

## e 10425PFXNS Epic Natural Suede Base

Wilflex Epic Natural Suede Base is a specially formulated plastisol ink that is non-phthalate. Epic Natural Suede Base can be used to produce a printed graphic with a soft, Suede or Velvet finish that is also highly durable. Epic Natural Suede can be combined with other Epic special effect bases to simulate leather or other textured surfaces.

### Highlights

- ▶ Compliant with CPSIA (Consumer Product Safety Improvement Act) 2008, Section 101, Lead Content in Substrates (<300 ppm lead); 16 CFR, Part 1303, Lead in Paint (<90 ppm lead); and CPSIA 2008, Section 108, Phthalates (<.1% DEHP, DBP, BBP, DINP, DIDP, DNOP).
- ▶ Eco-Passport Certified.
- ▶ Epic Natural Suede is a direct-print ink system.
- ▶ Creates a printed graphic that feels like suede.
- ▶ Use on light or dark colored textiles.
- ▶ Highly durable with excellent wash resistance.
- ▶ No odor.
- ▶ Easy to print and use. Suitable for manual or automatic presses.



### Printing Tips

- ▶ Limit pigment loading to keep finished texture soft and fuzzy.
- ▶ Adjust cure temp and rate to achieve desired surface effect.
- ▶ Mix with other special Epic effect bases to change the textured surface.
- ▶ Print through high-density screens for raised surfaces.
- ▶ Use firm flood stroke and medium print stroke to maintain detail.



### 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.
- ▶ Variable cure temperatures will affect the surface texture and feel of the suede ink. Preprint and test all fabrics for dye migration.
- ▶ Stir plastisols prior to 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 the Epic ink products.
  - ▶ 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.
  - ▶ Non-phthalate emulsions and pallet adhesives must be used.
- ▶ Any application not referred in this product bulletin should be pre-tested or consultation sought with Technical Services Department prior to printing.
- ▶ Email: techserviceswilflex@polyone.com

## Printing Parameters

Opacity	8	
Bleed Resistance	3	
Smooth Surface	6	
Flash	7	
Gloss	N/A	
Printability	9	



#### Fabric Types

100% Cotton, Cotton Blends



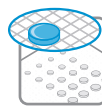
#### Mesh

Counts: 86-230 t/in (34-90 t/cm) recommended  
Tension: 25-35 n/cm<sup>2</sup> recommended



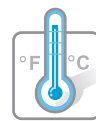
#### Squeegee

Durometer: 60-75 or 70/90/70  
Edge: Square  
Stroke: Medium



#### Stencil

non-phthalate  
Direct: 2 over 2  
Capillary/  
thick film: 200-400 micron  
Off contact: 1/16" (.2 cm)



#### Gel/Cure Temperatures

Gel: 185°F (85°C)  
Cure: 320°F (170°C) Entire film.  
Higher temps required for  
extreme ink deposits.



#### Epic Pigment Loading

MX: 25% max by weight  
EQs: 15% max by weight  
PCs: 10% max by weight



#### Additives

Extender: none  
Reducer: 3% - 10025VB QEC Viscosity  
Buster



#### Storage

65°-90°F (18°-32°C)  
Avoid direct sun.  
Use within one year of receipt.



#### Clean Up

Wilflex screen wash



#### Health & Safety

MSDS: www.polyone.com

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