

14020PFX Epic High Density Additive

Wilflex™ High Density Additive is a specially formulated additive designed to be used with Wilflex inks to achieve a three-dimensional print. The finished print exhibits a lofted image with excellent detail, edge definition and a matte finish.

Highlights

- ▶ Used to produce high, vertical stack of ink that allows for fine-line definition and open graphic content.
- ▶ Matte finish.
- ▶ Excellent stretch properties.

Printing Tips

- ▶ Best results have been obtained by adding High Density Additive to MX inks.
- ▶ Use the thinnest screen mesh thread diameter possible.
- ▶ Extended exposure times can result in undercutting of the image. Carefully monitor exposure times for the stencils.
- ▶ When creating defined “high wall” effects, it is important to ensure that the screen lifts away from the printed image immediately following the squeegee on the print stroke.
- ▶ Higher ink deposits and open screen meshes will increase the possibility of ink spread and image distortion. A 200 micron stencil and 86 t/in mesh (34 t/cm) will give the best results.
- ▶ Recommended for use with Epic Inks at 10-12% max by weight.

Compliance

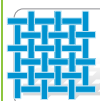
- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit www.wilflex.com/compliance.

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.
- ▶ 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



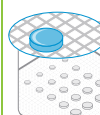
Fabric Types
100% cotton, cotton blends



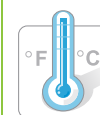
Mesh
Counts: 86-110 t/in (34-43 t/cm)
Tension: 25-35 n/cm²



Squeegee
Durometer: 70/90/70
Edge: Sharp
Stroke: Medium-Slow
**Do not use excess squeegee pressure.*



Non-Phthalate Stencil
Direct: 2 over 2
Capillary/Thick Film: 200-400 microns
Off Contact: 1/16" (.2 cm)



Flash & Cure Temperatures
Flash: 160°F (70°C)
Cure: 320°F (160°C)



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



Epic Additives
Extender: Add up to 12% by weight of High Density Additive to the ink.
Reducer: N/A
**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 or
Contact your local CSR.