

## Epic Standard Inks

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.

### 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

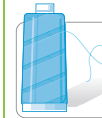
- ▶ For one-hit opacity through coarse meshes, use a coating procedure that builds a thick, even stencil to ensure a good column height of ink.
- ▶ For bleed resistance, use an underbase white such as 11835PFW Epic Quick White, 1117PFW Epic Polywhite, or 1195PFW Epic Athletic LB White. For cotton fabrics, underbase with 11335PFW Epic Sprint White.
- ▶ For cold-peel transfers, use a coated release paper.

### Compliance

- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit [www.wilflex.com/compliance](http://www.wilflex.com/compliance).

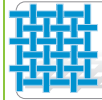
### Precautions

- ▶ Stir plastisols before printing.
- ▶ Do not dry clean, bleach or iron printed area.
- ▶ 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.
- ▶ **NON-CONTAMINATION OF EPIC INKS:** Do not mix EPIC inks with inks, additives or extenders from other companies. 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. Failure to follow these precautions may cause phthalate contamination in violation of consumer protection laws and regulations.
- ▶ Any application not referred in this product information bulletin should be pre-tested or consultation sought with Wilflex Technical Services Department prior to printing.
- ▶ Email: [techserviceswilflex@polyone.com](mailto:techserviceswilflex@polyone.com)



#### Fabric Types

100% cotton, cotton blends, polyesters, some nylon (generally open weave or mesh types), some synthetics



#### Mesh

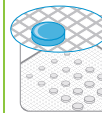
Counts: 86-230 t/in (34-91 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



#### Squeegee

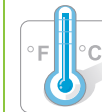
Durometer: 60-80, 70/90, 70/90/70  
Edge: Sharp  
Stroke: Medium for opacity./Fast for High Production.

*\*Do not use excess squeegee pressure.*



#### Non-Phthalate Stencil

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



#### Flash & Cure Temperatures

Flash: 230°F (110°C)  
Cure: 320°F (160°C)



#### Pigment Loading

EQ: N/A  
MX: N/A  
PC: N/A

*\*All percentages listed at % by weight.*



#### Epic Additives

Extender: Epic Extender Base-20% max  
Reducer: Epic Viscosity Buster-3% max  
*\*All percentages listed at % by weight.*



#### Shipping & Storage

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



#### Clean Up

Ink degradent or press wash.



#### Health & Safety

SDS: [www.polyone.com](http://www.polyone.com) or  
Contact your local CSR.