

18000PFXCB Epic Cork Base

Wilflex™ Epic Cork Base is a specially formulated non-phthalate base developed to simulate the texture of cork. The ink surface is soft to the touch, yet highly durable and stretchable. Epic Cork base can be used in all types of printing applications including high, medium, and low density prints.

Highlights

- ▶ Elevated smooth, cork effect texture for use with fashion design concepts.
- ▶ Tough and stretchable.
- ▶ Excellent adhesion to fabrics.
- ▶ Can be used on light or dark grounds.
- ▶ Can be printed direct to garment or over an underbase.
- ▶ Can be printed through flat screen meshes or high density films.

Printing Tips

- ▶ Can be mixed with Epic PCs, Epic EQs, or Epic MX to create custom colors. Add up to 10% by weight.
- ▶ Best results when printed directly onto fabric.
- ▶ A heavy flood stroke that fully fills the open areas of the stencil with ink is recommended.
- ▶ Use a print-flash-print method to build ink density.
- ▶ Changing ink cure temperature will affect surface texture and feel of the ink.

Compliance

- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit www.wilflex.com/compliance.

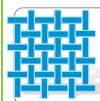
Precautions

- ▶ 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.
- ▶ Use an appropriate low-bleed underbase on polyester fabrics.
- ▶ Pretest all fabrics for dye migration.
- ▶ 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



Fabric Types

100% cotton, cotton blends, Lycra, denim



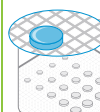
Mesh

Counts: 61-230 t/in (24-91 t/cm)
Tension: 25-35 n/cm²



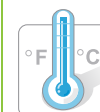
Squeegee

Durometer: 60-70, 60/90/60
Edge: Square, Sharp
Stroke: Medium
**Do not use excess squeegee pressure.*



Non-Phthalate Stencil

Direct: 2 over 2
Capillary/Thick Film: up to 400 microns
Off Contact: 1/16" (.2cm)



Flash & Cure Temperatures

Flash: 160°F (70°C)
Cure: 300°F (150°C)



Pigment Loading

EQ: 10% max
MX: 10% max
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 degradant or press wash.



Health & Safety

MSDS: www.polyone.com or
Contact your local CSR.