Wilflex Epic Rio Cheat Sheet: RFU Colors and Rio Mix

Low-cure Epic Rio ready-for-use colors and the 18-color Rio mixing system: mesh, flash, cure and printing tips.

Epic Rio RFU colors (ready for use)	
What it is	Popular industry colors ready to use; low cure, matte finish, designed for wet-on-wet printing on manual and automatic presses
Mesh	110-305 t/in. Best color on white or light garments and over a base plate with 160-305 mesh; use 230 or higher for wet-on-wet
Flash / cure	Flash 220 F (105 C). Cure 266-320 F (130-160 C), whole ink film
Fabrics	100% cotton, 100% polyester*, triblends, poly blends, cotton/poly blends, cotton/lycra, non-woven polypropylene bags
Bleed	Not low-bleed: on fabrics prone to bleed, underbase with an approved Wilflex low-bleed white and/or blocker
Non-woven bags	Single print with 110-160 mesh and a 60 or 70 single-durometer squeegee
Blending	ASI K2920 Finesse extends the ink for halftones; suitable at 270 F

Epic Rio Mix (mixing system)	
What it is	Low-cure, non-phthalate finished-ink mixing system with 18 intermixable colors for Pantone simulations; the most opaque Wilflex color system
Mesh / flash / cure	110-305 t/in; flash 220 F; cure 266-320 F (130-160 C)
Fabrics	100% cotton, 100% polyester, triblends, poly blends, cotton/poly, cotton/lycra
Dark garments	Print-flash-print with a soft squeegee and lower mesh count
Why fine mesh	High opacity gets to color quickly even on fine mesh, saving ink

Press setup (Avient)	
Tension	25-35 N/cm2
Squeegee	60/90/60, 70/90/70 or 60-90 durometer, 10-15 degrees, 2 over 2
Off contact	1/16 inch; storage 65-90 F, use within one year
Cold-peel transfers	70 duro, 110-230 mesh, powder, gel at 212 F for 60 sec, press at 300 F for 10-12 sec at medium pressure

Sources: Avient/Wilflex Epic Rio RFU Colors V3.29, Rio Mix Color Mixing System V3.22, Epic Rio Color Matching V3.13 (18 intermixable colors), Epic Rio Product Bulletin. Rio color cards are on our safety data sheets page. Reference only: the maker's current data sheet governs. Mesh in threads per inch. All data sheets: bucketsofink.com/page/safety-data-sheets.