wilflex™

Product Information Bulletin

11000PFXOSN Epic One-Step Nylon White

Wilflex™ Epic One-Step Nylon is a specially formulated non-phthalate ink designed to print onto "untreated" nylon substrates. Standard plastisol ink processes can be used and ink will not dry in the screen or harden in the container. OSN inks flash quickly to allow efficient multi-ink printing.

Highlights

- Excellent for printing untreated nylon fabrics ranging from coarse deniers used in backpacks and luggage to finer deniers used in garments and umbrellas.
- High opacity.
- Can be used with or without the Hugger Catalyst.

Printing Tips

- Use consistent, high-tensioned screen mesh to optimize performance properties.
- One-Step Nylon inks should NOT be used on waterproofed satin jackets or when printing onto waterproofed nylon materials. If the nylon material has been treated to repel water, the waterproofing must be removed, and the addition of Epic Hugger Catalyst at 10% by weight will be necessary. Wipe down the print area with rubbing alcohol or acetone if printing on a tightly woven jacket material.

Compliance

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

Precautions

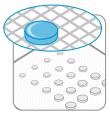
- Perform fusion tests before production. Failure to cure ink properly may result in poor wash fastness, inferior adhesion and unacceptable durability. Ink gel and cure temperatures should be measured using a Thermoprobe placed directly in the wet ink film and verified on the production run substrate(s) 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.
- Ink mixed with Epic Hugger Catalyst must be removed from the screen immediately following printing using cleaning solvents to prevent permanent mesh damage. Squeegees and any other printing apparatus must also be cleaned immediately.
- Epic Hugger Catalyst activates upon exposure to moisture in the air. The amount of moisture exposure determines the shelf life of the mixed ink. Pot life generally ranges from 4-8 hours.
- Maximum amount of Epic Hugger Catalyst is 10% by weight.
- The cross linking reaction between the catalyst and ink takes approximately 48-72 hours to fully bond to the fabric. Scratch testing should not be conducted immediately following printing.
- Open Epic Hugger Catalyst containers should be squeezed to push air out of the bottle and then sealed tightly. If left opened or loosely sealed, Epic Hugger Catalyst will solidify in the bottle.
- Hot cleaning solvents (containing Toluene, Xylene, and Acetone, etc.) will react with this ink causing hardening in the screen.
- 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

Recommended Parameters

Fabric Types
Untreated 100% nylon

Mesh
Counts: 86-230 t/in (34-91 t/cm)
Tension: 25-35 n/cm²

Squeegee
Durometer: 60-90
Edge: Straight Edge
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: 160°F (70°C)
Cure: 280°F (138°C)

Pigment Loading
EQ: N/A
MX: N/A
PC: N/A
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 or
Contact your local CSR.