

## 16250PFXUBG Epic Echo UBG

Wilflex™ Epic Echo UBG is a non-phthalate ink designed to prevent dye migration when printed as an underbase on 100% polyester and poly blends. It provides the highest performance bleed resistance along with superior printability and coverage.

### Highlights

- ▶ Can be used with any Epic Standard Color ink.
- ▶ Excellent bleed resistance.
- ▶ Excellent elasticity.
- ▶ Excellent printability.
- ▶ Matte finish.
- ▶ Smooth surface.

### Printing Tips

- ▶ Polyester fabrics are likely to have dye migration issues. To determine a material's bleed potential, please reference the Bleed Test procedures outlined in the Wilflex Evaluation of Plastisol Inks Technical Bulletin found in Tools & Downloads on our website.
- ▶ Best results are achieved using recommended mesh counts.
- ▶ Use consistent, high-tensioned screen mesh to optimize performance properties.
- ▶ To optimize performance, minimize the fabric's exposure to heat. Curing temperature is dependent on the substrate and over print inks utilized in the design graphic.

### Compliance

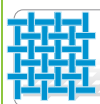
- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit [www.wilflex.com/compliance](http://www.wilflex.com/compliance).

### 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.
- ▶ Pre-test all fabrics for desired properties before beginning production printing.
- ▶ Adjust the time and temperature settings for the flash station and dryer to reach minimal ink gel and full cure temperatures respectively.
- ▶ 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 Epic inks. 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.
- ▶ Email: [techserviceswilflex@polyone.com](mailto:techserviceswilflex@polyone.com)



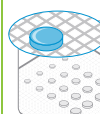
**Fabric Types**  
100% polyester, polyester blends



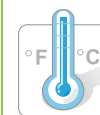
**Mesh**  
Counts: 86-158 t/in (34-62 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



**Squeegee**  
Durometer: 70, 70/90/70, 80  
Edge: Square, Sharp  
Stroke: Medium  
*\*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: 160°F (70-80°C)  
Cure: 320°F (160°C)



**Pigment Loading**  
EQ: N/A  
MX: N/A  
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.*



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



**Clean Up**  
Ink degradent or press wash.



**Health & Safety**  
MSDS: [www.polyone.com](http://www.polyone.com) or  
Contact your local CSR.