



2321 EPIC™ LC BASE

Wilflex™ Epic™ LC Base is a non-phthalate mixing base for manual and automatic screen printing on 100% cotton and cotton/poly blend substrates. LC Base exhibits consistent color reproduction, excellent graphic durability and efficient wet-on-wet application. Recommend cure temperature is 270°F - 320°F (132°C - 160°C).

HIGHLIGHTS

- ✔ Clean, bright colors when mixed with Wilflex™ PCs or Equalizers
- ✔ Low cure, save energy
- ✔ Semi-opaque colors
- ✔ Wet-on-wet printing at high production speeds with exceptional resistance to build-up
- ✔ Best color fastness to crocking test
- ✔ Matte finish

PRINTING TIPS

- ✔ Use consistent, high-tensioned screen mesh and sharp edged squeegees for best print results
- ✔ When blended according to formulations, colors will be 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.
- ✔ LC 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.
- ✔ 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
- ✔ LC Base can be cured between 270°F - 320°F (132°C - 160°C)
- ✔ 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

SUSTAINABILITY



Reduced Energy Use



AVIENT SPECIALTY INKS

V3.07 (Modified: 03/29/2024)

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: 270°F (132°C)
Entire ink film



Pigment Loading

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



Wilflex™ Additives

ASI Viscosity Buster-1% max
ASI Finesse Base



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