wilflex™

Product Information Bulletin

11000LBFF Epic Top Score White

Wilflex™ Epic Top Score White is a high performance non-phthalate low bleed white ink designed to complement the Top Score pre-mix color palette. It meets the changing demands in the screen print market by delivering a solution for printing on polyester and synthetic substrates.

Highlights

- Excellent bleed resistance on substrates prone to dye migration.
- High Opacity, excellent coverage, good stretch.
- Low cure, fast flash with little tack.
- Odorless, bright white with matte finish.
- Easy to print on both auto and manual presses.

Printing Tips

- Disciplined control of oven temperature and avoiding excessive heat spikes should always be practiced. To optimize bleed resistance, set the dryer belt at the higher possible speed while still ensuring the ink film reaches 290°F (143°C).
- Adjust flash cure temperature and dwell time so ink is just dry to touch. Depending on flash unit, a 4-6 second flash should be adequate. If surface is hot and tacky, the ink film has been over flashed. Reduce temperature or time to prevent an inter-coat adhesion problem.
- Infrared dryers require extra precaution when there is no air flow and a short oven dwell time is present. The best solution for IR dryers is to balance dryer belt speed and temperature settings to provide the lowest amount of heat exposure that result in successfully cured prints.
- Top Score is a low bleed ink. For challenging fabrics using sublimation dyes, a bleed blocking underbase such as Epic Performance Underbase Gray or Epic Bleed Blocker Gray may be required.

Compliance

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

Precautions

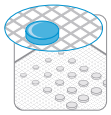
- Perform fusion tests before production. Failure to cure ink properly may result in poor wash fastness, inferior adhesion and unacceptable durability. Ink gel and cure temperatures should be measured using a Thermoprobe placed directly in the wet ink film and verified on the production run substrate(s) and production equipment.
- 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.
- Pretest all fabrics for dye migration.
- 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% polyesters, polyester blends

Mesh
Counts: 86-230 t/in (34-90t/cm)
Tension: 25-35 n/cm²

Squeegee
Durometer: 60-70, 60/90/60
Edge: Square, Sharp
Stroke: Hard flood, fast-stroke
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: 200-220°F (90°C-105°C)
Cure: 290°F (143°C) Entire film

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

Epic Additives
Extender: Not recommended
Reducer: Not recommended
All percentages listed at % by weight.

Shipping & 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
SDS: www.polyone.com or
Contact your local CSR.

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