

# FLEXCUT MAXX – APPLICATION INSTRUCTIONS

## Heat Transfer Flex Film for Plotter Cutting



Cut Mirrored

FlexCut Maxx is a water based 100% polyurethane super thin & super soft film with excellent stretch, opacity & color fastness. The sticky liner / carrier allows for fine cutting detail and fast weeding of a graphic or lettering. Cutting is easy with both a drag-knife and the tangential cutting technology. Large and multi-layered graphics can be applied without loss of wearing comfort.



Transfer Design

FlexCut Maxx is suitable for cotton and most blended textiles. **Caution** when applying to fabrics made of polyester and or contain polyester as they may exhibit dye / ink migration / bleeding and require testing before full production. FlexCut Maxx is not suitable for nylon or coated textiles. (See legend)

**Heat Pressing:** Apply the graphic to the textile and press for 15-17 seconds at 330°F / 165°C with medium high pressure. Then remove the carrier / transfer film using a hot or warm peel. Washing resistance up to 140°F / 60°C.

**Layering is possible: Flex on Flex.** We do not recommend more than four layers.

### Layering recommendations:

Five (5) seconds per layer with the final layer at fifteen (15) seconds or at the recommended time for the last layer applied. See SEF's application instruction sheet for time & temperature settings specific to the last layer applied. **Caution:** Layering **Flex on Flex**, we recommend using a "Warm" Peel. For Flock, we recommend a "Cold" Peel.



Hot / Warm Peel

### Cut in Mirror Image, Wrong Reading

#### Cutting Conditions:

- Blade: Relief angle 30° / 45°
- Blade pressure, med., 60 to 90 grams of down force. Test cuts recommended
- Cutting Speed: ≈40 cm/s

#### Transfer Recommendations:

- Temperature: 330°F / 165°C
- Time: 15-17 sec.
- Pressure: medium high
- Hot / warm peel of the transfer / carrier film

#### Layering Possible, Flex on Flex

#### Suitable Textiles:

- Cotton, cotton / polyester & blended textiles. Not suitable for Nylon or coated textiles
- **Fabrics made of polyester or contain polyester may exhibit dye / Ink migration / bleeding and require testing before full production"** Use of our **SBB** products, (Sublimation Blocking **B**arrier) may be required.

#### Wash Resistance:

- 140°F 60°C wash resistance

#### Colors:

- FlexCut Maxx comes in - 40 solid colors, 4 neon & 2 metallic

#### Available in:

- 15" x 5, 10, 25, & 50yd. rolls, all colors
- 19.7 x 10 & 25yd. rolls, White & Black

Custom roll widths & lengths may be available.



**Garment Care:** Wait 24 hours before first washing, wash & dry garment inside out, machine wash & dry at low temperatures. See "Wash Resistance" specification. Use mild detergents. No Chlorine. We do not recommend Dry Cleaning Flex or Flock.

Store SEF Heat Transfer Materials in a cool and dry place; protect against the influence of light when stored. We recommend not to exceed a storage period of 24 months. Due to the variety of possible influences / exposure outside of our control, to include processing / use, all specifications should be viewed as reference values. We recommend a suitability test to the material before a production. Technical specifications rest on extensive tests and technical research, however, a legally binding warranty of specific characteristics and or performance cannot be provided.



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### Technical Information

"Tips & Tricks"

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