

2321 EPIC™ LC BASE

Wilflex™ EPIC LC Base is a non-phthalate mixing base for manual and automatic screen printing on 100% cotton and cotton/poly blend substrates. EPIC LC Base exhibits consistent color reproduction, excellent graphic durability and efficient wet-on-wet application. Recommend cure temperature is 270°F/132°C - 320°F/160°C.

Highlights

- ▶ Matte finish.
- ▶ Clean, bright colors when mixed with Epic PCs
- ▶ Low cure, save energy
- ▶ Ideal for overprinting onto a flashed white underbase
- ▶ Wet-on-wet printing

Printing Tips

- ▶ Colors will reproduce best over white - light substrate or solid white base plate on dark substrates
- ▶ Exhibits good color saturation and holds color in high-speed wet-on-wet production with minimal build up. For some colors, base mixing systems are limited in color saturation and may require an increased ink deposit
- ▶ EPIC LC Base is not a low-bleed ink; for bleed resistance and/or maximize energy efficiency use in combination with EPIC Armor LC blocker and/or 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
- ▶ EPIC LC Base can be cured up to 320°F (160°C) and used with other premium EPIC whites such as 11835PFW Epic Quick White, 11480PFW Epic Bright Tiger or 11335PFW Epic Sprint White

Compliance

- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit www.wilflex.com/compliance.

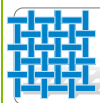
Precautions

- ▶ 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 of 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 phthalate 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



Fabric Types

100% cotton, cotton/poly blends



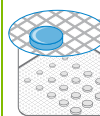
Mesh

Counts: 86 -305 t/in (34-120 t/cm)
Tension: 25-35 n/cm²



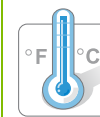
Squeegee

Durometer: 60-90, 70/90, 70/90/70
Edge: Sharp, Square
Stroke: Medium-Fast
**Do not use excess squeegee pressure.*



Non-Phthalate Stencil

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



Flash & Cure Temperatures

Flash: 220°F (105°C) for 3 - 5 seconds
Cure: 270°F (132°C) Entire ink film



Pigment Loading

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



Epic Additives

Extender: Epic Extender Base-20% max
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

Non-phthalate ink degradant or press wash



Health & Safety

SDS: www.polyone.com or
Contact your local CSR.