



## 17600LBFF EPIC™ TOP SCORE LBFF BASE

WILFLEX™ Epic Top Score Base is a non-phthalate plastisol ink designed to meet the changing demands of the athletic market by delivering a solution for printing on polyester substrates that require low cure temperatures.

### HIGHLIGHTS

- Mix with Wilflex™ PCs or EQualizers
- Good bleed resistance, reducing the need to underbase on polyesters
- Semi-opaque colors
- Matte finish with low surface tack
- 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
- 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
- Top Score LBFF 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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V1.00 (Modified: 11/30/2020)

## PRODUCT INFORMATION BULLETIN

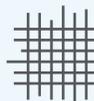


### RECOMMENDED PARAMETERS



#### Fabric Types

100% polyester, polyester blends,  
100% nylon Jersey



#### Mesh

Count: 86-160 t/in (34-62 t/cm)  
Tension: 25-35 n/cm2



#### Squeegee

60/90/60, 60-70  
Profile: Square, Sharp  
Stroke: Hard flood, Slow-Medium  
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



#### 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

SDS: [www.avient.com/resources/safety-data-sheets](http://www.avient.com/resources/safety-data-sheets)  
Contact your local CSR