



## EPIC™ PF COLOR MIXING SYSTEM

Wilflex™ Epic™ PF color mixing system is specially formulated with non-phthalate plasticizers. It is an easy-to-use, easy-to-mix color mixing system with 17 intermixable colors that enable printers to produce Pantone® simulations. Epic™ PF inks are suitable for high production, wet-on-wet printing with a matte finish.

### HIGHLIGHTS

- Pantone® approved
- Easy and accurate color mixing with finished inks that are balanced for viscosity
- Translucent to semi-opaque colors
- Wet-on-wet printing at high production speeds with exceptional resistance to build-up
- Good 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 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™ PF Mixing Colors 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



### 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



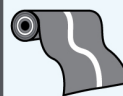
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V3.09 (Modified: 08/26/2025)

## PRODUCT INFORMATION BULLETIN



### RECOMMENDED PARAMETERS



#### Fabric Types

100% cotton, cotton blends, some synthetics



#### Mesh

Count: 110-305 t/in (43-120 t/cm)  
Tension: 25-35 n/cm<sup>2</sup>



#### 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



#### 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](http://www.avient.com/resources/safety-data-sheets)  
or contact your local CSR