

## 10140PFXSHC Epic™ Soft Hand Clear

Wilflex Epic Soft Hand Clear is designed to blend with other Epic general purpose and specialty inks to soften and extend. Epic Soft Hand Clear may be used as a stand-alone base with Wilflex Epic pigment concentrates and will produce inks with a soft hand and excellent color clarity.

### 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.
- ▶ Epic Inks - recommended 10% max by weight.
- ▶ Epic NuPuff and Epic Suede Inks - Recommended less than 10 percent, by weight. (Excessive amounts of Epic Soft Hand Clear will reduce puff height).
- ▶ Epic Specialities - Recommended 10% max by weight. See relevant PIB.
- ▶ Makes inks easier to print when used as an additive.
- ▶ Reduces build-up.

### Printing Tips

- ▶ For best results, follow the recommended Printing Parameters of relevant inks.

### 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 Soft Hand Clear is recommended for use in Wilflex Epic inks only.
- ▶ Additions above 10% may reduce bleed resistance and opacity.
- ▶ Wilflex products have been carefully designed to perform within a given viscosity range and any dramatic change in viscosity may result in a change in printing characteristics.
- ▶ 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](mailto:techserviceswilflex@polyone.com)

## Printing Parameters

Opacity *n/a*  
 Bleed Resistance *n/a*  
 Smooth Surface *n/a*  
 Flash 6 ██████  
 Gloss *n/a*  
 Printability 9 ██████████



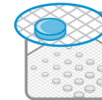
**Fabric Types**  
See relevant PIB



**Mesh**  
See relevant PIB



**Squeegee**  
See relevant PIB



**Stencil - non-phthalate**  
See relevant PIB



**Gel/Cure Temperatures**  
 Gel: 220 F (104 C)  
 Cure: 320 F (160 C) Entire film



**Pigment Loading**  
Maximum 15%



**Additives**  
 Extender: *n/a*  
 Reducer: see Highlights



**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](http://www.polyone.com)

[www.wilflex.com/pcb](http://www.wilflex.com/pcb)