

10400PFX EPIC Echo Soft Base

Wilflex™ Epic Echo Soft Base is a non-phthalate ink designed as a low viscosity plastisol base to simulate waterbase inks and produce an ultra soft hand feel. Epic Echo Soft Base has the ability to penetrate and become an integral part of the fabric.

Highlights

- ▶ Simulates waterbase finishes.
- ▶ Colors will reproduce best on white or light grounds.
- ▶ Can be printed over seams and stitched areas of finished apparel.
- ▶ Will not dry in the screen.
- ▶ Prints easily through recommended meshes.

Printing Tips

- ▶ Can be mixed with Epic PCs and Epic EQs to create custom colors. Add up to 10% by weight.
- ▶ Add opaque Epic inks to Epic Echo Soft Base to enhance ink opacity.
- ▶ Use a print stroke that allows the ink to fully penetrate the surface of the fabric. A single print stroke is recommended.

Compliance

- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit www.wilflex.com/compliance.

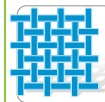
Precautions

- ▶ 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.
- ▶ Epic Echo Soft Base should not be used as a glitter carrier or adhesive base.
- ▶ 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



Fabric Types

100% cotton, cotton/poly blends, some synthetics



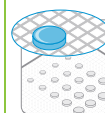
Mesh

Counts: 230-305 t/in (91-120 t/cm)
Tension: 25-35 n/cm²



Squeegee

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



Pigment Loading

EQ: 10% max
MX: 25% max
PC: 10% max
**All percentages listed at % by weight.*



Epic Additives

Extender: N/A
Reducer: Epic Viscosity Buster-1% 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 or
Contact your local CSR.