

## 10460PFXBB Epic Brittle Base

Wilflex™ Epic Brittle Inks are specially formulated non-phthalate inks that have the ability to easily fracture and crack when pressure is applied to the ink surface. Distorting the surface through bending or stretching causes the ink to crack and fracture. Epic Brittle inks have a worn, tough finish that can resemble cracked paint or distressed appearance.

### Highlights

- ▶ Tough and hard wearing.
- ▶ Can be used on light or dark grounds.
- ▶ Can be used in conjunction with Epic Fashion Soft inks.
- ▶ Will not dry in the screen.
- ▶ Prints easily through recommended meshes.

### Printing Tips

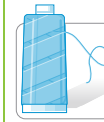
- ▶ Can be mixed with Epic PCs and Epic EQs to create custom colors. Add up to 5% by weight.
- ▶ Use a single print stroke for lower mesh counts and a print-flash-print application when using higher mesh counts.
- ▶ Ink deposit is critical to achieving desired results.
- ▶ Cure at high temperatures of 340-350°F (170-175°C) to achieve cracking effect.

### Compliance

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

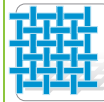
### Precautions

- ▶ 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.
- ▶ Brittle inks should not be used as an adhesive base.
- ▶ High density applications may require more heat for complete cure and acceptable cracking effects.
- ▶ 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)



#### Fabric Types

100% cotton, cotton blends, some synthetics



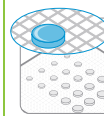
#### Mesh

Counts: 86-230 t/in (34-91 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



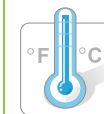
#### Squeegee

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: up to 200 microns  
Off Contact: 1/16" (.2cm)



#### Flash & Cure Temperatures

Flash: 220°F (105°C)  
Cure: 340-350°F (170-175°C)



#### Pigment Loading

EQ: 5% max  
MX: N/A  
PC: 5% 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 degradant or press wash.



#### Health & Safety

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