

## 10022PFX Epic Luna Clear

Wilflex™ Epic Luna Clear is a clear plastisol that appears nearly invisible in daylight, but illuminates in the presence of UV blacklight. Use Epic Luna Clear to create special effects, print secret messages or identify a printer's work by printing hidden licensing data. This ink is an excellent under base that reduces fibrillation and brightens some colors. Epic Luna Clear will remain bright after numerous washings and may be printed direct or transferred.

### Highlights

- ▶ Clear when overprinting designs, but illuminates under blacklight conditions.
- ▶ Matte finish when printed through high meshes or satin through coarser meshes.
- ▶ Excellent adhesion to fabrics with good elongation.
- ▶ Excellent printability.
- ▶ Fast flashing.
- ▶ Excellent wash properties.

### Printing Tips

- ▶ For best results, follow the recommended Printing Parameters.
- ▶ Printing sequence as: Overprint clear - last color, best results when printed over bright white such as 11835PFW Epic Quick White or Fluorescent colors.
- ▶ For transfers: First-down clear - Print as first color, gel, overprint colors, gel, heat press under standard TransFlex recommendations.
- ▶ Epic Luna Clear has no built-in bleed resistance.
- ▶ Use consistent, high tensioned screen mesh to optimize performance properties.

### Compliance

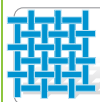
- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit [www.wilflex.com/compliance](http://www.wilflex.com/compliance).

### 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.
- ▶ Pre-test 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](mailto:techserviceswilflex@polyone.com)



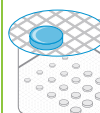
**Fabric Types**  
100% cotton, cotton blends



**Mesh**  
Counts: 110-355 t/in(43-140t/cm) recommended  
Tension: 25-35 n/cm<sup>2</sup>



**Squeegee**  
Durometer: 75, 60/90/60  
Edge: Square, Sharp  
Stroke: Medium  
*\*Do not use excess squeegee pressure.*



**Non-Phthalate Stencil**  
Direct: 2 over 2  
Capillary/Thick Film: N/A  
Off Contact: 1/16" (.2cm)



**Flash & Cure Temperatures**  
Flash: 170-190°F (75-90 °C). Transfer Gel 200-230°F(95-110 °C)  
Cure: 320 °F (160 °C) entire film. Transfer Temp 375 °F (190°C)



**Pigment Loading**  
EQ: N/A  
MX: N/A  
PC: N/A  
*\*All percentages listed at % by weight.*



**Epic Additives**  
Extender: N/A  
Reducer: N/A  
*\*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 degradent or press wash.



**Health & Safety**  
MSDS: [www.polyone.com](http://www.polyone.com) or  
Contact your local CSR.