

## 10670PFXRB Epic Rock Base

Wilflex™ Epic Rock Base is a specially formulated non-phthalate plastisol ink designed to create super textured effects such as solid rock, coarse rope, or fabric textured surfaces. Epic Rock Base Can be used alone or in combination with other Epic products to create various specialty effects.

### Highlights

- ▶ Tough, textured surface.
- ▶ Excellent adhesion to fabrics.
- ▶ Excellent wash properties.
- ▶ Can be used on light or dark grounds.
- ▶ Can be used alone or in combination with other Epic products to create various specialty effects.

### Printing Tips

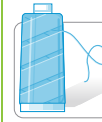
- ▶ Use screen meshes from 24-230 t/in (10-90 t/cm).
- ▶ Can be printed through flat screen meshes or high density films. To gain higher ink yields, use a print-flash-print method for both flat and high density printing.

### Compliance

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

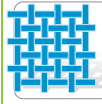
### Precautions

- ▶ 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.
- ▶ Avoid over flashing as it can result in poor intercoat adhesion of colors.
- ▶ Can be mixed with Epic PCs, Epic EQs, or Epic MX to create custom colors. Add up to 15% by weight.
- ▶ 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](mailto:techserviceswilflex@polyone.com)



#### Fabric Types

100% cotton, cotton blends, acrylic, Lycra, uncoated nylon



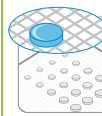
#### Mesh

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  
*\*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: 300°F (150°C)



#### Pigment Loading

EQ: 15% max  
MX: 15% max  
PC: 15% max  
*\*All percentages listed at % by weight.*



#### Epic Additives

Extender: N/A  
Reducer: Epic Viscosity Buster-3% 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.