

## EPIC™ Rio Color Matching

Wilflex™ EPIC Rio is a non-phthalate finished ink mixing system formulated for a perfect balance of color accuracy and opacity for peak press performance and color design. It is an easy-to-use color mixing system with 18 intermixable colors that enable printers to produce accurate PANTONE® simulations. EPIC Rio is the most opaque color system in our EPIC line. Its opacity helps printers get to color quicker even when using fine mesh screen size, saving ink and money.

### Highlights

- ▶ Accurate and vibrant color match to PANTONE
- ▶ Opaque
- ▶ Soft hand
- ▶ 18 intermixable colors
  - ▶ 110RX EPIC Rio Mixing White
  - ▶ 190RX EPIC Rio Deep Black
  - ▶ 380RX EPIC Rio Blaze Orange
  - ▶ 470RX EPIC Rio Red
  - ▶ 480RX EPIC Rio Barberry Maroon
  - ▶ 490RX EPIC Rio Majestic Magenta
  - ▶ 580RX EPIC Rio Deep Violet
  - ▶ 670RX EPIC Rio Midnight Blue
  - ▶ 680RX EPIC Rio Aquamarine
  - ▶ 690RX EPIC Rio Indigo Blue
  - ▶ 780RX EPIC Rio Forest Green
  - ▶ 880RX EPIC Rio Sunshine Yellow
  - ▶ 890RX EPIC Rio Golden Yellow
  - ▶ 980RX EPIC Rio Electric Yellow
  - ▶ 960RX EPIC Rio Electric Blue
  - ▶ 950RX EPIC Rio Electric Purple
  - ▶ 940RX EPIC Rio Electric Red
  - ▶ 900RX EPIC Rio Electric Pink
- ▶ Matte finish
- ▶ Wet-on-wet printing
- ▶ Low cure, save energy

### Printing Tips

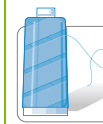
- ▶ Single print colors
- ▶ Colors will reproduce best over white - light substrate or single white base plate on dark substrates
- ▶ When direct printing over darks, print-flash-print using lower mesh count
- ▶ EPIC Rio is not a low-bleed ink; when printing as a first down a low cure temperature is required to minimize dye migration.
- ▶ Use EPIC Rio with EPIC LC Whites for a complete low cure system; EPIC Single LC White, EPIC Top Score LC White, EPIC Polywhite LC or EPIC Performance LC White
- ▶ 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, achieve graphic durability and reduce energy consumption

### Compliance

- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit [www.wilflex.com/compliance](http://www.wilflex.com/compliance).

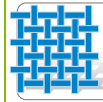
### Precautions

- ▶ Stir plastisols before printing.
- ▶ Do not dry clean, bleach or iron printed area.
- ▶ Perform fusion tests before production. Failure to cure ink properly can result in poor wash fastness, inferior adhesion and unacceptable durability. Gel and cure temperatures for ink should be measured using a Thermoprobe device placed directly in the wet ink film and verified on the substrate(s) and equipment to be used for production.
- ▶ 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 the printer's customer standards or specifications.
- ▶ Curing is the responsibility of each printer to confirm that the print is fully cured. PolyOne's cure recommendations are not a guarantee or warranty, but merely suggested starting points for curing evaluations as explained above.
- ▶ When printing on garments that contain certain dyes, you must pre-test for the potential ghosting. Please refer to our website for more information on this issue.
- ▶ Wilflex products have been carefully designed to perform within a given viscosity range, and any dramatic change in viscosity is probable to result in a change in printing characteristics
- ▶ **NON-CONTAMINATION OF EPIC INKS:** Do not mix EPIC inks with inks, additives or extenders from other companies. All buckets, palette knives, stirring apparatus, squeegees, flood bars and screens must be cleaned properly and free of phthalates and pvc containing inks. Non-phthalate emulsions and pallet adhesives must be used. Failure to follow these precautions may cause phthalate contamination in violation of consumer protection laws and regulations.
- ▶ Any application not referred in this product information bulletin should be pre-tested or consultation sought with Wilflex Technical Services Department prior to printing.



#### Fabric Types

100% cotton, 100% polyester, triblend, polyester blends, cotton/poly blends



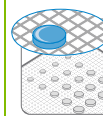
#### Mesh

Counts: 110-305 t/in (43-120 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



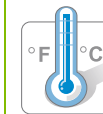
#### Squeegee

Durometer: 60-90, 70/90, 70/90/70  
Edge: Sharp  
Stroke: Hard flood, fast stroke  
*\*Do not use excess squeegee pressure.*



#### Non-Phthalate Stencil

Direct: 2 over 2  
Capillary/Thick Film: N/A  
Off Contact: 1/16" (.2cm)



#### Flash & Cure Temperatures

Flash: 220°F (105°F) for 3 - 5 seconds  
Cure: 260°F - 280°F (127°C - 138°C) Entire ink film



#### Pigment Loading

EQ: N/A  
MX: Use IMS System  
PC: N/A  
*\*All percentages listed at % by weight.*



#### EPIC Additives

Extender: N/A  
Reducer: Epic Viscosity Buster-1% max  
*\*All percentages listed at % by weight.*



#### Shipping & 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.polyone.com](http://www.polyone.com) or  
Contact your local CSR.

**PolyOne** Wilflex™ inks by PolyOne.

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

GENERAL PURPOSE | MIXING SYSTEM

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