

## 10009PFXHDC Epic HD Clear 2

Wilflex™ Epic HD Clear 2 is a non-phthalate clear developed to create the appearance of glass, gel, water or high gloss surfaces. Epic HD Clear 2 can be used in High Density applications or blended with other texture inks to create unique effects. It is also an effective adhesive carrier for foil, flock, and other applications.

### Highlights

- ▶ High gel, gloss appearance.
- ▶ Excellent adhesion to fabrics.
- ▶ Excellent elongation.
- ▶ Excellent wash properties.
- ▶ Can be used on light or dark grounds.
- ▶ Use as a clear overprint on colors and metallic inks to increase color vibrancy and create gloss surfaces.
- ▶ Use as a clear carrier/adhesive for caviar beads.
- ▶ Use as a High Density Clear, either on its own or with color addition.

### Printing Tips

- ▶ Can be mixed with Epic PCs, Epic EQs, or Epic MX to create custom colors. Add up to 10% by weight.
- ▶ A heavy flood stroke that fully fills the open areas of the stencil with ink is recommended.
- ▶ Use a print-flash-print method to build ink density. Do not print wet-on-wet.
- ▶ Surface of clear will appear milky after flashing, but this effect will disappear after Epic HD Clear 2 is totally cured.

### Compliance

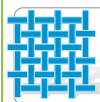
- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit [www.wilflex.com/compliance](http://www.wilflex.com/compliance).

### 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.
- ▶ Epic HD Clear 2 cures at 350°F (175°C). Ensure the entire ink film reaches 350°F.
- ▶ When printing over colors, it is recommended that you evaluate the color and the clear before production because of the potential of the clear to change in appearance when overprinted onto colors. Flash colors before overprinting.
- ▶ Pretest before printing caviar beads on polyester blends, as dye migration can affect the appearance of the bead.
- ▶ Dyestuffs inherent in the garment fabric can change the clarity and color of this clear ink during curing.
- ▶ 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)



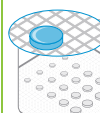
**Fabric Types**  
100% cotton, blends, acrylic, Lycra & uncoated nylon



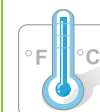
**Mesh**  
Counts: 24-110 t/in (9-43 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



**Squeegee**  
Durometer: 75, 60/90/60  
Edge: Sharp  
Stroke: Slow  
*\*Do not use excess squeegee pressure.*



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



**Flash & Cure Temperatures**  
Flash: 160°F (70°C)  
Cure: 350°F (175°C)



**Pigment Loading**  
EQ: 10% max  
MX: 10% max  
PC: 10% max  
*\*All percentages listed at % by weight.*



**Epic Additives**  
Extender: N/A  
Reducer: Epic Viscosity Buster-3% 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 degradant or press wash.



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