wilflex™

Product Information Bulletin

Epic Top Score Standard Colors

Wilflex™ Epic Top Score standard colors is a series of premixed athletic colors designed to meet the changing demands in the athletic market by delivering a solution for printing on polyester substrates that require low cure temperatures.

Highlights

- Premix offering of most popular athletic colors.
- Low cure properties. Delivers high stretch and bleed resistance in one package.
- Matte finish with low surface tack.
- Excellent printability.
- Convenient packaging.
- Epic Top Score Standard Colors:
  - 14600LBFF Epic Top Score Dark Gray
  - 15350LBFF Epic Top Score Silver Gray
  - 19000LBFF Epic Top Score Black
  - 20100LBFF Epic Top Score Dark Brown
  - 30150LBFF Epic Top Score Light Orange
  - 30200LBFF Epic Top Score Bright Orange
  - 30600LBFF Epic Top Score Texas Orange
  - 30850LBFF Epic Top Score Burnt Orange
  - 41850LBFF Epic Top Score Crimson
  - 43000LBFF Epic Top Score National Red
  - 44500LBFF Epic Top Score Light Maroon
  - 57150LBFF Epic Top Score Purple
  - 60500LBFF Epic Top Score Columbia Blue
  - 62100LBFF Epic Top Score Royal Blue
  - 66500LBFF Epic Top Score Navy
  - 67850LBFF Epic Top Score Aqua
  - 70000LBFF Epic Top Score Kelly Green
  - 70200LBFF Epic Top Score Dark Green
  - 80500LBFF Epic Top Score Old Gold
  - 80000LBFF Epic Top Score Gold
  - 86780LBFF Epic Top Score Vegas Gold

Printing Tips

- For optimal bleed resistance, print Epic PolyWhite or Top Score White as underbase. Set the dryer belt at the highest possible speed while still ensuring that the ink film reaches 300°F (150°C). For optimal stretch, print Epic Performance White as underbase. Set the dryer belt at the highest possible speed while still ensuring that the ink film reaches 290°F (145°C).
- Building a thick ink deposit on the polyester substrate provides additional bleed blocking power. To accomplish this, use the following coating screen method with a wet-on-wet application: 1) Coat print side; 2) Coat squeegee side; 3) Coat print side; 4) Coat squeegee side. Always end coating on the squeegee side to push the emulsion to the print side. Dry screens with print side facing the floor.
- If printing on a hard metal surface, use a palette covering to allow for a softer printing surface.
- Polyester fabrics are likely to have dye migration issues and may require use of additional bleed blocker, such as Epic Performance Underbase Gray. To determine a material's bleed potential, please reference the testing procedures outlined in the Wilflex User's Manual.

Compliance

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

Precautions

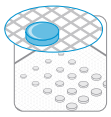
- Perform fusion tests before production. Failure to cure ink properly may result in poor wash fastness, inferior adhesion and unacceptable durability. Ink gel and cure temperatures should be measured using a Thermoprobe placed directly in the wet ink film and verified on the production run substrate(s) 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.
- Some fabric dyes may cause ghosting effect if not properly tested. Pre-test on light colored or stone washed garments. Avoid stacking printed garments while hot because such colors are more prone to color distortion (ghosting). Fabric and dye characteristics can vary between manufacturers and dye lot.
- 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

Recommended Parameters

Fabric Types
100% polyester, polyester blends, 100% nylon Jersey

Mesh
Counts: 86-158 t/in (34-62 t/cm)
Tension: 25-35 n/cm²

Squeegee
Durometer: 60-70
Edge: Square, Sharp
Stroke: Hard flood, Slow-Medium stroke
Do not use excess squeegee pressure.



Non-Phthalate Stencil
Direct: 2 over 2
Capillary/Thick Film: 30+ micron
Off Contact: 1/16" (.2cm)

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

Pigment Loading
EQ: N/A
MX: N/A
PC: N/A
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 degradent or press wash.

Health & Safety
MSDS: www.polyone.com or Contact your local CSR.

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PolyOne Wilflex™ inks by PolyOne.

www.wilflex.com/pib

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