



2325 EPIC™ TOP SCORE LC BASE

PRODUCT INFORMATION BULLETIN



WILFLEX™ Epic Top Score LC Base is a non-phthalate, low-bleed and low-cure mixing base for printing on polyester garments for both manual and automatic printers. Get piece of mind with combining a low bleed color system with the Top Score LC White for additional bleed protection.

HIGHLIGHTS

- Mix with Wilflex™ PCs or EQualizers
- Low cure, save energy, reduce bleed defects
- Semi-opaque to opaque colors
- Excellent bleed resistance, reducing the need to underbase on polyesters
- Best color fastness to crocking test
- Matte finish with low surface tack

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 to 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
- Use a printing technique to assure a good ink deposit to maximize bleed resistance and film strength properties
- Top Score LC Base is a low cure and low bleed mixing base. For challenging fabrics using sublimation dyes, a bleed blocking underbase such as EPIC ARMOR LC may be required
- 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
- Top Score 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. Print colors using 70 duro squeegee and 110-230 t/in (43-91 t/cm) mesh followed by powdering. Gel at 212°F (100°C) for 60 sec. Apply transfer with heat press at 300°F (150°C) for 10-12 sec at medium pressure. For transfers on polyester, back with a low bleed white and/or blocker. Verify process.

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

RECOMMENDED PARAMETERS



Fabric Types

100% polyester, polyester blends, 100% nylon Jersey



Mesh

Count: 86-230 t/in (34-90 t/cm)
Tension: 25-35 n/cm2



Squeegee

Durometer: 60/90/60, 60-70
Profile: Square, Sharp
Stroke: Hard flood, Slow-Medium 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

Epic Viscosity Buster-1% max



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



AVIENT
SPECIALTY
INKS

V3.01 (Modified: 05/13/2022)

2021, Avient Corporation. Avient makes no representations, guarantees, or warranties of any kind with respect to the information contained in this document about its accuracy, suitability for particular applications, or the results obtained or obtainable using the information. Some of the information arises from laboratory work with small-scale equipment which may not provide a reliable indication of performance or properties obtained or obtainable on larger-scale equipment. Values reported as "typical" or stated without a range do not state minimum or maximum properties; consult your sales representative for property ranges and min/max specifications. Processing conditions can cause material properties to shift from the values stated in the information. Avient makes no warranties or guarantees respecting suitability of either Avient's products or the information for your process or end-use application. You have the responsibility to conduct full-scale end-product performance testing to determine suitability in your application, and you assume all risk and liability arising from your use of the information and/or use or handling of any product. AVIENT MAKES NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, either with respect to the information or products reflected by the information. This literature shall NOT operate as permission, recommendation, or inducement to practice any patented invention without permission of the patent owner.