

## 10000PFXHB Epic Halftone Base

Wilflex™ Epic Halftone Base is a non-phthalate ink designed to produce Process and Fluorescent colors. Epic Halftone Base can be colored using Epic PCs, Epic EQs and Epic MX to create multiple color variations.

### Highlights

- ▶ Satin or matte finish.
- ▶ Excellent flash properties.
- ▶ Will not dry in the screen.
- ▶ Prints easily through recommended meshes.

### Printing Tips

- ▶ Recommended for use with Epic Inks at 10% max by weight.
- ▶ For cotton fabrics, underbase with 11335PFW Epic Sprint White.
- ▶ For bleed resistance, use an underbase white such as 11835PFW Epic Quick White, 11117PFW Epic Polywhite, or 11195PFW Epic Athletic LB White.

### Compliance

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

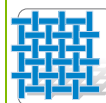
### Precautions

- ▶ 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.
- ▶ Epic Halftone Base should not be used as a glitter carrier or adhesive base.
- ▶ 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



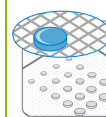
**Fabric Types**  
100% cotton, cotton blends, polyester, some synthetics



**Mesh**  
Counts: 230-305 t/in (91-120 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



**Squeegee**  
Durometer: 60-70, 60/90/60  
Edge: Square, Sharp  
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)



**Flash & Cure Temperatures**  
Flash: 160°F (70°C)  
Cure: 320°F (160°C)



**Pigment Loading**  
EQ: 10% max  
MX: 25% max  
PC: 10% max  
*\*All percentages listed at % by weight.*



**Epic Additives**  
Extender: N/A  
Reducer: Epic Viscosity Buster-1% max  
*\*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 degradent or press wash.



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