

1170PFW Epic™ Warrior LB White

Wilflex™ Epic Warrior LB White is a general purpose non-phthalate white ink designed for applications on 100% cotton and cotton/poly blends where moderate bleed-resistance is required. Warrior LB White can be used as an underbase flash white or as a highlight white. It is characterized by fast flash time with low after-tack, excellent fiber mat-down and matte appearance.

Highlights

- ▶ Non-phthalate.
- ▶ Compliant with CPSIA (Consumer Product Safety Improvement Act) 2008, Section 101, Lead Content in Substrates (<300 ppm lead); 16 CFR, Part 1303, Lead in Paint (<90 ppm lead); and CPSIA 2008, Section 108, Phthalates (<.1% DEHP, DBP, BBP, DINP, DIDP, DNOP).
- ▶ Eco-Passport Certified.
- ▶ Fast flash with low after-tack.
- ▶ Excellent fiber mat-down.
- ▶ Odorless.
- ▶ Good opacity.
- ▶ Smooth surface.
- ▶ Matte appearance.
- ▶ Use as a first-down, underbase flash white or as an overprint stand-alone white.

Printing Tips

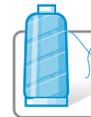
- ▶ Use consistent, high-tension screens to optimize performance.
- ▶ To increase production speeds, use a finer mesh count for the flash plate and decrease dwell time. Set flash dwell times based on heated pallets to simulate actual production conditions.
- ▶ Do not use excessive squeegee pressure.
- ▶ Best results are achieved using recommended mesh counts.

Precautions

- ▶ Perform fusion tests before production. Failure to cure ink properly may result in poor wash fastness, inferior adhesion and unacceptable durability. Ink gel 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.
- ▶ Stir plastisols before printing.
- ▶ Do not dry clean, bleach or iron printed area.
- ▶ Avoid overflashing, as it can result in poor inter-coat adhesion of overprint colors.
- ▶ Pretest Epic Warrior LB White on light colored or stone washed garments. Avoid stacking printed garments hot because such colors are more prone to color distortion. Fabric and dye characteristics can vary between manufacturers and from dye lot to lot.
- ▶ **NON-CONTAMINATION OF EPIC INKS**
 - ▶ Do not add or mix non-Epic inks, additives or extenders with the Epic ink products.
 - ▶ All buckets, palette knives, stirring apparatus, squeegees, flood bars and screens must be cleaned properly and free of phthalate containing inks.
 - ▶ Non-phthalate emulsions and pallet adhesives must be used.
- ▶ Any application not referred in this product bulletin should be pre-tested or consultation sought with Technical Services Department prior to printing.
- ▶ Email: techserviceswilflex@polyone.com

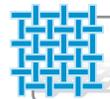
Printing Parameters

Opacity	9	
Bleed Resistance	7	
Smooth Surface	8	
Flash	8	
Gloss	4	
Printability	9	



Fabric Types

100% cotton, cotton/poly blends



Mesh

Counts: 86-305 t/in (34-120 t/cm) recommended

Tension: 25-35 n/cm² recommended

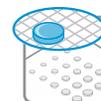


Squeegee

Durometer: 60-70, 60/90/60

Edge: Square, Sharp

Stroke: Hard flood, fast-stroke



Non-Phthalate Stencil

Direct: 2 over 2

Capillary/thick film: N/A

Off contact: 1/16" (.2 cm)



Gel/Cure Temperatures

Gel: 220°F (104°C)

Cure: 320°F (160°C) Entire Film



Pigment Loading

N/A



Additives

Extender: None

Reducer: 1% max - 10025VB QEC Viscosity Buster



Storage

65°-90°F (18°-32°C)

Avoid direct sun.

Use within one year of receipt.



Clean Up

Wilflex screen wash



Health & Safety

MSDS: www.polyone.com