

**15370PFX Epic Silver Shimmer**  
**85470PFX Epic Bright Gold Shimmer**  
**85570PFX Epic Ultra Gold Shimmer**

Wilflex Epic Shimmers are non-phthalate shimmer inks that can be used as multi-purpose inks to produce shiny finishes. Use in combination with other non-phthalate Epic system inks. Can be printed as a high density image or as a flat print graphic concept.

**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.
- ▶ To be used exclusively with Epic non-phthalate inks.
- ▶ Smooth surface appearance.
- ▶ Excellent adhesion to fabrics, good stretch and elongation.
- ▶ Use in combination with other Epic inks.
- ▶ Can be printed as a high density ink or combined with other non-phthalate inks.
- ▶ For light or dark fabric grounds (Best effect on darks).
- ▶ Excellent wash properties.

**Printing Tips**

- ▶ For best results, follow the recommended Printing Parameters.
- ▶ Use a print-flash-print method to build ink deposit. Do not print wet-on-wet.
- ▶ Avoid excessive squeegee pressure.
- ▶ Add Epic PCs or Equalizers to created tinted metallic effects.
- ▶ A heavy flood stroke that fully fills the open areas of the stencil with ink is recommended.

**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.
- ▶ Avoid polyester-based fabrics where dye migration will occur.
- ▶ Reducing viscosity will adversely affect opacity.
- ▶ 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

<b>Opacity</b>	9	
<b>Bleed Resistance</b>	n/a	
<b>Smooth Surface</b>	7	
<b>Flash</b>	7	
<b>Gloss</b>	9	
<b>Printability</b>	8	



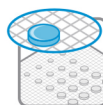
**Fabric Types**  
 100% cotton, blends, acrylic, lycra, & uncoated nylon



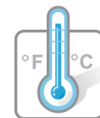
**Mesh**  
 Counts: 86-110 t/in (34-43 t/cm) recommended  
 Tension: 25-35 n/cm<sup>2</sup> recommended



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



**Stencil** non-phthalate  
 Direct: 2 over 2  
 Capillary/  
 thick film: 200-600 microns  
 Off contact: 1/16" (.2 cm)



**Gel/Cure Temperatures**  
 Gel: 220 F (104 C)  
 Cure: 290 F (143 C) entire film



**Epic Pigment Loading**  
 PCs: 10% by weight max.  
 EQs: 10% by weight max.  
 MX: n/a



**Additives**  
 Extender: None Recommended  
 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