

## 10450PFXST Epic HD Soft Base 11000PFWST Epic HD Soft White

Wilflex™ Epic HD Soft inks are specifically formulated non-phthalate inks designed to produce a surface that is soft to the touch with high stretch and good durability. Epic HD Soft inks can be used in all types of printing applications including high, medium, and low density prints.

### Highlights

- ▶ Elevated soft texture for use with fashion design concepts.
- ▶ Excellent stretch properties.
- ▶ Good durability.
- ▶ Excellent adhesion to fabrics.
- ▶ Can be used on light or dark grounds.
- ▶ Can be printed through flat screen meshes or high density films.

### Printing Tips

- ▶ Can be mixed with Epic PCs, Epic EQs, or Epic MX to create custom colors. Add up to 10% by weight.
- ▶ Can be printed directly to garment or over an underbase. Best results when printed directly onto fabric.
- ▶ Use a print-flash-print method to build ink density.
- ▶ Changing ink cure temperature will affect surface texture and feel of the ink.
- ▶ A heavy flood stroke that fully fills the open areas of the stencil is recommended.

### Compliance

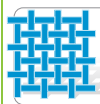
- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit [www.wilflex.com/compliance](http://www.wilflex.com/compliance).

### 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.
- ▶ Use an appropriate low-bleed underbase on polyester fabrics.
- ▶ Pretest all fabrics for dye migration. Avoid polyester fabrics where dye migration may occur.
- ▶ 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](mailto:techserviceswilflex@polyone.com)



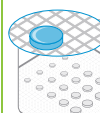
**Fabric Types**  
100% cotton, cotton blends, Lycra, denim



**Mesh**  
Counts: 61-230 t/in (24-91 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



**Squeegee**  
Durometer: 60-70, 60/90/60  
Edge: Square, Sharp  
Stroke: Medium  
*\*Do not use excess squeegee pressure.*



**Non-Phthalate Stencil**  
Direct: 2 over 2  
Capillary/Thick Film: 200- 400 microns  
Off Contact: 1/16" (.2cm)



**Flash & Cure Temperatures**  
Flash: 220°F (105°C)  
Cure: 320°F (160°C)



**Pigment Loading**  
EQ: 20% max  
MX: N/A  
PC: 20% max  
*\*All percentages listed at % by weight.*



**Epic Additives**  
Extender: N/A  
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](http://www.polyone.com) or  
Contact your local CSR.