General Application Recommendations

MetaFlex®
BY FIBERLOK

*** IMPORTANT INFORMATION — DO NOT DISCARD! ***

1. Machine Settings

****Top Heat only****

Important: Machine must have one cushioned, soft surface

MetaFlex Heat Transfers

Temp: 320° F (188° C)

Time Front: 4 seconds

Time Back: 14 seconds

Pressure: Medium
(30 psi for heat presses)

NOTE: Above settings are general recommendations. Every material and press varies. Please adjust your pressure according to your machine results. (Refer to page 2 for a more rigorous Testing Procedure to determine ideal settings. Staff are available to help with application issues.)

2. Pre-Test Fabric

Check fabric for melting, scorching, curling or other problems by applying heat at the temperature recommended above. Application to waterproof/water-resistant fabrics, leather or slick nylons is not recommended, due to adhesion or scorching problems. To maximize results, use the Testing Set-Up Procedure on the reverse side.

3. Place Transfer

Place transfer on fabric with the adhesive side down. If MetaFlex transfers are packed with slick liner paper between them, remove it first.

4. Apply Heat (Front)

Apply heat for 4 seconds.

5. Flip Over

Turn the garment inside out to allow heat to fully penetrate the back of the patch.

6. Apply Heat (Back)

Apply heat for 14 seconds, or dwell time based on Testing Procedure results on Page 2.

7. Let Cool

Remove from heat press keeping flat, without pulling or twisting while warm, which can weaken the adhesion. Allow applied transfer to cool to the touch or to room temperature in a flat position.

8. Peel Film (for designs with freestanding elements only)

Peel away carrier film, while checking that design is transferring. If not, repeat steps 4-6. If your transfer appears smashed or if you see an impression around your logo, decrease pressure and repeat steps 3-6.

9. Test Adhesion

Test transfer adhesion by machine washing with detergent. While still wet, try to pick off design. If the design only comes up slightly in the corners, then adhesion is satisfactory; if design can be peeled off in a continuous large piece, then adhesion is not satisfactory. Contact us for assistance.

10. Final Check

Properly applied, FiberLok apparel graphics look clear, feel soft, and will last the lifetime of the garment.

FIBERLOK®
INNOVATION APPLIED

FiberLok Technologies, Inc.
Main: 970.221.1200 Fax: 970.221.2424
sales@fiberlok.com www.fiberlok.com

MetaFlex®
BY FIBERLOK

Heat Application Testing Set-Up Procedure

Quality Window Test Matrix **Back Application**

Dwell Time (seconds)	Temperature 280° F (138° C)	300° F (149° C)	320° F (160° C)	340° F (171° C)	360° F (182° C)
4	*Test 1*	*Test 7*	*Test 13*	*Test 19*	*Test 25*
8	*Test 2*	*Test 8*	*Test 14*	*Test 20*	*Test 26*
12	*Test 3*	*Test 9*	*Test 15*	*Test 21*	*Test 27*
16	*Test 4*	*Test 10*	*Test 16*	*Test 22*	*Test 28*
20	*Test 5*	*Test 11*	*Test 17*	*Test 23*	*Test 29*
24	*Test 6*	*Test 12*	*Test 18*	*Test 24*	*Test 30*

Heat Application Testing Set-up Procedure

This procedure is optional and included for optimization

1. Pressure: Set heat press machine pressure to **Medium** for most transfer sizes. For larger transfers, increase pressure to **Medium-High**
2. Use numbered textile test swatches to correspond to the italicized numbers in the above matrix.
3. Apply each with above settings; wash or pick test.
4. Mark failures in matrix with an "X" and passes with an"O".
5. Note pattern of passes (O), you have now established the Quality Window. Below is an example of a completed Quality Test Matrix.

Quality Window Test Matrix **Back Application**

Dwell Time (seconds)	Temperature 280° F (135° C)	300° F (149° C)	320° F (163° C)	340° F (178° C)	360° F (191° C)
4	*Test 1*	*Test 7*	*Test 13*	*Test 19*	*Test 25*
8	*Test 2*	**X**	**X**	*Test 20*	*Test 26*
12	**X**	**O**	**O**	**X**	*Test 27*
16	**X**	**O**	**O**	**X**	*Test 28*
20	*Test 5*	**X**	**X**	*Test 23*	*Test 29*
24	*Test 6*	*Test 12*	*Test 18*	*Test 24*	*Test 30*