

e 10008PFX Epic Special Effects Clear

Wilflex Epic Special Effects Clear is a specially formulated plastisol ink that is non-phthalate. Epic Special Effects Clear is a special effect base developed to create effects, such as the appearance of glass, gel, water or high gloss surfaces. Epic Special Effects Clear is a fast fusion clear ink.

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.

Printing Tips

- ▶ For best results, follow the recommended Printing Parameters.
- ▶ Surface of clear will appear milky after flashing, but this effect will disappear after Epic Special Effects Clear is totally cured.
- ▶ 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.
- ▶ Avoid excessive squeegee pressure.
- ▶ 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. Epic Special Effect Clear cures at 280 F (137 C). Ensure the entire ink film reaches 280 F.
- ▶ When printing Epic Special Effects Clear 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
- ▶ Dye-stuffs 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	9
Flash	7
Gloss	9
Printability	8



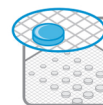
Fabric Types
100% cotton, blends, acrylic, lycra & uncoated nylon



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: 170-190F (75-88C)
Cure Temp: 280F (137C) 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