

## 10140PFXSHC Epic Soft Hand Clear

Wilflex™ Epic Soft Hand Clear is a non-phthalate ink additive designed to blend with other Epic general purpose and specialty inks to soften and extend ink bases. Epic Soft Hand Clear may be used as a stand-alone base with Wilflex Epic color systems and will produce inks with a soft hand and excellent color clarity.

### Highlights

- Makes inks easier to print when used as an additive.
- Build-up resistant for high productivity printing.
- Recommended for use with Epic Inks at 10% max by weight.
- Recommended for use with Epic specialties Epic NuPuff and Epic Suede Inks at less than 10% max by weight. Excessive amounts will reduce puff height.

### Printing Tips

### Compliance

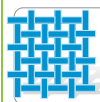
- Non-phthalate.
- For individual compliance certifications, please visit [www.wilflex.com/compliance](http://www.wilflex.com/compliance).

### 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 Soft Hand Clear is recommended for use in Wilflex Epic inks only.
- Additions above 10% may reduce bleed resistance and opacity.
- Wilflex products have been carefully designed to perform within a given viscosity range and any dramatic change in viscosity may result in a change in printing characteristics.
- 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)



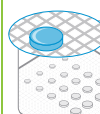
**Fabric Types**  
See relevant PIB.



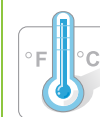
**Mesh**  
Counts: See relevant PIB.  
Tension: See relevant PIB.



**Squeegee**  
Durometer: See relevant PIB.  
Edge: See relevant PIB.  
Stroke: See relevant PIB.  
*\*Do not use excess squeegee pressure.*



**Non-Phthalate Stencil**  
Direct: See relevant PIB.  
Capillary/Thick Film: See relevant PIB.  
Off Contact: See relevant PIB.



**Flash & Cure Temperatures**  
Flash: 160°F (70°C)  
Cure: 300°F (150°C)



**Pigment Loading**  
EQ: 15% max  
MX: N/A  
PC: 15% max  
*\*All percentages listed at % by weight.*



**Epic Additives**  
Extender: N/A  
Reducer: See Highlights  
*\*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.