



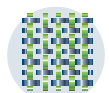
RECOMMENDED FABRICS
100% Cotton
Some Cotton/Polyester Blends



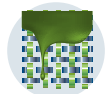
INK APPLICATION
Foil Adhesive 1801 should be used right out of the container without any modifications. Stir well prior to each use.



ADDITIVES
Not recommended



SCREEN MESH
74-110 t/in (30-43t/cm) monofilament recommended. Use 70 to 80 micron capillary film for best results.



EMULSION
Any direct or indirect solvent resistant emulsion. Use 50 to 80 micron capillary film for best results.



SQUEEGEE
60-75 Durometer
Sharp or beveled edge.



CURE TEMPERATURES
Direct Print: 325°F (163°C) entire ink film.
Transfer Printing (adhesive on foil): 240°F to 275°F (116°C to 135°C).



CLEAN-UP
Any environment friendly plastisol type screen wash



PRODUCT PACKAGING
Quart, 1 gallon, 5 gallon containers



STORAGE OF INK CONTAINERS
65° to 90°F (18°C to 32°C). Avoid storage in direct sunlight. Keep containers well sealed



SDS
Refer to SDS prior to use

FEATURES

AXEON™ Foil Adhesive 1801 is used to produce brilliant metallic foil designs on textiles.

The adhesive can be printed directly onto the fabric and the foil applied to the dried adhesive. The adhesive can also be printed directly on the foil as a conventional transfer would be printed (mirror image).

Designs made with Foil Adhesive 1801 may be applied to light or dark fabrics.

SPOT FLASHING

This product will spot dry, with a very low after flash tack. Dwell time is dependent on the spot dryer used. In some cases, you may have to lower the heat of the spot cure unit because too much heat may actually make the ink tacky. When you spot dry, you are only partially fusing or gelling the surface of the ink. The ink should be just dry to the touch, with no lift off, but not totally fused. Totally fusing the underprint may cause inter-coat adhesion problems with the inks printed on top. Final fusing or curing will occur in the dryer. Failure to fuse ink properly may cause cracking, poor adhesion and poor wash fastness.

FOIL APPLICATION

Foil is applied colored side up and aluminum looking (dull) side down. Rub foil with eraser immediately after application to help remove any wrinkles. Allow transfer to cool completely (20 to 30 seconds) after application before removal of foil sheet. Pull foil sheet off slowly.

Application Temperature:
300°F to 325°F (149°C to 163°C). Try lower temperature first for best results.

Application Time:
10-15 Seconds

Application Pressure:
T-Shirts = Medium (40lbs.)
Sweatshirts = Medium to Heavy (40lbs. to 60lbs)
The brightest foil effect will result when the foil is first removed. To achieve a textured matte finish foil, re-seal the garment or hat in the transfer press for 3-4 seconds after the foil carrier film has been removed.

IMPORTANT INFORMATION

For best durability of the foil after it is applied, it is recommended that the garment be hand washed or machine washed (delicate cycle) inside out, and then line or air dried. Do not use bleach. Do not iron printed area.

Note On Screen Mesh Selection
Recommend: 86 to 110 t/in or 34-43 t/cm mesh for T-Shirts
Recommend: 74 to 86 t/in or 30-34 t/cm mesh for sweatshirts

Test dryer temperatures and wash test printed product before and during a production run.

This ink and those in the **AXEON™** product line are not formulated with PVC resins or phthalate plasticizers, nor are they intentionally added.

Care should be taken to not cross-contaminate the AXEON™ products with PVC or phthalate containing products.

Do not use standard plastisol curable reducers with this or any of the AXEON™ products.

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