

e 10088PFXHDC Epic™ HD Sharp Clear

Wilflex Epic HD Sharp Clear is a non-phthalate special effect clear developed to create high resolution graphics with sharp detail. Epic HD Sharp Clear can be used in high density applications or blended with other texture inks to create unique effects.

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 finish, dry hand feel.
- ▶ Super straight-edge definition, excellent sharp-corner properties.
- ▶ Good elongation and stretch.
- ▶ Excellent wash properties.
- ▶ Excellent adhesion to fabrics.
- ▶ Use Epic HD Sharp Clear, either on its own or with color addition. May be overprinted with colors.
- ▶ Used in conjunction with other special effect bases, Epic HD Sharp Clear can create unique textures and design effects.
- ▶ Epic HD Sharp Clear is excellent for neoprene and other stretch fabrics.
- ▶ Greatly increases production efficiency of high density printing due to excellent stacking properties.

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 as an overprint clear on printed colors and metallic inks to improve crock resistance and hand feel. Pretest before beginning production. Clarity may vary slightly depending on thickness of ink deposit.
- ▶ Use a print-flash-print method to build ink with capillary films. Do not print wet-on-wet.
- ▶ A heavy flood stroke that fully fills the open areas of the stencil with ink is recommended.
- ▶ Ink will appear slightly milky after flashing with clarity achieved after full cure.
- ▶ Cure temperatures in excess of 350°F during curing will result in a tacky hand feel, rounded edges, and an increase in gloss. Please see page 2 for comparison.
- ▶ Avoid excessive squeegee pressure.
- ▶ When formulating customer formulas use Wilflex Ink Room Management Software to ensure formulas are balanced for optimal print, wash and cure performance.

continued on page 2

Printing Parameters

Opacity	N/A
Bleed Resistance	N/A
Smooth Surface	8 ██████████
Flash	7 ██████████
Gloss	5 ████████
Printability	7 ██████████



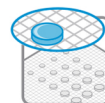
Fabric Types
100% cotton, blends, acrylic, lycra & uncoated nylon, & neoprene



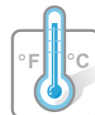
Mesh
Counts: 83-200 t/in (34-77 t/cm) recommended
Tension: 25-35 n/cm² recommended



Squeegee
Durometer: 75, 60/90/60
Edge: Sharp edge
Stroke: Medium. 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: 325-350°F (170-180°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