



EPIC™ ECHO MIXING BASE

EPIC™ ECHO MIXING BASE is a specially formulated, highly opaque non-phthalate base for Epic PC and Epic Equalizer mixing systems. Designed for high productivity wet-on-wet printing and offers good print quality for automatic printers.

HIGHLIGHTS

- Mix with Wilflex™ PCs or EQualizers
- Wet-on-wet printing at high production speeds with good resistance to build-up
- Translucent to semi-opaque colors
- Matte finish
- 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 vary in opacity from translucent to 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
- EPIC™ ECHO MIXING BASE is not a low-bleed ink; when printing on fabrics that are prone to bleed underbase with an approved WILFLEX low bleed white and/or blocker
- Exhibits good color retention in high-speed wet-on-wet production with exceptional resistance to build up
- 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
- For cold-peel transfers, use a coated release paper or polyester film

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



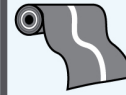
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V3.08 (Modified: 05/06/2025)

PRODUCT INFORMATION BULLETIN



RECOMMENDED PARAMETERS



Fabric Types

100% cotton, cotton/poly blends, some synthetics



Mesh

Count: 86-305 t/in (34-120 t/cm)
Tension: 25-35 n/cm2



Squeegee

Durometer: 60/90/60, 70/90/70, 60-90
Profile: Square, Sharp
Stroke: Medium 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: 320°F (160°C)



Pigment Loading

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



Wilflex™ Additives

Epic Viscosity Buster-1% max
Epic Finesse



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