

Optilux™ 950 Reflective Transfer Adhesive



Optilux™ 950 is a clear plastisol based transfer adhesive formulated to be used with the Optilux™ 901 reflective sheet to produce reflective heat seal transfers. Optilux™ 901 is a reflective transfer sheet composed of wide angled retro reflective lenses temporarily bonded to a polyester substrate.



Recommended Substrates

Reflective transfers made using Optilux™ 950 can be used on cotton, cotton blends and synthetic fabrics such as polyester, and some nylon and nylon blends. It is highly recommended that the finished transfers be thoroughly tested to assure compliance to individual performance requirements.

Manufacturing Requirements

To produce reflective transfers using Optilux™ 950, the following materials and procedures are recommended:

1. Screen Optilux™ 950 Reflective Transfer Adhesive, plastisol-based adhesive, onto the **Optilux™ 901** Reflective Transfer Sheets, mirror image, to create the desired image.
2. Add Optilux™ Coupler 200 just prior to using Optilux™ 950 Reflective Transfer Adhesive. Recommended mix ratio is 1% by weight of Optilux™ Coupler 200 to the Optilux™ 950 Reflective Transfer Adhesive. Mix all the components very thoroughly before using. Pot life of mixed adhesive is approximately 8 to 12 hours. Do not mix more adhesive than is needed for the job. Any mixed adhesive not used within 12 hours should not be used.
3. Adhesive yield is approximately 3,000 prints for a 4 x 5 inch (1.6 x 2.0 cm) design.
4. Use any direct or indirect lacquer proof emulsion.
5. Clean-Up Mineral Spirits or any environmentally friendly plastisol screen wash.

Screen Mesh and Emulsion

Mesh: 86 monofilament (34 threads/cm).

Squeegee: Sharp edge, 60 to 75 durometer. Print with squeegee at 45 degree angle to screen mesh. Print with screen off contact for best results.

Emulsion: Any direct or indirect lacquer emulsion or Capillary film.

Drying Printed Transfer Sheets

Printed **Optilux™ 901** reflective transfer sheets should be gelled (partially cured) at 270°F to 290°F (131°C to 142°C). Retention time in the dryer should be long enough for the transfer adhesive to completely reach the recommended gel temperatures. Test dryer temperatures and wash test printed/transferred product before and during a production run.



For more information about **Optilux™ Ultra** Reflective Ink Systems
www.vizreflectives.com/optilux or www.iccink.com/optilux

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Optilux™ Reflective Film & Transfer Adhesive

Technical Information

Transfer Application

Allow 24 hours after printing and partially drying the reflective transfers before beginning the application process. Completed reflective transfers should be applied within 6 months of production for best results. Transfers should be applied by heat sealing at 325°F to 350°F (163°C to 175°C), using medium pressure (40 psi), for 8 to 12 seconds. Peel cold.

Recommended Washing Instructions for Finished Garments

Allow 24 hours after application of transfers before washing. Machine wash finished product in cold water, delicate cycle, inside out. Recommend line or hang to dry. Do not use bleach. Do not iron on printed area of garment.

Storage of Optilux™ 950 Containers

Keep containers sealed when not in use. Keep indoors and store in a cool area. Recommend storage at 65°F to 90°F (18°C to 32°C). Avoid storage in direct sunlight or in extreme temperature conditions.

Optilux™ 950 Product Packaging

Available in Gallon and 5-Gallon Containers.

Reflective Transfer Application

Application Temperature: 325°F to 350°F (163°C to 175°C)
Application Time: 8 - 12 Seconds
Application Pressure: Medium (40 psi)
PEEL COLD

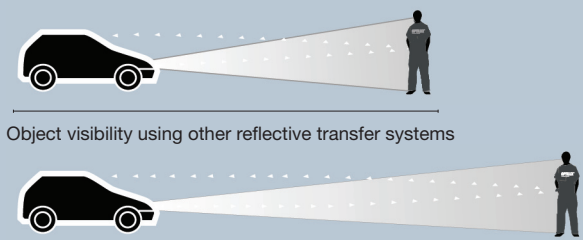
Directions for Viewing Reflective Transfers

1. View applied reflective transfers in a dark room.
2. Hold a flashlight at your eye level and aim at sample.
3. Applied transfers should produce, very bright, 500 candlepower light when using the Optilux™ 901 Reflective Transfer Sheets.

Properly applied Optilux™ 901 reflective transfers maintain reflectivity for the normal life of the garment to which they are applied. Performance can vary depending upon how the product is stored, applied and used, exposure conditions, and laundering conditions. Users must test the finished transfer to determine the suitability of the product for their particular requirements.

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Optilux™ reflective Transfer comparison



Object visibility using other reflective transfer systems

Object visibility using Optilux reflective transfer systems

*Based on a garment using full coverage

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