

## 10399PFXNB Epic Nova Base

Wilflex™ Epic Nova Base is a non-phthalate plastisol designed as a multi-purpose special effect ink for creating dry flake glitter effects and other specialty print surfaces. When mixed with a glitter particle flake, Epic Nova Base has the ability to penetrate the fabric and leave the glitter flake exposed and dry to touch. Epic Nova Base allows the glitter flake to retain its edge sharpness and brilliance when printed onto light and dark fabrics.

### Highlights

- ▶ Multi-purpose specialty base that creates textured surfaces when pigments, finished inks or particles are added.
- ▶ Base penetrates fabric, leaving glitter flake exposed and dry. Allows glitter to retain sharp edges, shine and clarity.
- ▶ Excellent wash properties. Glitter stays on the design!
- ▶ Most glitter flakes work well with Epic Nova Base.
- ▶ Prints easily through recommended meshes.

### Printing Tips

- ▶ When using glitter particle, it is recommended to use particle size .008" x .008".
- ▶ It is recommended to mix Epic Nova Base using 70-80% Nova Base and 20-30% glitter particle. Be sure to completely stir the glitter particle into the Epic Nova Base.
- ▶ To achieve the dry flake effect, print the Epic Nova Base and glitter mixture directly onto the fabric using the recommended meshes. To achieve a glossier look, print the ink onto a printed underlay.
- ▶ Use a heavy flood stroke and then light squeegee pressure to print Epic Nova Base and glitter particle ink onto the garment.
- ▶ Check the cure temperature at the ink surface.

### Compliance

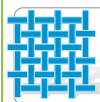
- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit [www.wilflex.com/compliance](http://www.wilflex.com/compliance).

### 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.
- ▶ Pretest all fabrics for dye migration.
- ▶ 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)



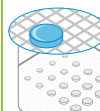
**Fabric Types**  
100% cotton, cotton blends, polyester



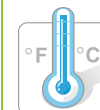
**Mesh**  
Counts: 24-38 t/in (9-15 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



**Squeegee**  
Durometer: 60/90/60  
Edge: Square, Sharp  
Stroke: Medium  
*\*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: 160°F (70°C)  
Cure: 320°F (160°C)



**Pigment Loading**  
EQ: 5% max  
MX: 5% max  
PC: 5% max  
*\*All percentages listed at % by weight.*



**Epic Additives**  
Extender: N/A  
Reducer: N/A  
*\*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.