wilflex™

Printing Parameters

e Epic Standard Colors

Wilflex™ Epic Standard Color Inks are specifically formulated for high productivity wet-on-wet printing. Although most standard colors are opaque, optimum opacity is achieved with Epic Super Inks. Epic inks have excellent resistance to build-up and may also be used to print conventional cold-peel transfers.

Compliance

▸ Non-phthalate.

▸ Compliant with CPSIA 2008 (Consumer Product Safety Improvement Act) Section 101, Lead Content in Substrates (<100 ppm lead); 16 CFR, Part 1303, Lead in Paint (<90 ppm lead); and CPSIA 2008, Section 108, Phthalates (<.1% DEHP, DBP, BBP, DINP, DIDP, DNOP).

▸ Epic Series: Eco-Passport Certified (Oeko-Tex).

Highlights

▸ Satin finish.

▸ Printable creamy viscosity.

▸ Excellent flash properties.

▸ Build-up resistant for high productivity printing.

▸ Use to print direct onto fabric or for cold-peel transfers.

▸ Available in standard pre-mixed colors.

Printing Tips

▸ For one-hit opacity through coarse meshes, use a coating procedure that builds a thick, even stencil to ensure a good column height of ink.

▸ For bleed resistance, use an underbase white such as 11835PFW Epic Quick White, 11117PFW Epic Polywhite, or 11195PFW Epic Athletic LB White. For cotton fabrics, underbase with 11335PFW Epic Sprint White.

▸ For cold-peel transfers, use a coated release paper.

⚠ Precautions

▸ Perform fusion tests before production. Failure to cure ink properly may result in poor wash fastness, inferior adhesion and unacceptable durability. Ink gel and cure temperatures should be measured using a Thermoprobe placed directly in the wet ink film and verified on the production run substrate(s) and production equipment. It is the responsibility of the printer to determine that the correct ink has been selected for a specific substrate and the application processes meet your customer's standards or specifications.

▸ Wilflex inks have been carefully designed to perform within a given viscosity range. Any alteration of viscosity should be minimized.

▸ Avoid polyester fabrics where dye migration may occur.

▸ Avoid over flashing as it can result in poor intercoat adhesion of colors.

▸ Stir plastisols before printing.

▸ Do not dry clean, bleach or iron printed area.

▸ **NON-CONTAMINATION OF EPIC INKS:** Do not add or mix non-Epic inks, additives or extenders with the Epic ink products. All buckets, palette knives, stirring apparatus, squeegees, flood bars and screens must be cleaned properly and free of phthalates and pvc containing inks. Non-phthalate emulsions and pallet adhesives must be used.

▸ Any application not referred in this product bulletin should be pre-tested or consultation sought with Wilflex Technical Services Department prior to printing.
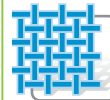
▸ Email: techserviceswilflex@polyone.com

Parameter	Value	
Opacity	8	|||||||
Bleed Resistance	-	
Smooth Surface	9	|||||||||
Flash	9	|||||||||
Gloss	4	||||
Printability	9	|||||||||

Fabric Types
100% cotton, cotton blends, polyesters, some nylon (generally open weave or mesh types), some synthetics
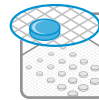
Mesh
Counts: 86-230 t/in (34-91 t/cm)
Tension: 25-35 n/cm²

Squeegee
Durometer: 60-80, 70/90, 70/90/70
Edge: Sharp
Stroke: Medium for opacity.
Fast for High Production.
Avoid excess squeegee pressure.

Non-Phthalate Stencil
Direct: 2 over 2
Capillary/Thick Film: 200-400 microns
Off-Contact: 1/16" (.2cm)

Gel/Cure Temperature
Gel Temp: 230°F (110°C)
Cure Temp: 320°F (160°C)

Pigment Loading
EQs: N/A
MX: N/A
PCs: N/A

Additives
Extender: Epic Extender Base-20% max
Reducer: Epic Viscosity Buster-3% max

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

Clean Up
Wilflex Screen Opener

Health & Safety
MSDS: www.polyone.com

EPIC STANDARD INKS :: Epic Standard GNS Inks :: 05.2012V1

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www.wilflex.com/pib