spun cotton
- Equipment  
M&R Gauntlet II, Habanero Flash
- Inks  
Wilflex Epic Inks- Cure 320F/160C

## Acknowledgements

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SanMar [www.sanmar.com](http://www.sanmar.com)  
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