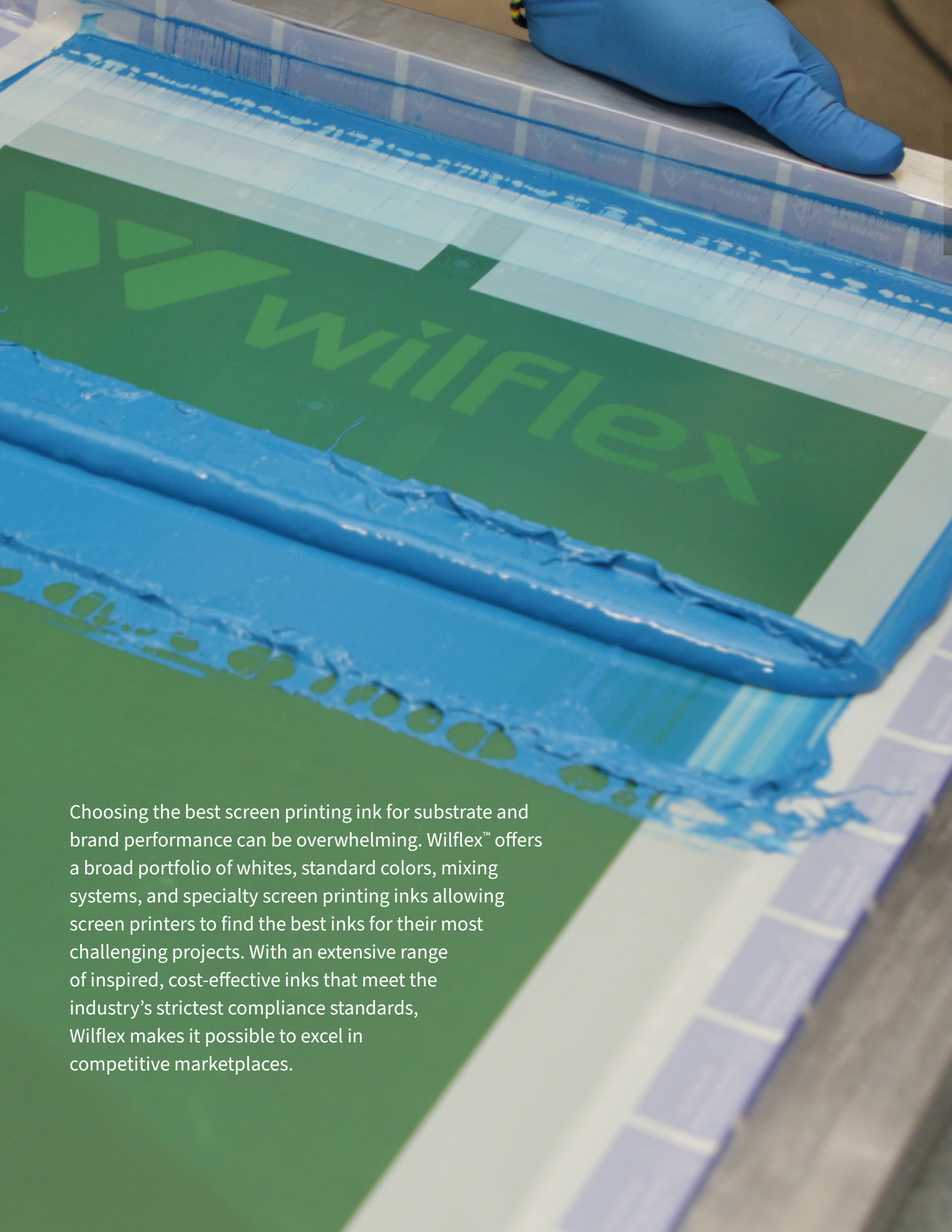# WILFLEX™
Plastisol Screen Printing Ink

wilflex™

AVIENT™

Choosing the best screen printing ink for substrate and brand performance can be overwhelming. Wilflex™ offers a broad portfolio of whites, standard colors, mixing systems, and specialty screen printing inks allowing screen printers to find the best inks for their most challenging projects. With an extensive range of inspired, cost-effective inks that meet the industry's strictest compliance standards, Wilflex makes it possible to excel in competitive marketplaces.

QUALITY AND CONSISTENCY

Wilflex™ products are produced to exacting standards and strict process procedures, ensuring quality and consistency of every batch.

Wilflex™ Epic™ inks are certified to **ZDHC Conformance Level 3** with **ECO PASSPORT by OEKO-TEX**. To learn more about compliance standards, please contact Avient Specialty Inks.*

ROADMAP TO **ZERO**

OEKO-TEX®
CONFIDENCE IN TEXTILES
ECO PASSPORT

PROFESSIONAL SUPPORT NETWORK

Knowledgeable and Highly Experienced Team

Our Avient Specialty Inks sales team has many years of experience in the screen printing industry to help you innovate and succeed, provide troubleshooting support, and solve technical problems you may encounter in your printing production environment. Our customer service team members are always ready to support ordering and fulfillment requests, ensuring a seamless customer experience.

Broad Distributor Network

Our extensive global network of distributors ensures Avient Specialty Inks products and services are available at your location and convenience.

Technical Expertise

We strive to help our customers stay ahead of marketplace trends and demands. Our qualified and experienced Avient Specialty Inks technical team is constantly looking at ways to improve our products' performance and to develop new technologies to meet emerging demands.

* Wilflex ECO PASSPORT certification numbers:
  Wilflex 1.3 - 21.0.65055
  Wilflex 2.10 - 21.0.70670

WHITE PLASTISOL INKS

Cotton Inks

- **Epic™ Echo Cotton White** is created with the large contract printer market in mind. It is characterized by its good fiber mat-down, brightness, matte appearance, and great value.

- **Epic™ Sprint White** is a premium ink that delivers superior printability and visual appearance. Epic Sprint White has an extremely fast flash time with minimal after-tack, excellent fiber mat-down, a smooth soft-hand, and bright finish.

- **Epic™ Shock LC White** is a low cure premium ink that delivers superior printability with an ultra-soft, pliable, and bright finish. Epic Shock LC White has a fast flash and fast print strokes, making it ideal for high production print shops.

- **Revive™ White** is a white plastisol ink with excellent wash durability and opacity. Revive White is created with over 50% bio-derived content and is certified to ASTM D6866.

Nylon Inks

- **Epic™ One-Step Nylon White** is created for printing on untreated nylon substances. Standard plastisol ink processes are recommended for this high opacity ink.

Polyester Inks

- **Epic™ Athletic Poly White** provides good resistance to dye migration and great coverage in polyester garments.

- **Epic™ Rival Sport™ White** is a high-performance, low bleed ink created for polyester sports apparel. Pair with Rival Sport Colors for printing polyester substrates that require low cure temperature.

- **Epic™ PolyWhite LC Xtra** is a low cure ink with excellent bleed resistance and great coverage.

- **Epic™ Performance LC White** combines best-in-class bleed resistance with ultra-stretch performance for a premium soft and pliable hand feel. It is created to print onto a variety of specialty fabrics, including compression wear, stretch garments containing spandex, lycra or elastane, polyester, blends, and triblends.

Poly-Cotton Blend Inks

- **Epic™ Echo LB White** is characterized by its opacity, good fiber mat-down, brightness, matte appearance, and great value. Epic Echo LB White is developed for applications on 100% cotton and poly-cotton blends where moderate bleed resistance is required.

- **Epic™ Quick White** delivers superior printability, premium aesthetics, an un-matched soft hand feel, and great fiber mat-down. It is characterized by an extremely fast flash time with minimal after-tack, fast print strokes, and easy mesh clearance for fast production environments.

- **Epic™ Amazing Bright Tiger White** is a low bleed white ink developed for applications where moderate bleed resistance is required. This white ink is press stable, giving printers flexibility to operate at a wide range of mesh counts, squeegee pressures, and pallet temperatures.

- **Epic™ Bolt LC White i**s a low cure white ink with great opacity. Pair with K2100 Epic Armor LC Gray as an underlay to obtain the best low-temperature dye migration resistance on all 100% polyester performance fabrics in the market today.

- **Epic™ Single LC White** is a flexible cure, non-ghosting white ink for a variety of garment types. Single LC White is characterized by its excellent bleed resistance, stretch, and high opacity.

REDUCE

Flexible Cure Inks

- Solutions in Avient's Reduce portfolio reduce negative environmental impacts by using better, cleaner materials that consume fewer natural resources and generate less waste.

- Avient Specialty Inks' reduced energy use portfolio is attributed with reducing energy consumption from typical alternatives, often resulting in decreased carbon emissions and lower energy costs. Achieve your sustainability goals with our flexible cure inks.

  Avient offers a variety of low, or flexible, cure inks that can not only reduce energy consumption, but can also minimize dye migration and prevent shrinkage of heat-sensitive fabrics. These inks cure at temperatures as low as 250° (121°C), as opposed to the standard 320°F (160°C) cure temperature of standard inks.

- **Epic Shock LC White,** Epic **Rival Sport LC White, Epic PolyWhite LC Xtra, Epic Performance LC White, Epic Single LC White, Epic Shock LC White, Epic Nylon One-Step White,** and **Epic Bolt LC White** are classified as flexible cure white inks due to their reduced energy use capabilities.

PRINT GALLERY

RENEW

Biopolymer Inks

- Avient's Renew portfolio consists of responsibly designed products with specialty and renewable materials thoughtfully engineered to ensure their ability to be transformed into new products or safely biodegraded after use.

- Avient Specialty Inks' biopolymer portfolio incorporates bio-derived resources that promote reducing screen printers' reliance on fossil fuel-based inks.

  Avient offers easy-to-print inks created with bio-derived content.

- **Revive White** is created with bio-derived content, classifying it as a biopolymer ink.

Sustainability Spotlight

Biopolymers   Reduced Energy Use

WHITE PLASTISOL INKS

CATEGORY	COTTON INKS				NYLON INKS	POLYESTER INKS				POLY-COTTON BLENDS				
Product Name	Epic Echo Cotton White	Epic Sprint White	Epic Shock LC White	Revive White	Epic One-Step Nylon	Epic Athletic Poly White	Epic Rival Sport White	Epic PolyWhite LC Xtra	Epic Performance LC White	Epic Echo LB White	Epic Quick White	Epic Amazing Bright Tiger	Epic Bolt LC White	Epic Single LC White
Code	K2200	11335PFW	K2200	N/A	11000PFXOSN	K2200	K2200	K2200	K2200	K2200	11835PFW	K2200	K2200	K2200
Plastisol Type	Standard cure	Standard cure	Flexible cure	Standard cure	Flexible cure	Standard cure	Flexible cure	Flexible cure	Flexible cure	Standard cure	Standard cure	Standard cure	Flexible cure	Flexible cure
Colors	White	White	White	White	White	White	White	White	White	White	White	White	White	White
RECOMMENDED SUBSTRATES														
Cotton	Yes	Yes	Yes	Yes	No	No	No	No	Yes	Yes	Yes	No	No	Yes
Cotton/ Polyeseter	No	No	No	No	No	Yes	Yes	Yes	Yes	Yes	Yes	Yes	Yes*	Yes
100% Polyester	No	No	No	No	No	Yes	Yes	Yes	Yes	No	No	No	Yes*	Yes
100% Untreated Nylon	No	No	No	No	Yes**	No	No	No	Yes	No	No	No	No	No
Nonwoven Polypropylene Bags	No	No	No	No	No	No	No	No	No	No	No	No	No	Yes
PROPERTIES & PERFORMANCE														
Opacity	Better	Better	Better	Best	Better	Better	Best	Better	Best	Best	Better	Better	Best	Better
Bleed Resistance	N/A	N/A	N/A	N/A	N/A	Better	Best	Best	Best	Good	Better	Better	Best	Good
Hand	Better	Best	Better	Best	Best	Good	Good	Good	Better	Good	Best	Better	Better	Good
Wet-on-Wet Capability	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended
APPLICATION														
Mesh	86–230 t/in (34–91 t/cm)	86–305 t/in (34–120 t/cm)	86–305 t/in (34–120 t/cm)	86–305 t/in (34–120 t/cm)	86–230 t/in (34–91 t/cm)	86–160 t/in (34–62 t/cm)	86–160 t/in (34–62 t/cm)	86–160 t/in (34–62 t/cm)	86–230 t/in (34–91 t/cm)	86–230 t/in (34–91 t/cm)	86–230 t/in (34–90t/cm)	86–280 t/in (34–110 t/cm)	86--305 t/in (34–120 t/cm)	86–230 t/in (34–90t/cm)
Flash	220°F (105°C)	220°F (105°C)	180°F (83°C)	220°F (105°C)	180°F (83°C)	220°F (105°C)	180°F (83°C)	180°F (83°C)	180°F (80°C)	220°F (105°C)	220°F (105°C)	220°F (105°C)	180°F (83°C)	180°F (83°C)
Stencil	Direct	Direct	Direct	Direct	Direct	Direct	Direct	Direct	Direct	Direct	Direct	Direct	Direct	Direct
Cure Temperature	320°F (160°C)	300°F (149°C)	270°F–320°F (132°C–160°C)	320°F (160°C)	280°F (138°C)	320°F (160°C)	250°F–300°F (121°C–148°C)	250°F–300°F (121°C–148°C)	270°F (132°C)	320°F (160°C)	300°F (149°C)	300°F (149°C)	270°F–320°F (132°C–160°C)	260°F–280°F (127°C–138°C)
Wash	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant
ADDITIVES														
Viscosity Reducer	ASI K2910 Viscosity Buster, 1–3% per weight	ASI K2910 Viscosity Buster, 1–3% per weight	ASI K2912 Viscosity Buster, 1–3% per weight	Not recommended	ASI K2912 Viscosity Buster, 1–3% per weight	ASI K2910 Viscosity Buster, 1–3% per weight	ASI K2912 Viscosity Buster, 1–3% per weight	ASI K2912 Viscosity Buster, 1–3% per weight	ASI K2912 Viscosity Buster, 1–3% per weight	ASI K2910 Viscosity Buster, 1–3% per weight	ASI K2910 Viscosity Buster, 1–3% per weight	ASI K2910 Viscosity Buster, 1–3% per weight	ASI K2912 Viscosity Buster, 1–3% per weight	ASI K2912 Viscosity Buster, 1–3% per weight
Bonding Agent	ASI K2940 hugger catalyst, 10% by weight	ASI K2940 hugger catalyst, 10% by weight	ASI K2940 hugger catalyst, 10% by weight	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	ASI K2940 hugger catalyst, 10% by weight
Extender	ASI K2920 FINESSE, 10% max by weight***	ASI K2920 FINESSE, 10% max by weight***	10340PFXFSB Epic Fashion Soft Base	Not recommended	Not recommended	ASI K2920 FINESSE, 10% max by weight***	10340PFXFSB Epic Fashion Soft Base	10340PFXFSB Epic Fashion Soft Base	10340PFXFSB Epic Fashion Soft Base	ASI K2920 FINESSE, 10% max by weight***	ASI K2920 FINESSE, 10% max by weight***	ASI K2920 FINESSE, 10% max by weight***	10340PFXFSB Epic Fashion Soft Base	Not recommended

* When printing on 100% polyester, cure at 270°F (132°C) and pre-test for bleed resistance.   ** Not suitable for all nylon substrates, pre-test prior to production.   *** Adding extender to any product will reduce opacity and performance.

COLOR SYSTEMS

Black Inks

- **Epic™ Matte Black** is a print black ink that produces a very low gloss surface appearance. Epic Matte Black offers exceptional print qualities for the manual and automatic printer due to its high-productivity, wet-on-wet printing capabilities.

- **Epic™ Rival Sport™ Black** delivers maximum coverage with the fewest strokes for color consistency when printing directly onto dark fabric or over an under base.

- **Epic™ Rio™ RFU Black Diamond** is a flexible cure ink that offers superior opacity and wet-on-wet printing capabilities. Screen printers can achieve color quickly, even when using fine mesh screens.

- **Epic™ One-Step Nylon Black** is created for printing on untreated nylon substances. Standard plastisol ink processes are recommended for this high opacity ink.

Standard Colors

- **Epic™ Rio™ RFU Colors** offer a range of popular industry colors formulated to be vibrant, bold, and pure in color. Each color is optimized for unmatched quality and printability in a ready-for-use format. Rio RFU Colors are flexible cure and suitable for manual and automatic press.

- **Epic™ Rival Sport™ Colors** are low bleed and flexible cure colors that deliver maximum coverage when printing directly onto dark fabric or over an under base. Epic Rival Sport offers superior on-press performance and exceptional print results.

Mixing Systems

- **Epic™ MX Color Mixing System** is an easy-to-mix color mixing with 17 translucent to semi-opaque intermixable colors. These Pantone®-simulated colors are developed for high production with a matte finish.

- **Epic™ PC Express Color Mixing System** is an easy-to-use color mixing system with 15 intermixable pigment concentrates and a variety of mixing bases. Epic PC Express Color Mixing System enables printers to produce versatile Pantone® simulations for high production jobs.

- **Epic™ Equalizer Color Mixing System** is an easy-printing color mixing system with 15 intermixable colorants and a base. The Epic Equalizer Color Mixing System allows printers to produce Pantone® simulations for high production projects.

- **Epic™ Rio™ Mix** is a low cure finished ink mixing system formulated for an optimal balance of color accuracy and opacity. With 18 intermixable colors that enable printers to produce accurate Pantone® simulations, Epic Rio Mix is the most opaque color system in the line of Wilflex mixing color systems.

Wilflex mixing inks are available for use on IMS 3.0, a proprietary color formulation software from Avient Specialty Inks. IMS manages daily maneuvers in a highly functional ink room by providing color management and communication agility, offerting tools for color creation and standardizing.

REDUCE

Flexible Cure Inks

- **Epic Rio RFU Colors, Epic Rival Sport Colors, Epic PC Express Color Mixing System, Epic Equalizer Color Mixing System, Epic Rio Mix, Epic Rival Sport Black, Epic Rio RFU Black Diamond,** and **Epic One-Step Nylon Black** are classified as flexible cure standard color inks due to their reduced energy use capabilities.

PRINT GALLERY

Sustainability Spotlight

Reduced Energy Use

COLOR SYSTEMS

CATEGORY	BLACK INKS				STANDARD COLORS			MIXING SYSTEMS		
Product Name	Epic Matte Black	Epic Rival Sport Black	Epic Rio RFU Black Diamond	Epic One-Step Nylon	Epic Rio RFU Colors	Epic Rival Sport Colors	Epic MX Mixing System	Epic PC Express Color Mixing System	Epic Equalizer Mixing System	Epic Rio Mix
Code	19000PFX	19000	Epic Rio RFU	19000PFXOSN	Epic Rio RFU	Rival Sport	Epic PF	Epic PC	Epic Equalizer	Epic Rio Mix
Plastisol Type	Standard cure	Flexible cure	Flexible cure	Flexible cure	Flexible cure	Flexible cure	Standard cure	Flexible cure	Flexible cure	Flexible cure
Colors	Black	Black	Black	Black	32 colors	22 colors	15 colors	15 colors	15 colors	18 colors
RECOMMENDED SUBSTRATES										
Cotton	Yes	No	Yes	No	Yes	No	Yes	Yes	Yes	Yes
Cotton/Polyeseter	Yes	Yes	Yes	No	Yes	Yes	Yes	Yes	Yes	Yes
100% Polyester	Yes	Yes	Yes*	No	Yes*	Yes	No	Yes	Yes	Yes*
100% Untreated Nylon	No	Yes	No	Yes**	No	Yes	No	Yes	No	No
Nonwoven Polyproylene Bags	No	Yes	No	No	No	Yes	No	Yes	No	No
PROPERTIES & PERFORMANCE										
Opacity	Good*	Good	Best	Better	Best	Better	Good	Better	Better	Best
Bleed Resistance	N/A	N/A	N/A	N/A	N/A	Best	N/A	Best	N/A	N/A
Hand	Better	Good	Best	Best	Best	Good	Best	Best	Better	Best
Wet-on-Wet Capability	Not recommended	Not recommended	Better	N/A	Better	Not recommended	Best	Best	Best	Better****
APPLICATION										
Mesh	86–305 t/in (34–120 t/cm)	86–230 t/in (34–90t/cm)	110–305 t/in (43–120 t/cm)	86–230 t/in (34–91 t/cm)	110–305 t/in (43–120 t/cm)	86–230 t/in (34–90t/cm)	110–305 t/in (43–120 t/cm)	110–305 t/in (43–120 t/ cm)	110–305 t/in (43–120 t/cm)	110–305 t/in (43–120 t/cm)
Flash	160°F (70°C)	180°F (83°C)	180°F (83°C)	180°F (83°C)	180°F (83°C)	180°F (83°C)	220°F (105°C)	See base specifications	See base specifications	180°F (83°C)
Stencil	Direct	Direct	Direct	Direct	Direct	Direct	Direct	Direct	Direct	Direct
Cure Temperature	320°F (160°C)	250°F–300°F (121°C–148°C)	266°F–320°F (130°C–160°C)	280°F (138°C)	266°F–320°F (130°C–160°C)	250°F–300°F (121°C–148°C)	320°F (160°C)	See base specifications	See base specifications	266°F–320°F (130°C–160°C)
Wash	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant	Standard plastisol cleaners, press wash, or ink degredant
ADDITIVES										
Viscosity Reducer	ASI K2910 Viscosity Buster, 1–3% per weight	ASI K2912 Viscosity Buster, 1–3% per weight	ASI K2912 Viscosity Buster, 1–3% per weight	ASI K2912 Viscosity Buster, 1–3% per weight	ASI K2912 Viscosity Buster, 1–3% per weight	ASI K2912 Viscosity Buster, 1–3% per weight	ASI K2910 Viscosity Buster, 1–3% per weight	ASI K2912 Viscosity Buster, 1–3% per weight	ASI K2912 Viscosity Buster, 1–3% per weight	ASI K2912 Viscosity Buster, 1–3% per weight
Bonding Agent	ASI K2940 hugger catalyst, 10% by weight	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended
Extender	ASI K2920 FINESSE, 10% max by weight***	10340PFXFSB Epic Fashion Soft Base	10340PFXFSB Epic Fashion Soft Base	Not recommended	10340PFXFSB Epic Fashion Soft Base	10340PFXFSB Epic Fashion Soft Base	ASI K2920 FINESSE, 10% max by weight***	10340PFXFSB Epic Fashion Soft Base	10340PFXFSB Epic Fashion Soft Base	10340PFXFSB Epic Fashion Soft Base

* For one-hit opacity through coarse meshes, use a coating procedure that builds a thick, even stencil to ensure a good column height of ink.

** For bleed resistance, use an underbase white such as 11835PFW Epic Quick White, 11117PFW Epic Polywhite Xtra, LC Xtra, or K2200 Epic Athletic Poly White.

*** Refer to properties of selected base.

**** Use 230 mesh or higher for best wet-on-wet printing.

BASES AND OTHERS

Mixing Bases

- **Epic™ Mixing Base** is a high-productivity base for Epic PC and Epic Equalizer mixing systems. Epic Mixing Base offers exceptional print qualities for both manual and automatic prints.

- **Epic™ Amazing Base** is developed for manual and automatic screen printing with design versatility and press performance. Epic Amazing Base has been engineered to produce optimal color vibrancy and printability.

- **Epic™ Transflex Base** is used to create a soft-feel, hot-split transfer that gives the appearance of a direct print. Properly formulated colors will produce opaque prints on dark fabrics, without under-basing. Epic Transflex inks are created for fine line detail, solid spot color printing applications, and conventional cold-peel transfers.

- **Epic™ LC Base** is created for manual and automatic screen printing with consistent color reproduction, excellent graphic durability, and efficient wet-on-wet application.

- **Epic™ Rival Sport™ LC Base** is a low bleed, flexible cure mixing base for both manual and automatic printers. Combine a low bleed color system with the Rival Sport White for additional bleed protection.

- **Epic™ One-Step Nylon Base** is created for printing on untreated nylon substances. Standard plastisol ink processes are recommended for this high opacity ink.

- **Epic™ Fashion Soft** is low cure, low viscosity plastisol base that simulates water-based ink printing and produces an ultra-soft hand feel. Fashion Soft can be mixed with colors or whites to soften the hand.

- **Revive™ Mixing Base** offers excellent wash durability and opacity. Revive Mixing Base is created with over 50% bio-derived content and is certified to ASTM D6866.

Bleed Blockers

- **Epic™ Armor LC Gray** and **Epic™ Armor LC Black** are premium gray or black under base plastisol inks developed to fight even the toughest dye migration. Armor LC gives a smooth, creamy finish with great printability and easy mesh clearance.

- **Epic™ UBG** is bleed-resistant under base developed to prevent dye migration, while maintaining good printability and coverage.

Flexible Cure Inks

- **Epic LC Base, Epic Rival Sport LC Base, Epic Armor LC Gray, Epic Armor LC Black, Epic LC Base, Epic One-Step Nylon Base,** and **Epic Fashion Soft** are classified as flexible cure mixing bases and bleed blockers due to their reduced energy use capabilities.

PRINT GALLERY

Biopolymer Inks

- **Revive Mixing Base** is created with bio-derived content, classifying it as a biopolymer ink.

BASES AND OTHERS

CATEGORY	MIXING BASES							BLEED BLOCKERS			OTHERS
Product Name	Epic Mixing Base	Epic Amazing Base	Epic Transflex Base	Epic LC Base	Epic Rival Sport LC Base	Epic One-Step Nylon	Revive Mixing Base	Epic Armor LC Gray	Epic Armor LC Black	Epic UBG	Epic Fashion Soft
Code	15000PFB	12004PFB	K2305	K2321	K2326	19930PFXOSN	N/A	K2100	K2100	K2100	10340PFXFSB
Plastisol Type	Standard cure	Standard cure	Standard cure	Flexible cure	Flexible cure	Flexible cure	Standard cure	Flexible cure	Flexible cure	Standard cure	Flexible cure
Colors	N/A	N/A	N/A	N/A	N/A	N/A	N/A	Gray	Black	Gray	N/A

RECOMMENDED SUBSTRATES

Cotton	Yes	Yes	Yes	Yes	No	No	Yes	No	No	No	Yes
Cotton/Polyeseter	Yes	Yes	Yes	Yes	Yes	No	No	Yes	Yes	Yes	Yes
100% Polyester	No	No	No	No	Yes	No	No	Yes	Yes	Yes	No
100% Untreated Nylon	No	No	No	No	No	Yes**	No	No	No	No	No
Nonwoven Polyproylene Bags	No	No	No	No	No	No	No	No	No	No	No

PROPERTIES &PERFORMANCE

Opacity	Better	Better	Good	Good	Better	Better	Better	Best	Best	Better	N/A
Bleed Resistance	N/A	N/A	N/A	N/A	Better	N/A	N/A	Best	Best	Best	N/A
Hand	Better	Best	Best	Good	Good	Best	Best	Good	Good	Good	Best
Wet-on-Wet Capability	Better	Best	Not recommended	Better	Not recommended	N/A	Best	Not recommended	Not recommended	Not recommended	Better

APPLICATION

Mesh	86–305 t/in (34–120 t/cm)	86–305 t/in	86–125 t/in (34–49 t/cm)	86–305 t/in (34–120 t/cm)	86–230 t/in (34–90 t/cm)	86–230 t/in (34–91 t/cm)	86–305 t/in	86–160 t/in (34–62 t/cm)	86–160 t/in (34–62 t/cm)	86–160 t/in (34–62 t/cm)	230–305 t/in (91–120 t/cm)
Flash	220°F (105°C)	220°F (105°C)	160°F (70°C)	180°F (83°C)	180°F (83°C)	180°F (83°C)	220°F (105°C)	180°F (83°C)	180°F (83°C)	180°F (83°C)	180°F (83°C)
Stencil	Direct	Direct	Direct	Direct	Direct	Direct	Direct	Direct	Direct	Direct	Direct
Cure Temperature	320°F (160°C)	300°F (149°C)	300°F (160°C)	270°F (132°C)	250°F–300°F (121°C–148°C)	280°F (138°C)	320°F (160°C)	270°F (132°C)	270°F (132°C)	320°F (160°C)	270°F–320°F (132°C–160°C)
Wash	Standard plastisol cleaners, press wash, or ink degradant	Standard plastisol cleaners, press wash, or ink degradant	Standard plastisol cleaners, press wash, or ink degradant	Standard plastisol cleaners, press wash, or ink degradant	Standard plastisol cleaners, press wash, or ink degradant	Standard plastisol cleaners, press wash, or ink degradant	Standard plastisol cleaners, press wash, or ink degradant	Standard plastisol cleaners, press wash, or ink degradant	Standard plastisol cleaners, press wash, or ink degradant	Standard plastisol cleaners, press wash, or ink degradant	Standard plastisol cleaners, press wash, or ink degradant

ADDITIVES

Viscosity Reducer	ASI K2910 Viscosity Buster, 1–3% per weight	ASI K2910 Viscosity Buster, 1–3% per weight	Not recommended	ASI K2912 Viscosity Buster, 1–3% per weight	ASI K2912 Viscosity Buster, 1–3% per weight	ASI K2912 Viscosity Buster, 1–3% per weight	Not recommended	ASI K2912 Viscosity Buster, 1–3% per weight	ASI K2912 Viscosity Buster, 1–3% per weight	ASI K2910 Viscosity Buster, 1–3% per weight	Not recommended
Bonding Agent	Not recommended	Not recommended	Not recommended	ASI K2940 hugger catalyst, 10% by weight	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	Not recommended	ASI K2940 hugger catalyst, 10% by weight
Extender	ASI K2920 FINESSE, 10% max by weight***	ASI K2920 FINESSE, 10% max by weight***	ASI K2920 FINESSE, 10% max by weight***	10340PFXFSB Epic Fashion Soft Base	10340PFXFSB Epic Fashion Soft Base	Not recommended	Not recommended	10340PFXFSB Epic Fashion Soft Base	10340PFXFSB Epic Fashion Soft Base	ASI K2920 FINESSE, 10% max by weight***	10340PFXFSB Epic Fashion Soft Base

* When printing on 100% polyester, cure at 270°F (132°C) and pre-test for bleed resistance.

** Not suitable for all nylon substrates, pre-test prior to production.

*** Adding extender to any product will reduce opacity and performance.

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