

- e 49858TFX Epic TFX Process Magenta
- 69858TFX Epic TFX Process Blue
- 89858TFX Epic TFX Process Yellow
- 19000TFX Epic TFX Soft Black

Wilflex™ Epic Transflex process inks have been specially formulated to produce 4-color process heat release transfers that exhibit superb color when using with full photographic, airbrush and spot process quality graphics. The base used is the 10007TFX Epic TFX TransClear.

### Highlights

- ▶ Excellent color vibrancy.
- ▶ Soft hand, hot peel inks.
- ▶ Excellent elongation. Excellent wash fastness.
- ▶ Compatible with all other Epic Transflex transfer inks.

### Printing Tips

- ▶ The standard printing sequence for the process colors is as follows: 1) Black, 2) Blue, 3) Magenta, 4) Yellow.
- ▶ If Epic TFX TransClear is used as the hot-peel coat, be sure that the TransClear is printed first on the paper. Recommended mesh for the first-down TransClear is 305-355 t/in (120-140 t/cm).
- ▶ Adjustments to the drying mechanism may be required as the variables of different drying (heat) types, length of dryer conveyor and drying units, will affect the overall transfer finish.
- ▶ The majority of standard transfer papers can be used with confidence. If a softer-feel transfer is required, an uncoated transfer paper is recommended. In most cases, a hotsplit/hot-peel transfer paper will be required.
- ▶ Lower temps will result in a transfer with little tensile strength, and higher temps will negatively affect the "split" of the final transfer.

### Compliance

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

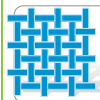
### Precautions

- ▶ 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.
- ▶ Preprint, transfer and test all fabrics for desired properties before beginning production printing.
- ▶ Turn the garment inside-out when washing and drying to keep the transfer looking its best.
- ▶ Examine the fabric type and color before and after the application of the transfer, as color distortion may occur due to the introduction of heat to sensitive fabric types and dyestuffs inherent in the garment.
- ▶ It is advisable to press the blank shirt under transfer press before applying transfer to reduce moisture in garment.
- ▶ Stir plastisols prior to printing.
- ▶ Do not dry clean, bleach or iron the printed area.
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- ▶ **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

Cotton, cotton blends, rayon, linen and lycra. NOT recommended for nylon or satin fabrics.



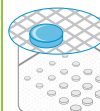
#### Mesh

Counts: 305-355 t/in (120-140 t/cm) recommended  
Tension: 25-35 n/cm<sup>2</sup> recommended



#### Squeegee

Durometer: 60-80 durometer, Straight edge  
Edge: Sharp, square  
Stroke: Medium flood and speed  
*\*Do not use excess squeegee pressure.*



#### Non-Phthalate Stencil

Direct: 2 over 2  
Capillary/Thick Film: N/A  
Off Contact: 1/16" (.2cm) or lower



#### Flash & Cure Temperatures

Flash: 240-270 °F (115-130 °C)  
Cure: 375 °F (190 °C) entire film



#### Pigment Loading

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



#### Epic Additives

Extender: N/A  
Reducer: N/A  
*\*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](http://www.polyone.com) or  
Contact your local CSR.