



## 18600PFXPB EPIC™ PERFORMANCE BASE

WILFLEX™ Epic Performance inks are non-phthalate plastisol inks designed to print onto a variety of specialty fabrics, including performance athletic stretch polyester and polyester blended fabrics.

### HIGHLIGHTS

- Mix with Wilflex™ PCs or EQualizers
- Low cure, save energy, reduce bleed defects
- Semi-opaque to opaque colors
- Good bleed resistance, reducing the need to underbase on polyesters
- Good color fastness to crocking test

### PRINTING TIPS

- Use consistent, high-tensioned screen mesh and sharp edged squeegees for best print results
- When blended according to formulations, colors will be semi-opaque to opaque
- Exhibits good color reproduction on white garment and over a base plate. For some colors, base mixing systems are limited in color saturation and may require an increased ink deposit or formula adjustment to achieve accurate color
- Use a printing technique to assure a good ink deposit to maximize bleed resistance and film strength properties
- Performance Base is a low bleed mixing base. For challenging fabrics using sublimation dyes, a bleed blocking underbase such as EPIC ARMOR LC may be required
- Adjust flash cure temperature and dwell time so ink is just dry to touch. Depending on flash unit, a 2 - 3 second flash is adequate
- Curing is a time and temperature process, a lower oven temperature setting with a slower belt speed while maintaining recommended ink cure temperature is always best to protect fabric, control dye migration and reduce energy consumption

### COMPLIANCE

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

### PRECAUTIONS

The information above is given in good faith and does not release you from testing inks and fabrics to confirm suitability of substrate and application process to meet your customer standards and specifications



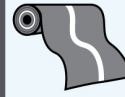
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V3.02 (Modified: 05/13/2022)

## PRODUCT INFORMATION BULLETIN



### RECOMMENDED PARAMETERS



#### Fabric Types

100% polyester, poly blends, 100% nylon Jersey, 100% cotton, cotton/Lycra blends, spandex \*not suitable for all nylon substrates. Pretest prior to production



#### Mesh

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



#### Squeegee

Durometer: 60/90/60, 60-70  
Profile: Square, Sharp  
Stroke: Hard Flood, Medium-Fast stroke  
Angle: 10-15%



#### Stencil

2 over 2  
Off Contact: 1/16" (.2cm)  
Emulsion Over Mesh: 15-20%



#### Flash & Cure

Flash: 220°F (105°C)  
Cure: 290°F (143°C)



#### Pigment Loading

EQ: Refer to IMS  
PC: Refer to IMS  
MX: N/A  
RIO: N/A



#### Wilflex™ Additives

Epic Viscosity Buster-1% max



#### 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

Find SDS information here:  
[www.avient.com/resources/safety-data-sheets](http://www.avient.com/resources/safety-data-sheets)  
or contact your local CSR