

19000PFXTFX Epic TFX Soft Black

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

- ▶ 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.

Compliance

- ▶ Non-phthalate.
- ▶ For individual compliance certifications, please visit www.wilflex.com/compliance.

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.
- ▶ Pretest 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 dyestuffs 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 before printing.
- ▶ Do not dry clean, bleach or iron printed area.
- ▶ **NON-CONTAMINATION OF EPIC INKS:** Do not add or mix non-Epic inks, additives or extenders with Epic inks. All buckets, palette knives, stirring apparatus, squeegees, flood bars and screens must be cleaned properly and free of phthalates and pvc containing inks. Non-phthalate emulsions and pallet adhesives must be used. Failure to follow these precautions may cause phthalate contamination in violation of consumer protection laws and regulations.
- ▶ Any application not referred in this product information bulletin should be pre-tested or consultation sought with Wilflex Technical Services Department prior to printing.
- ▶ Email: techserviceswilflex@polyone.com



Fabric Types

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



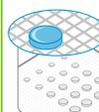
Mesh

Counts: 86-125 t/in (34-49 t/cm)
Tension: 25-35 n/cm²



Squeegee

Durometer: 60-80
Edge: Straight, Hard, Square
Stroke: Hard flood, Slow speed
**Do not use excess squeegee pressure.*



Non-Phthalate Stencil

Direct: 2 over 2
Capillary/Thick Film: 200-400 microns
Off Contact: 1/16" (.2cm)



Flash & Cure Temperatures

Flash: 240-270°F (115-130°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: 320°F (160°C)
Transfer: 375°F (191°C)



Pigment Loading

EQ: N/A
MX: N/A
PC: 10% max
**All percentages listed at % by weight.*



Epic Additives

Extender: N/A
Reducer: N/A
**All percentages listed at % by weight.*



Storage

65-90°F (18-32°C)
Avoid direct sunlight.
Use within one year of receipt.



Clean Up

Ink degradant or press wash.



Health & Safety

MSDS: www.polyone.com or
Contact your local CSR.