wilflex™

Product Information Bulletin

10210TFX Epic TFX Printable Adhesive

Wilflex™ Epic TFX Printable Adhesive has been formulated as a hot-split/hot-peel transfer adhesive to be used as an adhesive backer to all Epic Transflex inks. Epic TFX Printable Adhesive can be printed on multiple substrate paper types including: hot-peel/hot-split, cold peel and dual hot split/cold peel transfer papers.

Highlights

- Excellent adhesion to cotton and cotton blend fabrics.
- Improves ink stretch and washability.
- Provides additional ink durability when used on stretchable fabrics.
- Can be used as foil and fabric adhesive.

Printing Tips

- Use 110t/in mesh (43 t/cm) as standard for large coverage and non-detailed graphics.
- For fine line graphics use up to 195 t/in (77 t/cm) mesh.
- Epic Printable adhesive is printed last over the transfer inks.
- Slightly under cut graphic image separations so as to allow ink to spread following heat press application.
- Print flat coat of Epic Printable Adhesive using a 70/90/70 triple durometer squeegee.
- Gel ink under dryer at 230°F (90°C). Do not cure ink.
- Flash dry colors before applying printable adhesive.

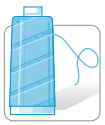
Compliance

- 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.
- When using the adhesive as a hot peel/hot split ink do not cure adhesive through the dryer as this will result in poor split/peel properties of the ink during heat press application. Gel ink only.
- Pretest all fabrics for desired properties before beginning production printing.
- When using the adhesive as a hot peel/hot split ink the transfer should be peeled immediately from the paper. When cold peeling, allow the transfer to cool for approximately 10 seconds before removing paper.
- 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

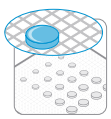
Recommended Parameters



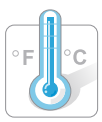
Fabric Types
100% cotton, cotton blends

Mesh
Counts: 110-158 t/in (43-62 t/cm)
Tension: 25-35 n/cm²

Squeegee
Durometer: 60-80, 70/90, 70/90/70
Edge: Square, Sharp
Stroke: Medium speed
Do not use excess squeegee pressure.

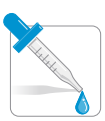


Non-Phthalate Stencil
Direct: 2 over 2
Capillary/Thick Film: N/A
Off Contact: 1/16" (.2 cm)



Flash & Cure Temperatures
Flash: 160°F (70°C)
Cure: N/A

Pigment Loading
EQ: 5% max
MX: N/A
PC: 5% 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 degradent or press wash.

Health & Safety
MSDS: www.polyone.com or
Contact your local CSR.

10210TFX Epic TFX Printable Adhesive : 07.2012.Vi

PolyOne Wilflex™ inks by PolyOne.

www.wilflex.com/pib

TRANSFER | ADDITIVE