

## 10290PFXSA Epic SuperBond Adhesive

Wilflex™ Epic SuperBond Adhesive is a specially formulated hot-peel/hot-split plastisol transfer adhesive. Epic SuperBond Adhesive will create transfers that have excellent durability, stretch and wash properties onto fabrics that are not totally conditioned for regular hot-split plastisol transfer inks.

### Highlights

- ▶ Excellent abrasion and crack resistance.
- ▶ Excellent adhesion to fabrics.
- ▶ Maximum elongation.
- ▶ Can be used as a foil adhesive for direct printing.

### Printing Tips

- ▶ Adjustments to the drying mechanism may be required as the variables of different drying (heat) types, length of dryer conveyor and drying units, will affect the overall transfer finish.
- ▶ The majority of standard transfer papers can be used with confidence. If a softer-feel transfer is required, an uncoated transfer paper is recommended. In most cases, a hotsplit/hot-peel transfer paper will be required.
- ▶ Pretest all fabrics for desired properties before beginning production printing.

### Compliance

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

### Precautions

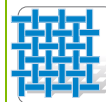
- ▶ Perform fusion tests before production. Failure to cure ink properly may result in poor wash fastness, inferior adhesion and unacceptable durability. Ink gel and cure temperatures should be measured using a Thermoprobe placed directly in the wet ink film and verified on the production run substrate(s) 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.
- ▶ Turn the garment inside-out when washing and drying to keep the transfer looking its best.
- ▶ Examine the fabric type and color before and after the application of the transfer, as color distortion may occur due to the introduction of heat to sensitive fabric types and dyestuffs inherent in the garment.
- ▶ It is advisable to press the blank shirt under transfer press before applying transfer to reduce moisture in garment.
- ▶ 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)

## Recommended Parameters



### Fabric Types

100% cotton, cotton blends, rayon, linen, uncoated nylon, and Lycra.



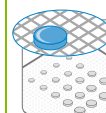
### Mesh

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



### Squeegee

Durometer: 60-80  
Edge: Hard, Square  
Stroke: Hard flood, slow speed  
*\*Do not use excess squeegee pressure.*



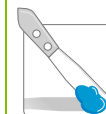
### Non-Phthalate Stencil

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



### Flash & Cure Temperatures

Flash: 160°F (70°C)  
Cure: 375°F (190°C)



### Pigment Loading

EQ: N/A  
MX: N/A  
PC: 10% max  
*\*All percentages listed at % by weight.*



### Epic Additives

Extender: N/A  
Reducer: N/A  
*\*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 degradant or press wash.



### Health & Safety

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