

## 10650PFXSCP Epic Sculpture Base

Wilflex™ Epic Sculpture Base is a specially formulated non-phthalate plastisol ink base designed for high density printing. Printed images can have either a smooth or textured surface depending on mesh counts and printing parameters. Epic Sculpture Base also controls the smallest design details—even with high density printing.

### Highlights

- ▶ Smooth high density textured base.
- ▶ Tough and stretchable.
- ▶ Excellent adhesion to fabrics.
- ▶ Can be used on light or dark grounds.
- ▶ Excellent wash properties.
- ▶ Can be used in high density or conventional flat screens.

### Printing Tips

- ▶ Can be mixed with Epic PCs, Epic EQs, or Epic MX to create custom colors.
- ▶ Print through high density screens for raised surfaces.
- ▶ Use a print-flash-print method to build ink density.
- ▶ Adjust cure temp and dwell time to achieve desired surface effect.
- ▶ Can be used alone or in combination with other Epic products to create various specialty effects.

### 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.
- ▶ Adding too much pigment or finished ink for color purposes may change the intended performance properties of the base.
- ▶ Variable cure temperatures will affect the surface texture and feel of the ink.
- ▶ 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)



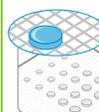
**Fabric Types**  
100% cotton, cotton blends



**Mesh**  
Counts: 86-230 t/in (34-91 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



**Squeegee**  
Durometer: 75, 70/90/70  
Edge: Square, Sharp  
Stroke: Medium  
*\*Do not use excess squeegee pressure.*



**Non-Phthalate Stencil**  
Direct: 2 over 2  
Capillary/Thick Film: 200-400 microns  
Off Contact: 1/16" (.2cm)



**Flash & Cure Temperatures**  
Flash: 160°F (70°C)  
Cure: 320°F (160°C)-340°F (171°C)



**Pigment Loading**  
EQ: 10% max  
MX: Use IMS System.  
PC: 10% max  
*\*All percentages listed at % by weight.*



**Epic Additives**  
Extender: N/A  
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.