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.

**Recommended Parameters**

- **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/cm²
- **Squeegee**: Durometer: 70/90/70 Edge: Square, Sharp Stroke: Medium for opacity. Fast for High Production. *Do not use excessive squeegee pressure.*
- **Non-Phthalate Stencil**: Direct: 2 over 2 Capillary/Thick Film: N/A Off Contact: 1/16” (.2 cm)
- **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 degradant or press wash.
- **Health & Safety**: MSDS: www.polyone.com or Contact your local CSR.

**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.

**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

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