



## EPIC™ RIO RFU COLORS

WILFLEX™ Epic Rio RFU Colors offer a range of popular industry colors formulated to be vibrant, bold and pure in color. Each color is optimized for unmatched quality and printability in a ready-for-use format. With superior opacity, printers get to color quickly even when using fine mesh screens, saving ink and money. Rio RFU Colors are low cure and designed for wet-on-wet printing and suitable for manual and automatic press.

### RECOMMENDED PARAMETERS

#### HIGHLIGHTS

- Popular industry colors, ready for use saving time to mix
- Low cure, save energy
- Opaque colors. Excellent color reproduction over base plate and white, light garments
- Wet-on-wet printing at high production speeds with good resistance to build-up
- Best color fastness
- Matte finish



#### Fabric Types

100% cotton, 100% polyester\*, triblend, polyester blends, cotton/poly blends, cotton/lycra blends, NWPB (non-woven polypropylene bags)



#### Mesh

Count: 110-305\* t/in (43-120 t/cm)  
\*See Printing Tips\*  
Tension: 25-35 n/cm2



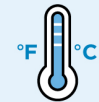
#### Squeegee

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: 266°F - 320°F (130°C - 160°C)



#### Pigment Loading

N/A



#### Wilflex™ Additives

ASI K2912 VISCOSITY BUSTER LC -1% max  
ASI K2920 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](http://www.avient.com/resources/safety-data-sheets)  
or contact your local CSR

#### PRINTING TIPS

- RIO RFU Colors can be cured between 266°F - 320°F (130°C - 160°C)
- Excellent color reproduction using 160-305 t/in (62-120 t/cm) mesh on white, light garments and over a base plate. Use finer mesh and save ink without sacrificing color accuracy.
- For best results on non-woven polypropylene bags, single print using 110-160 t/in (43-62 t/cm) mesh with a 60 or 70 single durometer squeegee
- RIO RFU Colors are not a low-bleed inks; \*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 minimal build up. Use 230 mesh or higher for best wet-on-wet printing.
- 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. Print colors using 70 duro squeegee and 110-230 t/in (43-91 t/cm) mesh followed by powdering. Gel at 212°F (100°C) for 60 sec. Apply transfer with heat press at 300°F (150°C) for 10-12 sec at medium pressure. For transfers on polyester, back with a low bleed white and/or blocker. Verify process.
- Use ASI K2920 FINESSE to extend the ink for blending colors in halftones or when garment colors allow ink opacity to be decreased. Suitable for use at 270°F (132°C)

#### 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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