

## 10088PFXHDC Epic HD Sharp Clear

Wilflex™ Epic HD Sharp Clear is a non-phthalate special effect clear developed to create high resolution graphics with sharp detail. Epic HD Sharp Clear can be used in high density applications or blended with other texture inks to create unique effects.

### Highlights

- ▶ Satin finish, dry hand feel.
- ▶ Super straight-edge definition, excellent sharp-corner properties.
- ▶ Excellent elongation.
- ▶ Excellent wash properties.
- ▶ Excellent adhesion to fabrics.
- ▶ Use Epic HD Sharp Clear, either on its own or with color addition. May be overprinted with colors.
- ▶ Used in conjunction with other special effect bases, Epic HD Sharp Clear can create unique textures and design effects.
- ▶ Excellent for neoprene and other stretch fabrics.
- ▶ Greatly increases production efficiency of high density printing due to excellent stacking properties.

### Printing Tips

- ▶ Can be mixed with Epic PCs, Epic EQs, or Epic MX to create custom colors. Add up to 10% by weight.
- ▶ Use as a clear overprint on colors and metallic inks to improve crock resistance and hand feel. Pretest before beginning production. Clarity may vary slightly depending on thickness of ink deposit.
- ▶ Use a print-flash-print method to build ink density. Do not print wet-on-wet.
- ▶ A heavy flood stroke that fully fills the open areas of the stencil with ink is recommended.
- ▶ Ink will appear slightly milky after flashing with clarity achieved after full cure.
- ▶ Cure temperatures in excess of 350°F during curing will result in a tacky hand feel, rounded edges, and an increase in gloss.
- ▶ When formulating custom formulas use Wilflex Ink Room Management Software to ensure formulas are balanced for optimal print, wash, and cure performance.

### Compliance

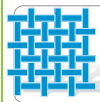
- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit [www.wilflex.com/compliance](http://www.wilflex.com/compliance).

### 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 Sharp Clear cures at 325°F (170°C). Ensure the entire ink film reaches 325°F.
- ▶ 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)



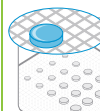
**Fabric Types**  
100% cotton, blends, acrylic, Lycra & uncoated nylon, & neoprene



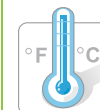
**Mesh**  
Counts: 86-196 t/in (34-77 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



**Squeegee**  
Durometer: 75, 60/90/60  
Edge: Sharp  
Stroke: Medium  
*\*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: 320°F (160°C)-340°F (171°C)  
Entire Ink Film



**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 degradent or press wash.



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