

## C Transflex™ Shimmer Inks

Wilflex Transflex Shimmer inks are formulated for hot-split applications on most fabrics. Transflex Shimmers offer many improvements over conventional hot-split inks including: printability, transfer latitude, quality of shimmer/shine, and soft feel - even on dark garments. Transflex Shimmers may also be used for conventional cold-peel transfers.

### 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:
  - ▶ 85370TF Transflex™ Super Gold Shimmer
  - ▶ 85570TF Transflex™ Super Ultra Gold Shimmer
  - ▶ 15370TF Transflex™ Super Silver Shimmer
- ▶ Hot-split transfer ink with a soft feel.
- ▶ For use with dark garments.
- ▶ Excellent printability.
- ▶ Hot-split, hot-peel or cold-peel
- ▶ Classic PCs can be added to the Transflex Silver Shimmer to create shimmer colors.

### Printing Tips

- ▶ The use of 10210TF Transflex Printable Adhesive will improve the adhesion of Transflex inks to a far wider range of substrates when cold-peeled.
- ▶ The transfer paper should be peeled immediately after transferring for optimum results. When cold-peeling, allow transfer to cool for approximately 15 seconds before removing the paper.
- ▶ 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

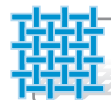
## Printing Parameters

|                         |     |  |
|-------------------------|-----|--|
| <b>Opacity</b>          | 9   |  |
| <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

100% Cotton, cotton blends, rayon, linen and Lycra. NOT recommended for nylon or satin fabrics.



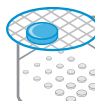
### Mesh

Counts: 60-86 t/in (24-34 t/cm) recommended  
Tension: 25-35 n/cm<sup>2</sup> recommended



### Squeegee

Durometer: 60-80 durometer, straight edge  
Edge: Sharp, square  
Stroke: Hard flood, medium 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: 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