

17600LBFF Epic Top Score LBFF Base

Wilflex™ Epic Top Score Base is a non-phthalate plastisol ink designed to meet the changing demands of the athletic market by delivering a solution for printing on polyester substrates that require low cure temperatures.

Highlights

- ▶ Low cure properties.
- ▶ Delivers high stretch and bleed resistance in one package.
- ▶ Matte finish.
- ▶ Low tack surface.
- ▶ Excellent printability.

Printing Tips

- ▶ For optimal bleed resistance, print Epic PolyWhite or Top Score White as underbase. Set the dryer belt at the highest possible speed while still ensuring that the ink film reaches 300°F (150°C). For optimal stretch, print Epic Performance White as underbase. Set the dryer belt at the highest possible speed while still ensuring that the ink film reaches 290°F (145°C).
- ▶ Building a thick ink deposit on the polyester substrate provides additional bleed blocking power. To accomplish this, use the following coating screen method with a wet-on-wet application: 1) Coat print side; 2) Coat squeegee side; 3) Coat print side; 4) Coat squeegee side. Always end coating on the squeegee side to push the emulsion to the print side. Dry screens with print side facing the floor.
- ▶ If printing on a hard metal surface, use a palette covering to allow for a softer printing surface.
- ▶ Polyester fabrics are likely to have dye migration issues and may require use of additional bleed blocker, such as Epic Performance Underbase Gray. To determine a material's bleed potential, please reference the testing procedures outlined in the Wilflex User's Manual.

Compliance

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

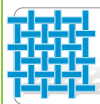
Precautions

- ▶ 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.
- ▶ 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.
- ▶ 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



Fabric Types

100% polyester, polyester blends, 100% nylon Jersey



Mesh

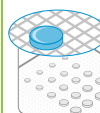
Counts: 86-158 t/in (34-62 t/cm)
Tension: 25-35 n/cm²



Squeegee

Durometer: 60-70
Edge: Square, Sharp
Stroke: Hard flood, Slow-Medium stroke

**Do not use excess squeegee pressure.*



Non-Phthalate Stencil

Direct: 2 over 2
Capillary/Thick Film: 30+ micron
Off Contact: 1/16" (.2cm)



Flash & Cure Temperatures

Flash: 160°F (70°C)
Cure: 290°F (140°C)



Pigment Loading

EQ: 35% max
MX: N/A
PC: 15% 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 or
Contact your local CSR.