

## 2200 EPIC™ Top Score LC White

Wilflex™ EPIC Top Score LC White is a high performance low bleed white ink aimed for polyester sports apparel and team sports number market. Use in combination with the Top Score pre-mix athletic colors for a solution to printing polyesters substrates that require low cure temperature.

### Highlights

- ▶ Excellent bleed resistance at a wide temperature range
- ▶ High Opacity, excellent coverage, improved stretch
- ▶ Low cure, save energy, reduce bleed defects
- ▶ Fast flashing, no after-flash tack
- ▶ Bright white with matte finish
- ▶ Easy to print on both auto and manual presses

### Printing Tips

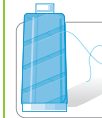
- ▶ Use a printing technique to assure a good ink deposit to maximize bleed resistance and stretch performance properties
- ▶ EPIC Top Score LC White is a low bleed ink. For challenging fabrics using sublimation dyes, a bleed blocking underbase such as EPIC Performance Underbase Gray or EPIC Echo Underbase Gray may be required
- ▶ Adjust flash cure temperature and dwell time so ink is just dry to touch. Avoid excessive flash temperatures to protect fabric and migration of dyes. Depending on flash unit, a 2 - 3 second flash is 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
- ▶ Curing is a time and temperature process, a lower oven temperature setting with a slower belt speed while maintaining recommended ink cure temperature is always best to protect fabric, control dye migration and reduce energy consumption
- ▶ EPIC Top Score LC White can be cured between 260°F - 320°F (127°C - 160°C). Running at the higher end of the temperature range and/or longer dwell times maybe required to achieve proper cure on jobs that contain cotton, high ink deposits or heavy weight garments.

### Compliance

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

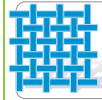
### Precautions

- ▶ Stir plastisols before printing.
- ▶ Do not dry clean, bleach or iron printed area.
- ▶ Perform fusion tests before production. Failure to cure ink properly can result in poor wash fastness, inferior adhesion and unacceptable durability. Gel and cure temperatures for ink should be measured using a Thermoprobe device placed directly in the wet ink film and verified on the substrate(s) and equipment to be used for production.
- ▶ 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 the printer's customer standards or specifications.
- ▶ Curing is the responsibility of each printer to confirm that the print is fully cured. PolyOne's cure recommendations are not a guarantee or warranty, but merely suggested starting points for curing evaluations as explained above.
- ▶ When printing on garments that contain certain dyes, you must pre-test for the potential of ghosting. Please refer to our website for more information on this issue.
- ▶ Wilflex products have been carefully designed to perform within a given viscosity range, and any dramatic change in viscosity is probable to result in a change in printing characteristics
- ▶ **NON-CONTAMINATION OF EPIC INKS:** Do not mix EPIC inks with inks, additives or extenders from other companies. 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% polyester, triblends, polyester blends, cotton/poly blends



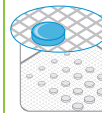
#### Mesh

Counts: 86-230 t/in (34-90t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



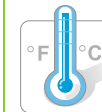
#### Squeegee

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)



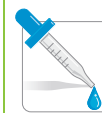
#### Flash & Cure Temperatures

Flash: 200-220°F (90°C-105°C)  
Cure: 260°F - 280°F (127°C - 138°C) Entire ink 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 degradant or press wash.



#### Health & Safety

SDS: [www.polyone.com](http://www.polyone.com) or  
Contact your local CSR.