



## WILFLEX® EPIC COLOR MATCHING SYSTEM

### DESCRIPTION

The Wilflex Epic new ink technology color mixing system has been specially formulated with non-phthalate plasticizers. It is an easy-to-use, easy-to-mix color mixing system with 15 intermixable colors that enables printers to produce simulations of coated and uncoated PANTONE® Color Formula Guide colors on white and dark (with white underlay) garments. Epic inks produce soft hand inks for high production, wet-on-wet printing, offering a matte finish and improved crock resistance

### PRINTER'S PARAMETERS

<b>Substrates</b>	100% cotton, cotton blends, some synthetics
<b>Bleed resistance</b>	None, use 1100PFW BR White as an underbase if bleed resistance is required
<b>Mesh</b>	156-305 t/in (43-120 t/cm)
<b>Squeegee</b>	60 to 90 durometer, straight edge blade
<b>Emulsion</b>	Phthalate-free emulsions of choice
<b>Cure temp</b>	320 F (160 C) entire film
<b>Extender</b>	10000PFX Epic non-phthalate plasticizer extender ONLY
<b>Reducer</b>	No modification of Epic inks is recommended
<b>Storage</b>	65-90 F (18-32 C). Avoid direct sun. Use within one year of receipt.
<b>Wash-up</b>	Wilflex Screen Wash
<b>Health &amp; Safety data</b>	Available upon request. Formulated to comply with EN71 and ASTM F9-63.

### MIXING GUIDELINES

Epic colors are created to mirror MX Mixing colors. For Pantone simulations, simply follow the MX formulas in the Wilflex MX Formula Guide. Epic formulas that reproduce PANTONE® color simulations have been calculated by weight and are presented as a total of 1,000 grams in the Formulation Guide. The final volume of ink produced from these formulas will vary according to color and the specific gravity of the ink concerned, but all formulas will make approximately 1 quart/1 liter.

### NON-CONTAMINATION OF EPIC INKS

- Do not add or mix non-Epic, phthalate-containing inks, additives or extenders with the Epic ink products.

- Use only Epic inks and Epic extenders together.
- Under normal printing parameters, the Wilflex Epic inks are ready to use straight out of the container, without the additives.
- Do not dilute or modify Epic inks with alien products, other than those recommended by PolyOne.
- When mixing, all buckets, palette knives and stirring apparatus must be cleaned properly and free of phthalate-containing inks.
- All squeegees, flood bars and screens must be cleaned properly to remove phthalate-containing inks before printing Epic.

FAILURE TO ADHERE TO THESE VITAL INSTRUCTIONS MAY EXPOSE YOU TO LEGAL CONSEQUENCES FROM YOUR CUSTOMERS WHO HAVE REQUESTED NON-PHTHALATE PLASTICIZERS IN THEIR PRINTS.

### SPECIAL RECOMMENDATIONS

- Inks produced from the EPIC Mixing System are translucent to opaque. When blended according to formulations, resulting colors vary in opacity from translucent to semi-opaque.
- Colors will reproduce best on white or light fabrics.
- An approved PF White such as 11001PFW Epic Cotton White may be used as an underbase and highlight white for 100 percent cotton ONLY. If bleed resistance is required, use 11000PFW Epic BR White.
- For consistency, all formulas provided were printed through 156 t/in (62 t/cm) mesh screen on white, 100 percent cotton fabric for color approval. Wilflex EPIC Mixing Inks can, however, be printed through a range of meshes between 110T and 305 t/in (43-120 t/cm). Variation in screen mesh and ink deposit can result in variation in depth of color and opacity.
- All EPIC Mixing Inks colors were developed using Genesis technology and can be printed wet-on-wet with exceptional resistance to build-up.
- Perform fusion tests before production. Failure to cure ink properly can result in poor wash fastness, inferior adhesion, unacceptable durability, and increased likelihood of dye migration. Testing procedures for plastisol fusion are outlined in the Wilflex User's Manual.
- Stir plastisols prior to printing. This product has a unique viscosity. Upon opening a container that has been unused for several days or weeks, it will appear slightly thick. Stir to easily restore the creamy texture.
- Do not dry clean, bleach or iron the printed area.
- Any application not referenced in this product information bulletin should be pre-tested or

consultation sought with Wilflex Technical Services  
Department prior to printing (US - 800-735-4353).

#### **ORDERING INFORMATION**

11888PFX Epic PF White  
19888PFX Epic PF Black  
38888PFX Epic PF Orange  
48888PFX Epic PF Red  
48889PFX Epic PF Magenta  
58888PFX Epic PF Violet  
68888PFX Epic PF Marine  
68889PFX Epic PF Blue

78888PFX Epic PF Green  
88888PFX Epic PF Yellow  
98880PFX Epic PF Fluorescent Pink  
98884PFX Epic PF Fluorescent Red  
98885PFX Epic PF Fluorescent Purple  
98886PFX Epic PF Fluorescent Blue  
98888PFX Epic PF Fluorescent Yellow

11000PFW Epic BR White  
11001PFW Epic Cotton White  
10000PFX Epic PF Extender

Wilflex EPIC ink formulations for screen process printing produce simulations of PANTONE® Colors in this color reproduction method due to differences in ink film, opacity, pigment selection, and substrate. The pigment selection used in blending screen process inks may cause metamerism. EPIC inks were matched under Cool White Fluorescent 4100K illuminant. Pantone, Inc. assumes no responsibility for formula accuracy. PANTONE® is Pantone, Inc.'s check-standard trademark for color. Portions® Pantone, Inc., 1963,1991.

Effective 11/27/02. Not all Wilflex products are available in every country. The information in this publication is based on information and experience believed reliable. Since many factors may affect processing for an application, processors must carry out their own tests and experiments to confirm suitability for intended use. You must make your own determination of suitability for your intended use and environmental acceptability, the safety and health of your employees, and purchasers of your product.

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