

EPIC™ Rio Color Matching

Wilflex™ EPIC Rio is a non-phthalate finished ink mixing system formulated for a perfect balance of color accuracy and opacity for peak press performance and color design. It is an easy-to-use, easy-to-mix color mixing system with 18 intermixable colors that enable printers to produce accurate PANTONE® simulations. Epic RIO is the most opaque color system in our Epic line. The increase opacity helps printers get to color quicker on press even when using fine mesh screen sizes, saving printers ink and money.

Highlights

- ▶ Accurate and vibrant color match to PANTONE
- ▶ Opaque
- ▶ Soft hand prints
- ▶ Matte finish
- ▶ Wet-on-wet printing
- ▶ 18 intermixable colors
 - ▶ 110RX EPIC Rio Mixing White
 - ▶ 690RX EPIC Rio Indigo Blue
 - ▶ 190RX EPIC Rio Deep Black
 - ▶ 780RX EPIC Rio Forest Green
 - ▶ 380RX EPIC Rio Blaze Orange
 - ▶ 880RX EPIC Rio Sunshine Yellow
 - ▶ 470RX EPIC Rio Red
 - ▶ 890RX EPIC Rio Golden Yellow
 - ▶ 480RX EPIC Rio Barberry Maroon
 - ▶ 980RX EPIC Rio Electric Yellow
 - ▶ 490RX EPIC Rio Majestic Magenta
 - ▶ 960RX EPIC Rio Electric Blue
 - ▶ 580RX EPIC Rio Deep Violet
 - ▶ 950RX EPIC Rio Electric Purple
 - ▶ 670RX EPIC Rio Midnight Blue
 - ▶ 940RX EPIC Rio Electric Red
 - ▶ 680RX EPIC Rio Aquamarine
 - ▶ 900RX EPIC Rio Electric Pink

Printing Tips

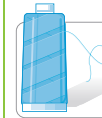
- ▶ Single print colors
- ▶ Colors will reproduce best over white - light substrate or single white base plate on dark substrates
- ▶ When direct printing over dark cotton, print-flash-print using lower mesh screens
- ▶ For cotton fabrics, underbase with 11335PFW Epic Sprint White
- ▶ For bleed resistance, use an underbase white such as 11835PFW Epic Quick White, 11480PFW EPIC Bright Tiger, 11770PFW EPIC Amazing Bright White, 11117PFW Epic Polywhite

Compliance

- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit www.wilflex.com/compliance.

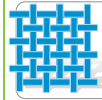
Precautions

- ▶ Perform fusion tests before production. Failure to cure ink properly may result in poor wash fastness, inferior adhesion and unacceptable durability. Flash 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/ For consistency, all formulas provided were printed through 156 t/in (62 t/cm) mesh screen on 100% white cotton fabric and over a single white base plate on 100% dark cotton fabric for color approval. Wilflex EPIC Rio can, however, be printed through a range of meshes between 110-305 t/in (43-120 t/cm). Variation in screen mesh and ink deposit can result in variation in depth of color and opacity.
- ▶ Reducing viscosity will adversely affect opacity.
- ▶ Avoid over flashing as it can result in poor intercoat adhesion of colors.
- ▶ 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



Fabric Types

100% cotton, cotton blends, some synthetics



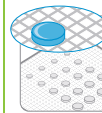
Mesh

Counts: 110-305 t/in (43-120 t/cm)
Tension: 25-35 n/cm²



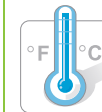
Squeegee

Durometer: 60-90, 70/90, 70/90/70
Edge: Sharp
Stroke: Hard flood, fast stroke
**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: 220°F (105°F) for 3 - 5 seconds
Cure: 300°F (150°C)



Pigment Loading

EQ: N/A
MX: Use IMS System
PC: N/A
**All percentages listed at % by weight.*



Epic Additives

Extender: N/A
Reducer: Epic Viscosity Buster-1% max
**All percentages listed at % by weight.*



Storage

65-90°F (18-32°C)
Avoid direct sunlight.
Use within one year of manufacturing date



Clean Up

Ink degradant or press wash



Health & Safety

SDS: www.polyone.com or
Contact your local CSR.