wilflex™

Product Information Bulletin

10000PFXHB Epic Halftone Base

Wilflex™ Epic Halftone Base is designed to produce Process and Fluorescent colors. Epic Halftone Base can be colored with Epic PCs, Epic EQs and Epic MX to create multiple color variations.

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).
- Eco-Passport Certified.
- Satin or matte finish.
- Excellent flash properties.
- Will not dry in the screen.
- Prints easily through recommended meshes.

Printing Tips

- For best results, follow the recommended Printing Parameters.
- Add Epic PCs or Epic EQs to create colors, up to 10% by weight.
- For cotton fabrics, underbase with 11335PFW Sprint White.
- For bleed resistance, use an underbase white, such as 11835PFW Quick White or 11117PFW PolyWhite.

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.
- Epic Halftone Base should not be used as a glitter carrier or adhesive base.
- 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 Wilflex Technical services Department prior to printing.
- Email: techserviceswilflex@polyone.com

Printing Parameters

Opacity	3	▮▮▮
Bleed Resistance	n/a	
Smooth Surface	9	▮▮▮▮▮▮▮▮▮
Flash	9	▮▮▮▮▮▮▮▮▮
Gloss	1	▮
Printability	9	▮▮▮▮▮▮▮▮▮

Fabric Types
100% cotton, cotton blends, polyester some synthetics

Mesh
Counts: 230-305 t/in (90-120 t/cm) recommended
Tension: 25-35 n/cm² recommended

Squeegee
Durometer: 60-70, 60/90/60
Edge: Sharp
Stroke: Medium-fast

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

Gel/Cure Temperatures
Gel: 230°F (110°C)
Cure: 320°F (160°C) Entire Film

Epic Pigment Loading
MX: 25% max. weight
EQs: 10% max by weight
PCs: 10% 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

www.wilflex.com/pib

TECH SUPPORT PHONE: 888.600.6789 / WEB: TECHSUPPORTSPS.COM

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