



2100 EPIC™ ARMOR LC

WILFLEX™ Epic Armor LC is a premium low bleed under base plastisol ink designed to prevent dye migration on 100% polyester, polyester blends and dye sublimation garments. Armor LC combines low cure technology with the latest bleed blocking chemistry to fight the toughest dye migration. Formulated to a lower and creamier viscosity. Armor LC is designed to give a smooth finish with great printability and easy mesh clearance.

HIGHLIGHTS

- 2100 ARMOR LC GRAY
- 2100 ARMOR LC BLACK
- Low cure, save energy, reduce bleed defects
- Smooth surface with good hand, drape and fiber-matte down
- Excellent printability, easily clears mesh
- High performance, bleed-resistant technology
- Works on a variety of fabrics

PRINTING TIPS

- Stir inks before printing
- Use consistent, high-tensioned screen mesh and sharp edged squeegees for best print results
- Print Armor LC so that the flashed ink deposit fully covers the underlying fabric, avoid any fabric showing through the under base layer
- For difficult bleeding fabrics such as digital camo, it is important to get a good ink deposit to block dye migration and a print-flash-print technique with lower mesh count is recommended. For optimized bleed protection, overprint with a Wilflex low-bleed, low-cure white
- Always overprint Armor LC with a white and/or color systems for durability performance
- Adjust flash cure temperature and dwell time so ink is just dry to touch. Depending on flash unit, a 2 - 3 second flash is adequate
- Curing is a time and temperature process, a lower oven temperature setting with a slower belt speed while maintaining recommended ink cure temperature is always best to protect fabric, control dye migration and reduce energy consumption
- Armor LC can be cured between 270°F - 320°F (132°C - 160°C). Running at the higher end of the temperature range and/or longer dwell times maybe required to achieve proper cure on jobs that contain cotton, high ink deposits or heavy weight garments

COMPLIANCE

- Non-phthalate
- For individual compliance certifications and conformity statements, please visit: www.avient.com/wilflex-compliance

PRECAUTIONS

The information above is given in good faith and does not release you from testing inks and fabrics to confirm suitability of substrate and application process to meet your customer standards and specifications



AVIENT
SPECIALTY
INKS

V3.00 (Modified: 02/18/2021)

PRODUCT INFORMATION BULLETIN



RECOMMENDED PARAMETERS



Fabric Types

100% polyester, polyester blends, tri-blends, dye sublimated fabrics



Mesh

Count: 86-160 t/in (34-62 t/cm)
Tension: 25-35 n/cm2



Squeegee

60/90/60, 60-70
Profile: Square, Sharp
Stroke: Hard flood, Medium stroke
Angle: 10-15%



Stencil

2 over 2
Off Contact: 1/16" (2mm)
Emulsion Over Mesh: 15-20%



Flash & Cure

Flash: 220°F (105°C)
Cure: 270°F (132°C)
Entire ink film



Pigment Loading

NA



Wilflex™ Additives

Epic Viscosity Buster - 1% max



Storage

65-90°F (18-32°C)
Avoid direct sunlight
Use within one year of receipt



Clean Up

Ink degradant or press wash



Health & Safety

Find SDS information here:
www.avient.com/resources/safety-data-sheets
or contact your local CSR