

C WP111SBD SuperBond Adhesive

Wilflex SuperBond Adhesive is a specially formulated hot-peel/hot-split plastisol transfer adhesive. Super Bond Adhesive will create transfers that have excellent durability, stretch and wash properties onto fabrics that are not totally conditioned for regular hot-split plastisol transfer inks.

Highlights

- ▶ 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).
- ▶ Excellent abrasion and crack resistance.
- ▶ Superior Adhesion.
- ▶ Maximum elongation.
- ▶ Can be used as a foil adhesive for direct printing.

Printing Tips

- ▶ Adjustments to the drying mechanism may be required as the variables of different drying (heat) types, length of dryer conveyor and drying units, will affect the overall transfer finish.
- ▶ The majority of standard transfer papers can be used with confidence. If a softer-feel transfer is required, an uncoated transfer paper is recommended. In most cases, a hot-split/hot-peel transfer paper will be required.
- ▶ Preprint, transfer and test all fabrics for desired properties before beginning production printing.

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.
- ▶ Turn the garment inside-out when washing and drying to keep the transfer looking its best.
- ▶ Examine the fabric type and color before and after the application of the transfer, as color distortion may occur due to the introduction of heat to sensitive fabric types and dye-stuffs inherent in the garment.
- ▶ It is advisable to press the blank shirt under transfer press before applying transfer to reduce moisture in garment.
- ▶ Stir plastisols prior to printing.
- ▶ Do not dry clean, bleach or iron the printed area.
- ▶ Email: techserviceswilflex@polyone.com

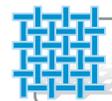
Printing Parameters

Opacity	n/a
Bleed Resistance	n/a
Smooth Surface	9
Flash	8
Gloss	n/a
Printability	9



Fabric Types

100 % Cotton, cotton blends, rayon, linen, uncoated nylon, and lycra.



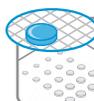
Mesh

Counts: 86-156 t/in (34-61 t/cm) recommended
Tension: 25-35 n/cm² recommended



Squeegee

Durometer: 60-80
Edge: Hard, square
Stroke: Hard flood, slow speed
Avoid excess pressure.



Stencil

Direct: 2 over 2
Capillary/
thick film: 200-400 micron
Off contact: 1/16" (.2 cm)



Gel/Cure Temperatures

Gel: 220-260 F (104-127 C).
Lower temps will result in a transfer with little tensile strength, and higher temps will negatively affect the "split" of the final transfer.
Cure: 375 F (190 C) entire film



Pigment Loading

MX: N/A
EQs: N/A
PCs: 10% max by weight



Additives

Extender: None
Reducer: None



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