

**11422PFXMSH Epic Nylon Mesh Base**  
**19000PFXMSH Epic Nylon Mesh Black**

Wilflex™ Epic Nylon Mesh Base is a non-phthalate ink designed to print directly onto 100% Nylon open mesh and dazzle cloth. Epic Nylon Mesh Base can be used with Epic PCs or EQs to produce highly durable graphics.

**Highlights**

- ▶ High gloss finish.
- ▶ Excellent durability.
- ▶ Excellent adhesion to fabrics.

**Printing Tips**

▶ Epic Nylon Mesh Base will not adhere to nylon jackets or water-repellent fabrics without the addition of Epic Hugger Catalyst. If the material has been treated to repel water, the waterproofing must be removed and the addition of the Epic Hugger Catalyst at 10% by weight will be necessary. Wipe down the print area with rubbing alcohol or acetone if printing on a tightly woven material.

**Compliance**

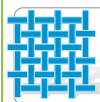
- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit [www.wilflex.com/compliance](http://www.wilflex.com/compliance).

**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.
- ▶ Ink mixed with Epic Hugger Catalyst must be removed from the screen immediately following printing using cleaning solvents to prevent permanent mesh damage. Squeegees and any other printing apparatus must also be cleaned immediately.
- ▶ Epic Hugger Catalyst activates upon exposure to moisture in the air. The amount of moisture exposure determines the shelf life of the mixed ink. Pot life generally ranges from 4-8 hours.
- ▶ Maximum amount of Epic Hugger Catalyst is 10% by weight.
- ▶ The cross linking reaction between the catalyst and ink takes approximately 48-72 hours to fully bond to the fabric. Scratch testing should not be conducted immediately following printing.
- ▶ Open Epic Hugger Catalyst containers should be squeezed to push air out of the bottle and then sealed tightly. If left opened or loosely sealed, Epic Hugger Catalyst will solidify in the bottle.
- ▶ Avoid over flashing as it can result in poor intercoat adhesion of colors.
- ▶ 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)



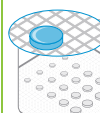
**Fabric Types**  
 Untreated 100% nylon mesh, dazzle cloth



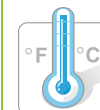
**Mesh**  
 Counts: 61-196 t/in (24-77 t/cm)  
 Tension: 25-35 n/cm<sup>2</sup>



**Squeegee**  
 Durometer: 60-90  
 Edge: Straight  
 Stroke: Medium  
*\*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: 300°F (150°C)



**Pigment Loading**  
 EQ: 25% max  
 MX: N/A  
 PC: 15% 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.