

## C Transflex™ Process Inks

Wilflex Transflex process inks have been specially formulated to produce 4-color process heat release transfers that exhibit superb color when used with full photographic, airbrush and spot process quality graphics. The base used is the 10007TF Transflex TransClear.

### 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).
- ▶ Transflex Process inks include:
  - ▶ 49858TF Process Magenta
  - ▶ 69858TF Process Blue
  - ▶ 89858TF Process Yellow
  - ▶ 19000TF Process Black
  - ▶ 10007TF Transflex TransClear
- ▶ Excellent color vibrancy
- ▶ Soft hand, hot peel inks
- ▶ The inks have good elongation and wash properties
- ▶ Compatible with all other Transflex transfer ink systems.

### Printing Tips

- ▶ A standard printing sequence for the process colors is as follows: 1) Black, 2) Blue, 3) Magenta, 4) Yellow.
- ▶ If TransClear is used as the hot-peel coat, be sure that the TransClear is printed **First** on the paper. Recommended mesh for the first-down TransClear is 305-355 t/in (120-140 t/cm)
- ▶ 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.

### 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.
- ▶ Preprint, transfer and test all fabrics for desired properties before beginning production printing.
- ▶ 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.
- ▶ Any application not referred in this product bulletin should be pre-tested or consultation sought with Technical Services Department prior to printing.
- ▶ Email: techserviceswilflex@polyone.com

## Printing Parameters

<b>Opacity</b>	n/a
<b>Bleed Resistance</b>	n/a
<b>Smooth Surface</b>	9 ██████████
<b>Flash</b>	8 ██████████
<b>Gloss</b>	n/a
<b>Printability</b>	9 ██████████



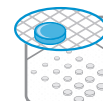
**Fabric Types**  
Cotton, cotton blends, rayon, linen and lycra. NOT recommended for nylon or satin fabrics.



**Mesh**  
Counts: 305-355 t/in (120-140 t/cm) recommended  
Tension: 25-35 n/cm² recommended



**Squeegee**  
Durometer: 60-80 durometer, straight edge  
Edge: Sharp, square  
Stroke: Medium flood and speed  
Avoid excess pressure.



**Stencil**  
Direct: 2 over 2  
Capillary/thick film: N/A  
Off contact: 1/16" (2 cm)



**Gel/Cure Temperatures**  
Gel: 240-270 F (115-132 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: N/A



**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