

10010PFXMB Epic Metallic Base

Wilflex™ Epic Metallic base is a non-phthalate crystal clear ink specifically designed for use with metallic pigments. Epic Metallic Base can also be utilized as a stand-alone clear or base.

Highlights

- ▶ Excellent clarity.
- ▶ Can be mixed with Epic PCs and Epic EQs to create custom colors.
- ▶ Chemically stable when used as a carrier for metallics. Inks will not shift in color (oxidize) during storage.
- ▶ Optimized for a maximum optical flash when used as a metallic carrier.
- ▶ May be used to create “gripping patterns” when printed as a HD Gel application.

Printing Tips

- ▶ Be sure to completely disperse the metallic pigments into the Epic Metallic Base.
- ▶ Use a heavy flood stroke and then light squeegee pressure to print Epic Metallic Base with metallic pigments onto the garments.
- ▶ Check the cure temperature at the ink surface.

Compliance

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

Precautions

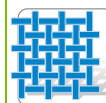
- ▶ Perform fusion tests before production. Failure to cure ink properly may result in poor wash fastness, inferior adhesion and unacceptable durability. Ink gel and cure temperatures should be measured using a Thermoprobe placed directly in the wet ink film and verified on the production run substrate(s) 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 Metallic Base is not recommended for mixing glitter inks.
- ▶ Pretest all fabrics for dye migration.
- ▶ 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

Recommended Parameters



Fabric Types

100% cotton, cotton/poly blends, polyester



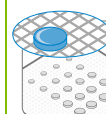
Mesh

Counts: 74-110 t/in (29-43 t/cm)
Tension: 25-35 n/cm²



Squeegee

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



Non-Phthalate Stencil

Direct: 2 over 2
Capillary/Thick Film: 200-400+ microns
Off Contact: 1/16” (.2cm)



Flash & Cure Temperatures

Flash: 160°F (70°C)
Cure: 320°F (160°C)



Pigment Loading

EQ: 5% max
MX: 5% max
PC: 5% 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
Contact your local CSR.