

## EPIC TOP SCORE LC Standard Colors

Wilflex™ EPIC TOP SCORE LC standard colors 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 Epic Top Score low cure colors.

### Highlights

- ▶ Popular athletic standard colors
- ▶ Matte finish with low surface tack
- ▶ High opacity, excellent coverage
- ▶ EPIC TOP SCORE LC Standard Colors:
- ▶ Superior bleed resistance
- ▶ Low cure, save energy, reduce bleed defects

- |                       |                      |                     |
|-----------------------|----------------------|---------------------|
| ▶14600 Dark Gray      | ▶43000 National Red  | ▶70200 Dark Green   |
| ▶15350 Silver Gray    | ▶44550 Maroon        | ▶70367 Lime Shock   |
| ▶19000 Black          | ▶57150 Purple        | ▶80000 Gold         |
| ▶20550 Brown          | ▶60500 Columbia Blue | ▶80123 Yellow       |
| ▶30200 Bright Orange  | ▶62100 Royal Blue    | ▶80500 Old Gold     |
| ▶30400 Dolphin Orange | ▶66500 Navy          | ▶80550 Lemon Yellow |
| ▶40550 Pink           | ▶67550 Teal          | ▶86780 Vegas Gold   |
| ▶41550 Cardinal       | ▶70000 Kelly Green   |                     |

### Printing Tips

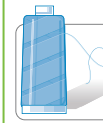
- ▶ Colors have good reproducibility over dark (blocker) and white base plates or direct to garment
- ▶ Use a print-flash-print technique when printing directly to dark grounds
- ▶ EPIC TOP SCORE LC colors are low bleed inks. For challenging fabrics using sublimation dyes, a bleed blocking underbase such as EPIC ARMOR LC may be required
- ▶ Adjust flash cure temperature and dwell time so ink is just dry to touch. 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 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.

### Compliance

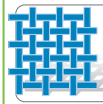
- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit [www.wilflex.com/compliance](http://www.wilflex.com/compliance).

### 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 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](mailto:techserviceswilflex@polyone.com)



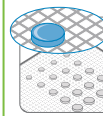
**Fabric Types**  
100% polyester, polyester blends, 100% nylon Jersey



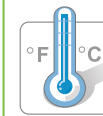
**Mesh**  
Counts: 86-230 t/in (34-90t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



**Squeegee**  
Durometer: 60-70  
Edge: Square, Sharp  
Stroke: Hard flood, Slow-Medium stroke  
*\*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: 220°F (105°C) for 3 - 5 seconds  
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.