wilflex™

Product Information Bulletin

# 19850PFX Epic Process Black
# 49850PFX Epic Process Magenta
# 69850PFX Epic Process Cyan
# 89850PFX Epic Process Yellow

**Wilflex™ Epic Process colors are designed to produce the cleanest, highest intensity colors for textile printing. These pure, transparent colors are designed for high productivity direct wet-on-wet printing with excellent resistance to build-up, superb printability, extremely soft hand and minimal dot gain.**

## Highlights

- Designed for printing on light colored fabric grounds.
- Can be printed on top of an appropriate underbase white, such as 11335PFW Epic Sprint White or 11835PFW Epic Quick White.

## Printing Tips

- Most effective when art is separated by experienced, specialized textile screen print process artist.
- Use consistent, high-tensioned screen mesh to optimize performance properties.

## Compliance

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

## Precautions

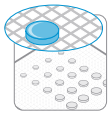
- Perform fusion tests before production. Failure to cure ink properly may result in poor wash fastness, inferior adhesion and unacceptable durability. Ink gel and cure temperatures should be measured using a Thermoprobe placed directly in the wet ink film and verified on the production run substrate(s) 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.
- Wilflex inks have been carefully designed to perform within a given viscosity range. Any alteration of viscosity should be minimized.
- 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**
100% cotton, cotton blends, all-white fabric grounds

**Mesh**
**Counts:** 305-355 t/in (120-140 t/cm)
**Tension:** 25-35 n/cm²

**Squeegee**
**Durometer:** 70/90, 70/90/70
**Edge:** Sharp
**Stroke:** 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:** 220°F (105°C)
**Cure:** 320°F (160°C)

**Pigment Loading**
**EQ:** N/A
**MX:** N/A
**PC:** N/A
***All percentages listed at % by weight.***

**Epic Additives**
**Extender:** Epic Halftone Base-20% max
**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.

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