


-  10344PFXREF Epic™ ImageBrite Base 14295PFXREF Epic™ ImageBrite Mid Gray
 19000PFXREF Epic™ ImageBrite Black 14298PFXREF Epic™ ImageBrite Dark Gray
 15325PFXREF Epic™ ImageBrite Met. Platinum

Epic™ ImageBrite Base and Colors are non-phthalate reflective inks formulated for direct printing on textiles. ImageBrite Base is non-pigmented/non-colored. Add up to 6% (by weight) pigment concentrate to create custom colors.

Highlights

- ▶ Non-phthalate.
- ▶ 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)
 - ▶ CPSIA 2008, Section 108, Phthalates (<.1% DEHP, DBP, BBP, DINP, DIDP, DNOP)
- ▶ Eco-Passport Certified.
- ▶ State-of-the-art reflectivity on dark and light fabrics
- ▶ For high-visibility clothing and fashion graphics
- ▶ Excellent adhesion
- ▶ Prints easily through recommended meshes
- ▶ Super after wash reflective response
- ▶ For use with safety and fashion design concepts

Printing Tips

- ▶ For best results, follow the recommended Printing Parameters.
- ▶ To produce reflective colors, add up to 6% by weight of Wilflex pigment concentrate to the ImageBrite base. NOTE: When adding pigment concentrates to ImageBrite Base 10344PFXREF, it is recommended to mix only what is needed for the print application. Increased viscosity in the mixed ink may occur in the short term. Not all PC's are recommended. See Precautions.
- ▶ Do not print reflective inks on an underbase; as the reflectivity will be greatly diminished.
- ▶ Print/flash/print application not recommended.
- ▶ Reflective colors work well on dark fabrics, but will not be highly saturated. The color under normal lighting may vary with substrate color.
- ▶ To print a block graphic design on dark fabrics, the printer may print the inside of the design with a reflective ink and outline with another reflective color or a non-reflective ink.
- ▶ Avoid excess squeegee pressure.

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.
- ▶ Reflective and wash properties may be compromised by adding products other than those recommended.
- ▶ Reducing viscosity will adversely affect opacity.
- ▶ 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 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 to in this product bulletin should be pre-tested or consultation sought with Technical Services Department prior to printing.
- ▶ Email: techserviceswilflex@polyone.com

Printing Parameters

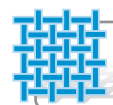
Opacity	9	
Bleed Resistance	n/a	
Smooth Surface	8	
Flash	9	
Gloss	4	
Printability	8	



Fabric Types

100% Cotton, Cotton Blends,
Some Synthetics

**Do not print on nylon.*



Mesh

Counts: 110 - 156 t/in (43-62 t/cm)
recommended

Tension: 25-35 n/cm² recommended



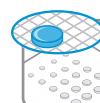
Squeegee

Durometer: 60-70, 70/90/70

Edge: Sharp

Stroke: Medium

Avoid excess pressure



Stencil

Direct: non-phthalate

Capillary/thick film: 2 over 2

Off contact: n/a

1/16" (.2 cm)



Gel/Cure Temperatures

Gel: 160 - 180°F (70-82°C)

Cure: 340-350°F (171-177°C)

Entire Film



Epic Pigment Loading

MX: 5% max by weight

EQs: 5% max by weight

PCs: 5% max by weight



Additives

Extender: None Recommended

Reducer: 1% Max of 10025VB

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