

18600PFXPB Epic Performance Base

19000PFXPB Epic Performance Black

Wilflex™ Epic Performance inks are non-phthalate plastisol inks designed to print onto a variety of specialty fabrics, including performance athletic stretch polyester and polyester blended fabrics.



Highlights

- ▶ Excellent bleed resistance for polyester fabrics.
- ▶ Odorless.
- ▶ Wet-on-wet printing.
- ▶ Low cure, Fast flashing.
- ▶ Matte finish.
- ▶ Excellent elasticity.
- ▶ Excellent stretch properties.



Printing Tips

- ▶ Use consistent, high-tensioned screen mesh to optimize performance properties.
- ▶ To optimize bleed resistance, print Epic Performance Underbase Gray as underbase to block dye migration. Set the dryer belt at the highest possible speed while still ensuring that the ink film reaches 290°F (145°C). This ensures that the ink's heat exposure is minimal.
- ▶ Wilflex recommends Epic Pigment Concentrates (PCs) as Performance Ink colorants. Ink formulations using the PCs or other color variants should be thoroughly print and wash tested in alignment with fabric considerations before production application.
- ▶ To achieve optimal color opacity, print with Epic Performance White as underbase.
- ▶ To increase production speeds, use finer mesh counts for the flash plate to decrease gel time. Set flash dwell times on heated pallets to simulate production. Adjust your settings so that the ink is just dry to the touch.
- ▶ Polyester fabrics are likely to have dye migration issues. 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.



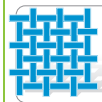
Precautions

- ▶ 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.
- ▶ Avoid over flashing as it can result in poor intercoat adhesion of colors.
- ▶ 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.
- ▶ Use of Equalizers are not recommended and may affect the bleed properties of the 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% polyester, polyester blends, 100% nylon Jersey, 100% cotton, cotton/poly blends, cotton/Lycra blends, spandex
*not suitable for all nylon substrates.
Pretest prior to production



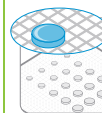
Mesh

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



Squeegee

Durometer: 60-70, 60/90/60
Edge: Square, Sharp
Stroke: Hard Flood, 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: 290°F (143°C)



Pigment Loading

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