

## 10425PFXNS Epic Natural Suede Base

Wilflex™ Epic Natural Suede Base is a specially formulated plastisol ink that is non-phthalate. Epic Natural Suede Base can be used to produce a printed graphic with a soft, suede or velvet finish that is also highly durable. Epic Natural Suede can be combined with other Epic special effect bases to simulate leather or other textured surfaces.

### Highlights

- ▶ Can be used straight out of the container.
- ▶ Creates a printed graphic that feels like suede.
- ▶ Can be used on light or dark grounds.
- ▶ Excellent durability.
- ▶ Excellent wash properties.
- ▶ Odorless.
- ▶ Easily printed with both manual and automatic presses.

### Printing Tips

- ▶ Limit pigment loading to keep finished texture soft and fuzzy.
- ▶ Print through high density screens for raised surfaces.
- ▶ Use firm flood stroke and medium print stroke to maintain detail.
- ▶ Adjust cure temp and dwell time to achieve desired surface effect.
- ▶ Can be used alone or in combination with other Epic products to create various specialty effects.

### Compliance

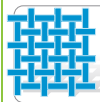
- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit [www.wilflex.com/compliance](http://www.wilflex.com/compliance).

### 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.
- ▶ Variable cure temperatures will affect the surface texture and feel of the suede ink.
- ▶ 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)



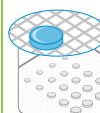
**Fabric Types**  
100% cotton, cotton blends



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



**Squeegee**  
Durometer: 60-75, 70/90/70  
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: 15% max  
MX: 25% max  
PC: 10% max  
*\*All percentages listed at % by weight.*



**Epic Additives**  
Extender: N/A  
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 degradant or press wash.



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