

## 10520PFXFLEX Epic Flexipuff Additive

Wilflex™ Epic Flexipuff Additive is formulated to be mixed with Wilflex Epic Inks to give a raised or elevated effect. Epic Flexipuff Additive may be added in amounts up to 30% by weight to the ink.

### Highlights

- ▶ Can be used with any Epic Standard Color ink.
- ▶ Allows printers to conserve reduced stock, especially Epic NuPuff inks.
- ▶ Matte finish.

### Printing Tips

- ▶ Use a 86 t/in (34 t/cm) for large areas, 195 t/in (77 t/cm) for fine line.
- ▶ If printing a large area, lightweight fabric may pucker. To minimize puckering, print a mezzotint or dot pattern (80% solid).
- ▶ For Pantone® Colors choose the Pantone® Color two shades darker as color will lighten.
- ▶ Use a slightly rounded squeegee for large area and high puff requirements.

### Compliance

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

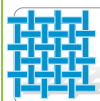
### Precautions

- ▶ 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.
- ▶ Additions of 10520PFXFLEX Epic Flexipuff Additive in excess of 30% by weight of ink may result in poor ink film formation during cure.
- ▶ Ensure sufficient ink is printed to ensure required puff height is produced.
- ▶ Do not add to Epic Transflex or Epic NuPuff Inks.
- ▶ Reducing viscosity will adversely affect opacity and puff height. 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.
- ▶ Pretest all fabrics for dye migration.
- ▶ 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, some synthetics



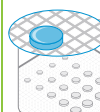
#### Mesh

Counts: 61-196 t/in (24-77 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



#### Squeegee

Durometer: 60-80, 70/90/70  
Edge: Slightly Rounded for large area, Sharp for fine detail  
Stroke: Medium-Slow  
*\*Do not use excess squeegee pressure.*



#### Non-Phthalate Stencil

Direct: 2 over 2  
Capillary/Thick Film: N/A  
Off Contact: 1/16" (.2 cm)



#### Flash & Cure Temperatures

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



#### Pigment Loading

EQ: See relevant PIB  
MX: See relevant PIB.  
PC: See relevant PIB.  
*\*All percentages listed at % by weight.*



#### Epic Additives

Extender: Add up to 30% by weight of Flexipuff 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 degradant or press wash.



#### Health & Safety

MSDS: [www.polyone.com](http://www.polyone.com) or  
Contact your local CSR.