

## Epic Hugger Catalyst

Wilflex™ Epic Hugger Catalyst is an ink additive recommended for use when printing on waterproofed satin jackets or other waterproofed nylon materials.

### Highlights

- ▶ Recommended for use with Epic inks at 10% max by weight to improve adhesion.

### Printing Tips

- ▶ The addition of Epic Hugger Catalyst to ink at 10% by weight is recommended when printing on waterproofed satin jackets and/or other waterproofed nylon materials.
- ▶ When printing on nylon material that has been treated to repel water, the waterproofing must be removed. Remove waterproofing by wiping down the print area with rubbing alcohol or acetone. Check for penetration of the waterproofing with small drops of water. The water drops will spread and penetrate the fabric if the waterproof coating is properly removed.
- ▶ Epic Hugger Catalyst activates upon exposure to moisture in the air. The amount of moisture exposure determines the shelf life of the mixed ink. Pot life generally ranges from 4-8 hours.

### Compliance

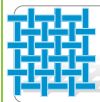
- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit [www.wilflex.com/compliance](http://www.wilflex.com/compliance).

### Precautions

- ▶ Perform fusion tests before production. Failure to cure ink properly may result in poor wash fastness, inferior adhesion and unacceptable durability. 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.
- ▶ The cross linking reaction between the catalyst and ink takes approximately 48-72 hours to fully bond to the fabric. Scratch testing should not be conducted immediately following printing.
- ▶ Ink mixed with Epic Hugger Catalyst must be removed from the screen immediately following printing using cleaning solvents to prevent permanent mesh damage. Squeegees and any other printing apparatus must also be cleaned immediately.
- ▶ 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](mailto:techserviceswilflex@polyone.com)



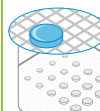
**Fabric Types**  
See relevant PIB.



**Mesh**  
Counts: See relevant PIB.  
Tension: See relevant PIB.



**Squeegee**  
Durometer: See relevant PIB.  
Edge: See relevant PIB.  
Stroke: See relevant PIB.  
*\*Do not use excess squeegee pressure.*



**Non-Phthalate Stencil**  
Direct: See relevant PIB.  
Capillary/Thick Film: See relevant PIB.  
Off Contact: See relevant PIB.



**Flash & Cure Temperatures**  
Flash: N/A  
Cure: N/A



**Pigment Loading**  
EQ: N/A  
MX: N/A  
PC: N/A  
*\*All percentages listed at % by weight.*



**Epic Additives**  
Extender: N/A  
Reducer: N/A  
*\*All percentages listed at % by weight.*



**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**  
MSDS: [www.polyone.com](http://www.polyone.com) or  
Contact your local CSR.