

e 19000PFX Epic™ Matte Black

Wilflex™ Epic™ Matte Black is a specially formulated non-phthalate print black designed to produce a very low gloss surface appearance. It is designed for high productivity wet-on-wet printing. Epic™ Matte Black offers exceptional print qualities for both the manual as well as the automatic printer.

Highlights

- ▶ Non-phthalate.
- ▶ Compliant with CPSIA 2008 (Consumer Product Safety Improvement Act) 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.
- ▶ Matte finish.
- ▶ Excellent flash properties.
- ▶ Build Up Resistant.

Printing Tips

- ▶ For best results, follow the recommended Printing Parameters.
- ▶ For one-hit opacity through coarse meshes, use a coating procedure that builds a thick, even stencil to ensure a good column height of ink.
- ▶ Avoid excessive squeegee pressure.
- ▶ For bleed resistance, use an underbase white such as 11835PFW Epic™ Quick White, 11117PFW Epic™ Polywhite, or 11195PFW Epic™ Athletic LB White.
- ▶ For cold-peel transfers, use a coated release paper.

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 inter-coat adhesion of colors.
- ▶ Any alteration of viscosity should be minimized.
- ▶ 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 Technical Services Department prior to printing.
- ▶ Email: techserviceswilflex@polyone.com

Printing Parameters

Opacity	9	
Bleed Resistance	n/a	
Smooth Surface	9	
Flash	9	
Gloss	0	
Printability	8	



Fabric Types

100% cotton, some nylon (generally open weave or mesh types) as well as other synthetics



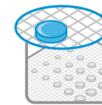
Mesh

Counts: 86 - 305 t/in (34 - 120 t/cm) recommended
Tension: 25-35 n/cm² recommended



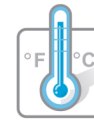
Squeegee

Durometer: 70/90/70
Edge: Sharp
Stroke: Medium for opacity, Fast for High Production. Avoid excess pressure



Stencil

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



Gel/Cure Temperatures

Gel: 160-180 F (71-82 C)
Cure: 320 F (160 C) entire film



Epic Pigment Loading

PC: N/A
EQ: N/A
MX: N/A



Additives

Extender: 20% max - 10000PFX Epic PF Extender
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