

10005PFX Epic™ Stretch Base 11000PFS Epic™ Stretch White

Wilflex Epic™ Stretch Base is specially formulated to cure at lower temperatures than conventional plastisol inks. Epic™ Stretch Base will cure at temperatures low enough to prevent or substantially reduce shrinkage of heat-sensitive fabrics such as 100 % acrylic.

Highlights

- ▶ Non-phthalate.
- ▶ Compliant with CPSIA (Consumer Product Safety Improvement Act) 2008, Section 101, Lead Content in Substrates (<100 ppm lead); 16 CFR, Part 1303, Lead in Paint (<90 ppm lead); and CPSIA 2008, Section 108, Phthalates (<.1% DEHP, DBP, BBP, DINP, DIDP, DNOP).
- ▶ Eco-Passport Certified.
- ▶ Excellent durability and elongation.
- ▶ Highly stretchable.
- ▶ Excellent printability.
- ▶ Excellent wash properties.
- ▶ Ideal for high stretch and heat sensitive fabrics.
- ▶ Can be mixed with Epic™ MX, Epic™ EQs, and Epic™ PCs.



Printing Tips

- ▶ For best results follow the recommended printing parameters.
- ▶ Epic™ Stretch Base is 100 % solvent-free and cannot be air-dried.
- ▶ Use consistent, high tensioned screen mesh to optimize performance properties.

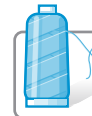


Precautions

- ▶ 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.
- ▶ Preprint and test 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 the Epic™ ink products.
 - ▶ All buckets, palette knives and stirring apparatus must be cleaned properly and free of phthalate containing inks. All squeegees, flood bars and screens must be cleaned properly to remove phthalate containing inks before printing Epic™.
 - ▶ Non-phthalate emulsions and pallet adhesives must be used.
- ▶ Any application not referred in this product bulletin should be pre-tested or consultation sought with Technical Services Department prior to printing.
- ▶ Email: techserviceswilflex@polyone.com

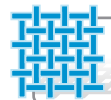
Printing Parameters

Opacity	6	
Bleed Resistance	n/a	
Smooth Surface	8	
Flash	6	
Gloss	9	
Printability	8	



Fabric Types

100% Cotton, cotton blends, acrylic, nylon, some synthetics



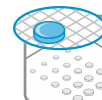
Mesh

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



Squeegee

Durometer: 75-85, 60/90/60
Edge: Sharp
Stroke: Medium
Avoid excess pressure



Stencil

non-phthalate
Direct: 2 over 2
Capillary/thick film: N/A
Off contact: 1/16" (.2 cm)



Gel/Cure Temperatures

Gel: 170-190 F (75-88 C)
Cure: 280 F (138 C) entire film
Transfer: 320 F (160 C) 10-15 sec
40-45 PSI
med. firm pressure



Epic Pigment Loading

MX: 2%
EQs: 5% max by weight
PCs: 5% max by weight



Additives

Extender: None
Reducer: 1% max. - 10025VB QEC
Viscosity Buster



Storage

65°-90°F (18°-32°C)
Avoid direct sun.
Use within one year of receipt.



Clean Up

Wilflex screen wash



Health & Safety

MSDS: www.polyone.com