

## 14000PFB Epic Echo Mixing Base

Wilflex™ Epic Echo Mixing Base is a specially formulated, highly opaque non-phthalate base for Epic PC and Epic EQualizer mixing systems. Designed for high productivity, wet-on-wet printing, Epic Echo Mixing Base offers exceptional print qualities for both manual and automatic prints.

### Highlights

- ▶ Matte finish.
- ▶ Excellent flash properties.
- ▶ High opacity.
- ▶ Build-up resistant for high productivity printing

### Printing Tips

- ▶ For one-hit opacity through coarse meshes, use a coating procedure that builds a thick, even stencil to ensure a good column height of ink.
- ▶ For cotton fabrics, underbase with 11335PFW Epic Sprint White.
- ▶ For polyester fabrics, underbase with 11835PFW Epic Quick White, 11117PFW Epic Polywhite, or 11195PFW Epic Athletic LB White.
- ▶ For cold-peel transfers, use a coated release paper

### Compliance

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

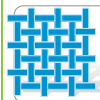
### Precautions

- ▶ 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.
- ▶ Avoid polyester fabrics where dye migration will occur.
- ▶ Wilflex inks have been carefully designed to perform within a given viscosity range. Any alteration of viscosity should be minimized.
- ▶ 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/poly blends, some nylon (generally open weave or mesh types) as well as other synthetics



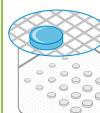
#### Mesh

Counts: 86 - 305 t/in (34 - 120 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



#### Squeegee

Durometer: 70/90/70  
Edge: Square, Sharp  
Stroke: Medium for opacity. Fast for High Production.  
*\*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: 160-180°F (70-80°C)  
Cure: 320°F (160°C) entire film



#### Pigment Loading

EQ: Use IMS System.  
MX: Use IMS System.  
PC: Use IMS System.  
*\*All percentages listed at % by weight.*



#### Epic Additives

Extender: Epic Extender Base-20% max  
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.