



## EPIC™ TOP SCORE LC STANDARD COLORS

WILFLEX™ Epic Top Score LC Standard Colors are low bleed and low cure colors that deliver maximum coverage with the fewest strokes for color consistency when printing directly onto dark fabric or over an under base. With the most popular industry colors, superior on-press performance and exceptional print results on today's garments, printers win big with Wilflex Top Score low cure colors.

### HIGHLIGHTS

- Popular athletic low-bleed standard colors, ready for use saving time to mix
- Low cure, save energy, reduce bleed defects
- Opaque colors. Excellent color reproduction over base plate and direct to light and dark garments
- Superior bleed resistance, reducing the need to underbase on polyesters
- Best color fastness to crocking test
- Matte finish with low surface tack

### PRINTING TIPS

- Use consistent, high-tensioned screen mesh and sharp edged squeegees for best print results
- Good color reproduction using 160-230 t/in (62-90 t/cm) on white and dark (blocker) base plates and direct to dark substrates. For lighter ink colors, use 110-160 t/in (43-62 t/cm) for best color reproduction when printing direct to dark substrates. Use a print-flash-print technique when printing direct to dark substrates.
- For best results on non-woven polypropylene bags, single print using 110-160 t/in (43-62 t/cm) mesh with a 60 or 70 single durometer squeegee
- EPIC Top Score LC Standard Colors are low cure and low bleed inks. For challenging fabrics using sublimation dyes, a bleed blocking underbase such as EPIC ARMOR LC may be required
- 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
- EPIC TOP SCORE LC Colors 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 or heavy weight garments
- For cold-peel transfers, use a coated release paper or polyester film. Print colors using 70 duro squeegee and 110-230 t/in (43-91 t/cm) mesh followed by powdering. Gel at 212°F (100°C) for 60 sec. Apply transfer with heat press at 300°F (150°C) for 10-12 sec at medium pressure. For transfers on polyester, back with a low bleed white and/or blocker. Verify process.

### COMPLIANCE

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

## PRODUCT INFORMATION BULLETIN



### RECOMMENDED PARAMETERS



#### Fabric Types

100% polyester, polyester blends, 100% nylon Jersey, NWPB (non-woven polypropylene bags)



#### Mesh

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



#### Squeegee

60/90/60, 60-70  
Profile: Square, Sharp  
Stroke: Hard flood, Slow-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

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



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