

C Transflex™ Soft

Wilflex Transflex Soft inks are a soft-feel, hot-split transfer ink formulated for white or pastel substrates. This ink offers improvements in printability and transfer latitude compared with conventional hot-split inks. Transflex Soft inks also may 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).
- ▶ Hot-split transfer ink with a soft feel.
- ▶ For use with white or pastel garments.
- ▶ Excellent printability.
- ▶ Hot-split or cold-peel

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

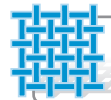
Printing Parameters

Opacity	5	
Bleed Resistance	n/a	
Smooth Surface	9	
Flash	8	
Gloss	n/a	
Printability	9	



Fabric Types

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



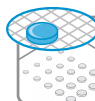
Mesh

Counts: 86-123 t/in (34-49 t/cm) recommended
Tension: 25-35 n/cm² recommended



Squeegee

Durometer: 60-80 durometer, straight edge
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: 210-240 F (99-116 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