

## 15400PFB Epic High Opacity Mixing Base

Wilflex™ Epic High Opacity Mixing Base is a specially formulated, highly opaque non-phthalate base for Epic PC and Epic EQualizer mixing systems. Designed for high productivity, wet-on-wet printing, Epic HO Mixing Base offers exceptional print qualities for both manual and automatic prints.

### Highlights

- ▶ Non-phthalate.
- ▶ Compliant with CPSIA 2008 (Consumer Product Safety Improvement Act) Section 101, Lead Content in Substrates (<300 ppm lead); 16 CFR, Part 1303, Lead in Paint (<90 ppm lead); and CPSIA 2008, Section 108, Phthalates (<.1% DEHP, DBP, BBP, DINP, DIDP, DNOP).
- ▶ Eco-Passport certified.
- ▶ Matte finish.
- ▶ Excellent flash properties.
- ▶ High opacity.
- ▶ Build-up resistant for high productivity printing.

### Printing Tips

- ▶ For one-hit opacity through coarse meshes, use a coating procedure that builds a thick, even stencil to ensure a good column height of ink.
- ▶ For cotton fabrics, underbase with 11335PFW Epic Sprint White.
- ▶ For polyester fabrics, underbase with 11835PFW Epic Quick White, 1117PFW Epic Polywhite, or 1195PFW Epic Athletic LB White.
- ▶ For cold-peel transfers, use a coated release paper.

### 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.
- ▶ Avoid direct printing polyester fabrics as dye migration may occur.
- ▶ The viscosity of Epic HO Mixing Base is designed to enhance opacity and printability. Any alteration of viscosity should be minimized.
- ▶ 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™ ink products.  
All buckets, palette knives and stirring apparatus must be cleaned properly and free of phthalate containing inks. All squeegees, flood bars and screens must be cleaned properly to remove phthalate containing inks before printing Epic™.  
Non-phthalate emulsions and pallet adhesives must be used.
- ▶ Any application not referred in this product bulletin should be pre-tested or consultation sought with Technical Services Department prior to printing.
- ▶ Email: techserviceswilflex@polyone.com

**PolyOne** Wilflex™ inks by PolyOne.

©2009 PolyOne Corporation All Rights Reserved. Effective 11/02/2005. Not all Wilflex products are available in every country. The information in this publication is based on information and experience believed reliable. Since many factors may affect processing for an application, processors must carry out their own tests and experiments to confirm suitability for intended use. You must make your own determination of suitability for your intended use and environmental acceptability, the safety and health of your employees, and purchasers of your product.

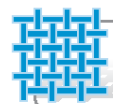
## Printing Parameters

Opacity	9	
Bleed Resistance	-	
Smooth Surface	9	
Flash	9	
Gloss	3	
Printability	8	



#### Fabric Types

100% cotton, cotton/poly blends, some nylon (generally open weave or mesh types) as well as other synthetics



#### Mesh

Counts: 86 - 305 t/in (34 - 120 t/cm)  
Tension: 25-35 n/cm² recommended



#### Squeegee

Durometer: 70/90/70  
Edge: Square, Sharp  
Stroke: Medium for opacity.  
Fast for High Production.  
Avoid excess pressure



#### Non-Phthalate Stencil

Direct: 2 over 2  
Capillary/  
thick film: N/A  
Off contact: 1/16" (.2 cm)



#### Gel/Cure Temperatures

Gel: 160-180 F (71-82 C)  
Cure: 320 F (160 C) entire film



#### Epic Pigment Loading

Use IMS System



#### Additives

Extender: Epic Extender Base-20% max  
Reducer: Epic Viscosity Buster- 3% max



#### Storage

65°-90°F (18°-32°C)  
Avoid direct sun.  
Use within one year of receipt.

#### Clean Up

Wilflex screen wash



#### Health & Safety

MSDS: www.polyone.com



www.wilflex.com/pib