

## 2100 EPIC™ ARMOR LC

Wilflex™ EPIC ARMOR LC is a premium low bleed under base plastisol ink designed to prevent dye migration on 100% polyester, polyester blends and dye sublimation garments. EPIC Armor combines low cure technology with the latest bleed blocking chemistry to fight the toughest dye migration. Formulated to a lower and creamier viscosity, EPIC Armor LC is designed to give a smooth finish with great printability and easy mesh clearance.

### Highlights

- ▶ Available in gray or black under base colors
- ▶ High performance, bleed-resistant technology
- ▶ Low cure, save energy, reduce bleed defects
- ▶ Excellent printability
- ▶ Smooth surface
- ▶ Works on a variety of fabrics.

### Printing Tips

- ▶ Print EPIC Armor LC so that the flashed ink deposit fully covers the underlying fabric, avoid any fabric showing through the under base layer
- ▶ For difficult bleeding fabrics such as digital camo, it is important to get a good ink deposit to block dye migration and a print-flash-print technique with lower mesh count is recommended. For optimized bleed protection, follow the under base with a print-flash-print of Wilflex low cure whites
- ▶ Always overprint EPIC Armor LC with Wilflex LC whites and/or color systems for durability performance
- ▶ Use consistent, high-tension screens to optimize performance
- ▶ When possible, use S-thread screens with smaller diameter threads and larger mesh opening
- ▶ Adjust flash cure temperature and time so ink is just dry to touch. Avoid excessive flash temperatures to protect fabric and migration of dyes. Depending on flash unit, a 2 - 3 second flash is adequate. If surface is hot and tacky, the ink film has been over flashed. Reduce temperature or time to prevent an inter-coat adhesion problem
- ▶ 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 Armor LC 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, high ink deposits or heavy weight garments.

### Compliance

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

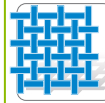
### Precautions

- ▶ 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.
- ▶ 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 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, tri-blends, dye sublimated fabrics



#### Mesh

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



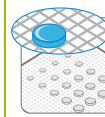
#### Squeegee

Durometer: 60-70, 60/90/60

Edge: Square, Sharp

Stroke: Medium

*\*Do not use excess squeegee pressure.*

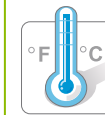


#### Non-Phthalate Stencil

Direct: 2 over 2

Capillary/Thick Film: N/A

Off Contact: 1/16" (.2cm)



#### Flash & Cure Temperatures

Flash: 200-220°F (90°C-105°C)

Cure: 270°F (132°C) Entire ink film



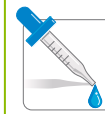
#### Pigment Loading

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.*



#### 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.