

Ideal for heat sensitive or stretch fabrics

V Low-cure, save energy

# 10005PFX EPIC™ STRETCH BASE

PRODUCT INFORMATION BULLETIN

# **RECOMMENDED PARAMETERS**

## **Fabric Types**

100% cotton, blends, acrylic, nylon, some synthetics



#### Mesh

Count: 86-230 t/in (34-90 t/cm) Tension: 25-35 n/cm2



### Squeegee

60/90/60, 60-70 Profile: Square, Sharp

Stroke: Hard flood, Medium stroke

Angle: 10-15%



#### **Stencil**

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



#### Flash & Cure

Flash: 220°F (105°C) Cure: 270°F (132°C) Entire ink film



#### **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**

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

WILFLEX™ Epic Stretch Base is a non-phthalate, low cure plastisol ink with exceptional stretch and adhesion properties. Stretch Base can be used as a first-down base, mixing base or as an additive to increase elongation properties of Wilflex inks. Available in stretch white and black standard colors.

## **HIGHLIGHTS**

- ▼ STRETCH BASE | 10005PFX STRETCH WHITE | 11000PFS STRETCH BLACK | 19000PFS
- W Mix base with Wilflex™ PCs or Equalizers or use as additive with finished inks
- W Superior adhesion to fabrics, stretch properties, and wash durability

# PRINTING TIPS

- W Use consistent, high-tensioned screen mesh and sharp edged squeegees for best print results
- When blended according to formulations, colors will be semi-opaque
- Use a printing technique to assure a good ink deposit to maximize stretch and film strength properties
- W Use as a stand-alone product for a first-down base layer to improve overall stretch of subsequent ink layers
- W Use Stretch Base as an additive to blocker, whites and finished inks for additional elongation. Add up to 25% (by weight) depending on desired properties
- Stretch Base is not a low-bleed ink; when printing on fabrics that are prone to bleed use in combination with an approved WILFLEX low bleed white and/or blocker
- 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
- W 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
- Stretch Base can be cured between 270°F 320°F (132°C 160°C)

# **COMPLIANCE**

- Non-phthalate
- For individual compliance certifications and conformity statements, please visit: 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



AVIENT SPECIALTY

V3.00 (Modified: 02/18/2021)

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