

**19000PFXNPF Epic NuPuff Black**  
**11000PFXNPF Epic NuPuff White**

Wilflex™ NuPuff inks are a plastisol puff ink formulated to provide raised textured effects. NuPuff has excellent durability and resistance to overblow.

**Highlights**

- ▶ Produces an elevated surface for specialty designs.
- ▶ NuPuff inks are available in a base and variety of colors.
- ▶ Excellent durability.
- ▶ Formulated to resist overblow.

**Printing Tips**

- ▶ Different effects may be achieved through the use of multiple passes, flash curing, thick screen stencils and overprinting standard and specialty inks.
- ▶ In multi-color printing, it is necessary to flash the puff prior to overprinting.
- ▶ If printing a large area, lightweight fabric may pucker. To alleviate puckering, print a mezzotint or dot pattern (an 80 percent solid).
- ▶ NuPuff is formulated with overblow protection so the possibility of collapse of the expanded ink is greatly reduced.

**Compliance**

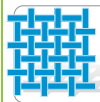
- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit [www.wilflex.com/compliance](http://www.wilflex.com/compliance).

**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.
- ▶ 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 Epic inks. 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)



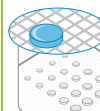
**Fabric Types**  
100% cotton, cotton blends



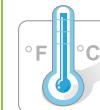
**Mesh**  
Counts: 61-110 t/in (24-43 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



**Squeegee**  
Durometer: 60-70  
Edge: Rounded  
Stroke: Medium  
*\*Do not use excess squeegee pressure.*



**Non-Phthalate Stencil**  
Direct: 2 over 2  
Capillary/Thick Film: N/A  
Off Contact: 1/16" (.2cm)



**Flash & Cure Temperatures**  
Flash: 290-330°F (140-165°C)  
Cure: 320°F (160°C)



**Pigment Loading**  
EQ: N/A  
MX: N/A  
PC: Use IMS System.  
*\*All percentages listed at % by weight.*



**Epic Additives**  
Extender: Epic Finesse may be used to lower puff height without reducing viscosity.  
Reducer: Epic Viscosity Buster-3% max  
*\*All percentages listed at % by weight.*



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