



10005PFX EPIC™ STRETCH BASE

PRODUCT INFORMATION BULLETIN



WILFLEX™ Epic Stretch Base is a non-phthalate, low cure plastisol ink with exceptional stretch and adhesion properties. Stretch Base can be used as a first-down base, mixing base or as an additive to increase elongation properties of Wilflex inks. Available in stretch white and black standard colors.

HIGHLIGHTS

- STRETCH BASE | 10005PFX
- STRETCH WHITE | 11000PFS
- STRETCH BLACK | 19000PFS
- Mix base with Wilflex™ PCs or Equalizers or use as additive with finished inks
- Superior adhesion to fabrics, stretch properties, and wash durability
- Ideal for heat sensitive or stretch fabrics
- Low-cure, save energy

PRINTING TIPS

- Use consistent, high-tensioned screen mesh and sharp edged squeegees for best print results
- When blended according to formulations, colors will be semi-opaque
- Use a printing technique to assure a good ink deposit to maximize stretch and film strength properties
- Use as a stand-alone product for a first-down base layer to improve overall stretch of subsequent ink layers
- Use Stretch Base as an additive to blocker, whites and finished inks for additional elongation. Add up to 25% (by weight) depending on desired properties
- Stretch Base is not a low-bleed ink; when printing on fabrics that are prone to bleed use in combination with an approved WILFLEX low bleed white and/or blocker
- 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
- Stretch Base can be cured between 270°F - 320°F (132°C - 160°C)

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

RECOMMENDED PARAMETERS



Fabric Types

100% cotton, blends, acrylic, nylon, some synthetics



Mesh

Count: 86-230 t/in (34-90 t/cm)
Tension: 25-35 n/cm²



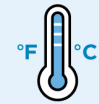
Squeegee

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



Stencil

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



Flash & Cure

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



Pigment Loading

N/A



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

SDS: www.avient.com/resources/safety-data-sheets
Contact your local CSR



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