

## 10099PFXATH Epic Athletic LB Base

Wilflex™ Epic Athletic LB Base is a non-phthalate, low-bleed plastisol ink with excellent opacity, brightness, and dye bleed resistance designed for printing on fabrics prone to dye migration, such as polyesters and poly/cotton blends

### Highlights

- ▶ Excellent bleed resistance.
- ▶ Fast flashing with minimal after-tack.

### Printing Tips

- ▶ To optimize bleed resistance, set the dryer belt at the highest possible speed while still ensuring that the ink film reaches 320°F. This ensures that the ink's heat exposure is minimal.
- ▶ Suggestions for automatic printing: Print 130 mesh screen - Flash - Print 86 mesh screen. Use minimal pressure on first print.
- ▶ Polyester fabrics are likely to have dye migration issues. To determine a material's bleed potential, please reference the testing procedures outlined in the Wilflex User's Manual.
- ▶ Use consistent, high-tensioned screen mesh to optimize performance properties.
- ▶ To increase production speeds, use finer mesh counts for the flash plate to decrease gel time. Set flash dwell times on heated pallets to simulate production. Adjust your settings so that the ink is just dry to the touch.

### 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.
- ▶ Avoid over flashing as it can result in poor intercoat adhesion of colors.
- ▶ When processed properly, Epic Athletic LB Base will not ghost.
- ▶ 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)



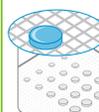
**Fabric Types**  
100% cotton, cotton blends, 100% polyester



**Mesh**  
Counts: 86-230 t/in (34-91 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



**Squeegee**  
Durometer: 60-70, 60/90/60  
Edge: Square, sharp  
Stroke: Hard flood, Medium speed  
*\*Do not use excess squeegee pressure.*



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



**Flash & Cure Temperatures**  
Flash: 160°F (70°C)  
Cure: 320°F (160°C)



**Pigment Loading**  
EQ: N/A  
MX: 25% max  
PC: 20% 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.