

## 10005PFX Epic Stretch Base

Wilflex™ Epic Stretch Base is a non-phthalate plastisol ink specially formulated to cure at lower temperatures than conventional plastisol inks. Low cure temperatures will prevent or substantially reduce shrinkage of heat-sensitive fabrics such as 100% acrylic.

### Highlights

- ▶ Excellent durability.
- ▶ Excellent stretch properties.
- ▶ Ideal for heat sensitive or stretch fabrics.
- ▶ Excellent wash properties.
- ▶ Can be mixed with Epic PCs, Epic EQs, or Epic MX to create custom colors.

### Printing Tips

- ▶ Epic Stretch Base is 100% solvent-free and cannot be air-dried.
- ▶ Use consistent, high-tensioned screen mesh to optimize performance properties.

### Compliance

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

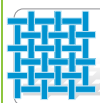
### Precautions

- ▶ 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.
- ▶ 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, nylon, some synthetics



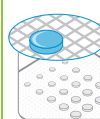
#### Mesh

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



#### Squeegee

Durometer: 75-85, 60/90/60  
Edge: Square, Sharp  
Stroke: Medium  
*\*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: 5% max  
MX: 25% max  
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.