wilflex™

**Product Information Bulletin**

# 10009PFXHDC Epic HD Clear 2

Wilflex Epic HD Clear 2 is a non-phthalate clear developed to create the appearance of glass, gel, water or high gloss surfaces. Epic HD Clear 2 can be used in High Density applications or blended with other texture inks to create unique effects. It is also an effective adhesive carrier for foil, flock, and other applications.

## Highlights

- 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.
- High gel gloss appearance.
- Excellent adhesion to fabrics.
- Super elongation and stretch.
- Excellent wash properties.
- For light or dark fabric grounds.
- Use as an overprint clear on printed colors and metallic inks to increase color vibrancy and create gloss surfaces.
- Use as a clear carrier/adhesive for caviar beads.
- Use as a High Density Clear, either on its own or with color addition.

## Printing Tips

- For best results, follow the recommended Printing Parameters.
- Add Epic PCs, Epic MX, or Epic Equalizer to create custom color. Addition of pigments or finished ink to the base should not exceed 10% by weight.
- Use a print-flash-print method to build ink. Do not print wet-on-wet.
- A heavy flood stroke that fully fills the open areas of the stencil with ink is recommended.
- Avoid excessive squeegee pressure.
- Surface of clear will appear milky after flashing, but this effect will disappear after Epic HD Clear 2 is totally cured.

## 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 HD Clear 2 cures at 350°F (177°C). Ensure the entire ink film reaches 350°F.
- When printing Epic HD Clear 2 over colors, it is recommended that you evaluate the color and the clear before production because of the potential of the clear to change in appearance when overprinted onto colors. Flash colors before overprinting.
- When printing caviar beads, pre-test when printing on polyester blends, as dye migration can affect the appearance of the bead, especially clear beads.
- Dyestuffs inherent in the garment fabric can change the clarity and color of this clear ink during curing.
- **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** | N/A |
| **Bleed Resistance** | N/A |
| **Smooth Surface** | 8 |
| **Flash** | 7 |
| **Gloss** | 9 |
| **Printability** | 7 |

**Fabric Types**
100% cotton, blends, acrylic, lycra & uncoated nylon

**Mesh**
Counts: 24-110 t/in (10-43 t/cm) recommended
Tension: 25-35 n/cm² recommended

**Squeegee**
Durometer: 75, 60/90/60
Edge: Sharp edge
Stroke: Slow. Avoid excess pressure

**Stencil** non-phthalate
Direct: 2 over 2
Capillary/ thick film: 200-400 microns
Off contact: 1/16" (.2 cm)

**Gel/Cure Temperatures**
Gel Temp: 220°F ( 104°C)
Cure Temp: 350°F (177°C) entire film

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

**Additives**
Extender: None
Reducer: 3% 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

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