



18600PFXPB EPIC™ PERFORMANCE BASE

WILFLEX™ Epic Performance inks are non-phthalate plastisol inks designed to print onto a variety of specialty fabrics, including performance athletic stretch polyester and polyester blended fabrics.

HIGHLIGHTS

- Mix with Wilflex™ PCs or EQualizers
- Low cure, save energy, reduce bleed defects
- Semi-opaque to opaque colors
- Good bleed resistance, reducing the need to underbase on polyesters
- Good color fastness to crocking test

PRINTING TIPS

- Use consistent, high-tensioned screen mesh and sharp edged squeegees for best print results
- When blended according to formulations, colors will be semi-opaque to opaque
- Exhibits good color reproduction on white garment and over a base plate. For some colors, base mixing systems are limited in color saturation and may require an increased ink deposit or formula adjustment to achieve accurate color
- Use a printing technique to assure a good ink deposit to maximize bleed resistance and film strength properties
- Performance Base is a low bleed mixing base. For challenging fabrics using sublimation dyes, a bleed blocking underbase such as EPIC ARMOR LC may be required
- Adjust flash cure temperature and dwell time so ink is just dry to touch. Depending on flash unit, a 2 - 3 second flash is adequate
- Curing is a time and temperature process, a lower oven temperature setting with a slower belt speed while maintaining recommended ink cure temperature is always best to protect fabric, control dye migration and reduce energy consumption

COMPLIANCE

- Non-phthalate
- For individual compliance certifications and conformity statements, please visit: www.avient.com/wilflex-compliance

PRECAUTIONS

The information above is given in good faith and does not release you from testing inks and fabrics to confirm suitability of substrate and application process to meet your customer standards and specifications



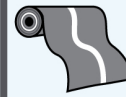
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INKS

V3.00 (Modified: 02/18/2021)

PRODUCT INFORMATION BULLETIN



RECOMMENDED PARAMETERS



Fabric Types

100% polyester, poly blends, 100% nylon Jersey, 100% cotton, cotton/Lycra blends, spandex *not suitable for all nylon substrates. Pretest prior to production



Mesh

Count: 86-230 t/in (34-90 t/cm)
Tension: 25-35 n/cm2



Squeegee

60/90/60, 60-70
Profile: Square, Sharp
Stroke: Hard Flood, Medium-Fast stroke
Angle: 10-15%



Stencil

2 over 2
Off Contact: 1/16" (.2cm)
Emulsion Over Mesh: 15-20%



Flash & Cure

Flash: 220°F (105°C)
Cure: 290°F (143°C)



Pigment Loading



Wilflex™ Additives

Epic Viscosity Buster-1% max



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

Find SDS information here:
www.avient.com/resources/safety-data-sheets
or contact your local CSR

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