

15545PFXUBG Epic Underbase Gray EU

Wilflex™ Epic Underbase Gray EU is a premium plastisol ink designed to prevent dye migration on 100% polyester, poly/synthetic blends, cotton/poly blends and 100% cotton fabrics containing highly migrating dyes such as camouflage.

Highlights

- ▶ High performance, bleed-resistant technology.
- ▶ Works on a variety of fabrics.
- ▶ Excellent elasticity.
- ▶ Smooth surface.
- ▶ Matte finish.
- ▶ Prints easily through recommended meshes.

Printing Tips

- ▶ Print Underbase Gray so that the flashed ink deposit fully covers the underlying fabric.
- ▶ Overprint with Epic Performance low-bleed inks, white and/or colors.
- ▶ Best results achieved using recommended mesh counts.
- ▶ Use consistent, high-tension screens to optimize performance.
- ▶ To optimize performance, minimize the fabric's exposure to heat. Adjust the dryer belt speed to highest setting while ensuring that entire ink film still reaches 290°F (145°C).

Compliance

- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit www.wilflex.com/compliance.

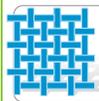
Precautions

- ▶ 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.
- ▶ Due to difference in heat and moisture absorption rates between fabrics, the oven settings will require adjustments when switching from one fabric to another.
- ▶ 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.
- ▶ Avoid over flashing as it can result in poor intercoat adhesion of colors.
- ▶ Reducing viscosity will adversely affect opacity.
- ▶ 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



Fabric Types

100% polyester, polyester blends, 100% nylon Jersey, 100% cotton, cotton/poly blends, cotton/Lycra blends, spandex
*Not suitable for all nylon substrates



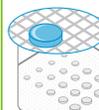
Mesh

Counts: 86-140 t/in (34-60 t/cm)
Tension: 25-35 n/cm²



Squeegee

Durometer: 70, 80
Edge: Square, Sharp
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: 320°F (160°C)



Pigment Loading

EQ: N/A
MX: N/A
PC: N/A
*All percentages listed at % by weight.



Epic Additives

Extender: N/A
Reducer: Epic Viscosity Buster-1% 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 or
Contact your local CSR.