

## 10700PFXPB Epic Plush Base

Wilflex™ Epic Plush Base is a non-phthalate ink specially formulated to create soft fashion textures that simulate chenille, velvet, flock, suede and textured fabric finishes. Various textured and embossed surfaces can be produced by adjusting ink deposit and cure temperatures.

### Highlights

- ▶ Can produce multiple soft fashion textured finishes.
- ▶ Can be printed through flat screen meshes or high density films.
- ▶ Can be mixed with Epic PCs, Epic EQs, or Epic MX to create custom colors.

### Printing Tips

- ▶ Heavier deposits will produce superior dimensional textured images. Lower deposits will produce a softer finish.
- ▶ CHENILLE FORMULA: 85 gms Epic Plush Base + 15 gms Epic PC/MX/EQ color. Use flat 86 screen mesh or 86 screen mesh with 200 micron capillary film. Ink can be printed directly onto fabric or over an under-print. Print-flash-print only. Cure ink at 340°F (171°C) entire film.
- ▶ FLOCK FORMULA: 85 gms Epic Plush Base + 15 gms Epic PC/MX/EQ color. Use flat 156 screen mesh or 156 screen mesh with 150 micron capillary film. Ink can be printed directly onto fabric or over an under-print. Print-flash-print only. Cure ink at 340°F (171°C) entire film.
- ▶ SUEDE FORMULA: 85 gms Epic Plush Base + 15 gms Epic PC/MX/EQ color. Use flat 250 screen mesh, no capillary film. Ink can be printed directly onto fabric or over an underbase. Print-flash-print only. Cure ink at 340°F (171°C) entire film.

### Compliance

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

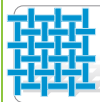
### Precautions

- ▶ 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.
- ▶ Some fabric dyes may cause ghosting effect if not properly tested. Pre-test on light colored or stone washed garments. Avoid stacking printed garments while hot because such colors are more prone to color distortion (ghosting). Fabric and dye characteristics can vary between manufacturers and dye lot.
- ▶ Excessive heat may result in undesirable effects such as flaking.
- ▶ 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, some synthetics



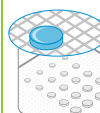
#### Mesh

Counts: 86-305 t/in (34-120 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



#### Squeegee

Durometer: 60-70, 70/90/70  
Edge: Square, Sharp  
Stroke: Medium-Fast  
*\*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: 25% max  
MX: 25% max  
PC: 5% 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 degradant or press wash.



#### Health & Safety

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