



RIO MIX COLOR MIXING SYSTEM

WILFLEX™ Rio Mix is a low cure non-phthalate finished ink mixing system formulated for a perfect balance of color accuracy and opacity for peak press performance and color design. It is an easy-to-use color mixing system with 18 intermixable colors that enable printers to produce accurate PANTONE® simulations. RIO MIX is the most opaque color system in the line of Wilflex mixing color systems. Its opacity helps printers get to color quicker even when using fine mesh screens, saving ink and money.

HIGHLIGHTS

- ✓ Accurate and vibrant color match. PANTONE® approved
- ✓ Easy and accurate color mixing with finished inks that are balanced for viscosity
- ✓ Excellent color reproduction over base plates and white, light garments
- ✓ Wet-on-wet printing at high production speeds with good resistance to build-up
- ✓ Best color fastness to crocking test
- ✓ Matte finish

PRINTING TIPS

- ✓ Use consistent, high-tensioned screen mesh and sharp edged squeegees for best print results
- ✓ When blended according to formulations, colors are vibrant, accurate and opaque allowing printers to achieve color easier over a range of grounds and mesh counts
- ✓ Excellent color reproduction using 160-305 t/in (62-120 t/cm) mesh on white, light garments and over a base plate. Use finer mesh and save ink without sacrificing color accuracy. When direct printing over dark garments, print-flash-print using soft squeegee and lower mesh count
- ✓ RIO Mixing Colors is not a low-bleed ink; when printing on fabrics that are prone to bleed underbase with an approved WILFLEX low bleed white and/or blocker
- ✓ Exhibits good color retention in high-speed wet-on-wet production with minimal build up. Use fine mesh for best wet-on-wet printing
- ✓ Adjust flash cure temperature and dwell time so ink is just dry to touch. Depending on flash unit, a 2 - 3 second flash is adequate
- ✓ Curing is a time and temperature process, a lower oven temperature setting with a slower belt speed while maintaining recommended ink cure temperature is always best to protect fabric, control dye migration and reduce energy consumption
- ✓ RIO Colors can be cured between 266°F - 320°F (130°C - 160°C)
- ✓ Use ASI Finesse to extend the ink for blending colors in halftones or when garment colors allow ink opacity to be decreased. Suitable for use at 270°F (132°C)
- ✓ For cold-peel transfers, use a coated release paper or polyester film. Print colors using 70 duro squeegee and 110-230 t/in (43-91 t/cm) mesh followed by powdering. Gel at 212°F (100°C) for 60 sec. Apply transfer with heat press at 300°F (150°C) for 10-12 sec at medium pressure. For transfers on polyester, back with a low bleed white and/or blocker. Verify process.

COMPLIANCE

- ✓ Non-phthalate
- ✓ For individual compliance certifications and conformity statements, please visit:
www.avient.com/wilflex-compliance

SUSTAINABILITY



Reduced
Energy Use

PRECAUTIONS

The information above is given in good faith and does not release you from testing inks and fabrics to confirm suitability of substrate and application process to meet your customer standards and specifications

PRODUCT INFORMATION BULLETIN



RECOMMENDED PARAMETERS



Fabric Types

100% cotton, 100% polyester, triblends, polyester blends, cotton/poly blends, cotton/lycra blends



Mesh

Count: 110-305 t/in (43-120 t/cm)
Tension: 25-35 n/cm2



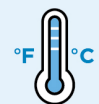
Squeegee

Durometer: 60/90/60, 70/90/70, 60-90
Profile: Square, Sharp
Stroke: Medium flood,
Medium-Fast stroke
Angle: 10-15%



Stencil

2 over 2
Off Contact: 1/16" (.2cm)
Emulsion Over Mesh: 15-20%



Flash & Cure

Flash: 220°F (105°C)
Cure: 266°F - 320°F (130°C - 160°C)



Pigment Loading



Wilflex™ Additives

ASI Viscosity Buster-1% max
ASI Finesse Base



Storage

65-90°F (18-32°C)
Avoid direct sunlight
Use within one year of receipt



Clean Up

Ink degradant or press wash



Health & Safety

Find SDS information here:
www.avient.com/resources/safety-data-sheets
or contact your local CSR



AVIENT
SPECIALTY
INKS

V3.22 (Modified: 08/26/2025)

2025, Avient Corporation. Avient makes no representations, guarantees, or warranties of any kind with respect to the information contained in this document about its accuracy, suitability for particular applications, or the results obtained or obtainable using the information. Some of the information arises from laboratory work with small-scale equipment which may not provide a reliable indication of performance or properties obtained or obtainable on larger-scale equipment. Values reported as "typical" or stated without a range do not state minimum or maximum properties; consult your sales representative for property ranges and min/max specifications. Processing conditions can cause material properties to shift from the values stated in the information. Avient makes no warranties or guarantees respecting suitability of either Avient's products or the information for your process or end-use application. You have the responsibility to conduct full-scale end-product performance testing to determine suitability in your application, and you assume all risk and liability arising from your use of the information and/or use or handling of any product. AVIENT MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, either with respect to the information or products reflected by the information. This literature shall NOT operate as permission, recommendation, or inducement to practice any patented invention without permission of the patent owner.