wilflex™

Product Information Bulletin

10545PFX Epic™ Performance Underbase Gray

Wilflex Epic Performance Underbase Gray is a premium plastisol ink designed to prevent dye migration on 100% polyester, poly/synthetic blends, cotton/poly blends and 100% cotton fabrics containing highly migrating dyes such as camouflage.

Highlights

- Non-phthalate
- Compliant with CPSIA (Consumer Product Safety Improvement Act) 2008, Section 101, Lead Content in Substrates (<300 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).
- Epic Series - Eco-Passport Certified (OekoTex)
- High performance, bleed-resistant technology
- Works on a variety of fabrics
- Excellent elasticity, stretch
- Smooth surface
- Matte appearance
- Prints easily through recommended meshes

Printing Tips

- Print Performance Underbase Gray so that the flashed ink deposit fully covers the underlying fabric.
- Overprint with Epic Performance low-bleed inks, white and/or colors.
- Best results are achieved using recommended mesh counts.
- Use consistent, high-tension screens to optimize performance.
- Do not use excessive squeegee pressure.
- To optimize performance, minimize the fabric's exposure to heat. Adjust the dryer belt speed to highest setting while ensuring that entire ink film still reaches 290°F (143°C).

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 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.
- Due to difference in heat and moisture absorption rates between fabrics, the oven settings will require adjustments when switching from one fabric to another.
- To determine a fabric's bleed potential, please reference the testing procedures outlined in the Wilflex User's Manual.
- Stir inks before printing.
- Avoid over flashing as it can result in poor inter-coat adhesion of colors.
- Reducing viscosity will adversely affect opacity.
- 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, squeegees,flood bars and screens must be cleaned properly and free of phthalate containing inks.
  - Non-Phthalate emulsions and pallet adhesive must be used.
- Any application not referred in this product bulletin should be pre-tested or consultation sought with Wilflex Technical Services Department prior to printing.
- Email: techserviceswilflex@polyone.com

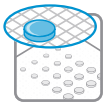
Printing Parameters

Opacity	9	▮▮▮▮▮▮▮▮▮
Bleed Resistance	9	▮▮▮▮▮▮▮▮▮
Smooth Surface	8	▮▮▮▮▮▮▮▮
Flash	7	▮▮▮▮▮▮▮
Gloss	5	▮▮▮▮▮
Printability	9	▮▮▮▮▮▮▮▮▮

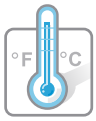
Fabric Types
100% polyester, polyester blends, 100% nylon jersey, 100% cotton, cotton/poly blends, cotton/lycra blends, spandex
**Not suitable for all nylon substrates. Pre-test prior to production.*

Mesh
Counts: 86 - 140t/in (34-60 t/cm)
Tension: 25-35 n/cm² recommended

Squeegee
Durometer: 70, 80
Edge: Square, sharp
Stroke: Medium speed, low- medium pressure



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



Gel/Cure Temperatures
Gel: 163°F (73°C)
Cure: 290°F (143°C) Entire Film

Pigment Loading
N/A

Additives
Extender: None
Reducer: Up to 1% (by weight) of 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

www.wilflex.com/pib

Wilflex Epic Performance Underbase Gray :: 05.2011

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