



# 10012PFXPB EPIC™ PARTICLE BASE

## PRODUCT INFORMATION BULLETIN



WILFLEX™ Epic Particle Base is a non-phthalate crystal clear base specifically designed for printing glitter particles. The particle base allows for infinite creativity in designs and can be mixed with multiple colored glitter flake sizes. The Willflex Particle Base is a low-cure special effect with excellent adhesion and wash durability.

### RECOMMENDED PARAMETERS

#### HIGHLIGHTS

- ✔ Add glitter particles to base for infinite designs
- ✔ Low-cure, save energy
- ✔ Tintable with Wilflex Colorants
- ✔ Use on light or dark grounds. Provides great contrast when printed on darks
- ✔ Excellent adhesion to fabrics, stretch properties, and wash durability



#### Fabric Types

100% cotton, blends, some synthetics



#### Mesh

Count: 24-61 t/in (9-24 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



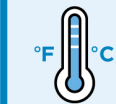
#### Squeegee

60/90/60, 60-70  
Profile: Square, Sharp  
Stroke: Hard flood, Medium stroke  
Angle: 10-15%



#### Stencil

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



#### Flash & Cure

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



#### Pigment Loading

up to 3% PC recommended  
up to 5% EQ recommended  
up to 15% RIO recommended  
up to 15% MX recommended



#### Wilflex™ Additives

Epic Curable Reducer < 10%  
Epic Finesse < 10%  
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](http://www.avient.com/resources/safety-data-sheets)  
or contact your local CSR

#### PRINTING TIPS

- ✔ Stir inks before printing
- ✔ Mix up to 15% glitter particles dependent on particle size and desired look, mix thoroughly. A particle size of .008" x .008" is a good recommendation
- ✔ Use consistent, high-tensioned screen mesh and sharp edged squeegees for best print results. Recommended mesh counts can vary depending on particle size
- ✔ Tintable with PC, Equalizer, RIO or MX finished ink colorants. See Pigment Loading section for suggested tinting percentages. Adjust the % colorant added based on the strength of the colorants and color saturation desired
- ✔ Print direct to fabric or over a flashed-dried base plate. Use a suitable underbase when printing on garments prone to bleed
- ✔ Print glitters in last position or flash after each print if using multiple screens
- ✔ Metallics reflect infrared heat and a forced air dryer is recommended for proper curing
- ✔ 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
- ✔ Particle Base can be cured between 270°F - 320°F (132°C - 160°C)
- ✔ Can be mixed with other HD special effect bases or clears

#### 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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