

**Avatrex 6500 for HP Indigo Presses
Preliminary Application Methods**

IMPORTANT: All printing must be in reverse/mirror image. Printed Avatrex is applied ink side down to other substrates.

FLEXIBLE SUBSTRATES	Attachment Method	Temperature	Speed/Dwell	Applications	Recommended Process
Specialty Papers Metallic Pearlescent Light/heavy textured Handmade	Direct heat lamination: roll or vacuum press	250-300 F	3'/minute or 2 minutes dwell	Artwork, photography, cards, labels & packaging, point of purchase/sale signs, direct mail, books	Laminate with the carrier off. However, leaving the carrier on may eliminate any potential wrinkling and requires a second lamination after the carrier is removed.
Other Canvas Bonded leather Films	Direct heat lamination: roll or vacuum press	250-300 F	3'/minute or ~2 minutes dwell	Artwork, photography, book covers, labels, luxury packaging, specialty & decor graphics	Laminate with the carrier off. However, leaving the carrier on may eliminate any potential wrinkling and requires a second lamination after the carrier is removed.
RIGID SUBSTRATES:	Application Method	Temperature	Speed/Dwell	Applications	Recommended
Glass	Soap/water solution *	n/a	n/a	Temporary window/glass graphics	See soap/water* directions below
	Primer solution**	250 F	1 minute	Labels & specialty graphics	See primer solution** directions below
	OC mounting adh	250-300F	3'/minute		OCMA option for permanent application
Stone/rock/ceramic tile Wood	Primer solution**	250 F	1 minute	Signs, plaques & awards, art, specialty & décor Graphics	See primer solution** directions below
Metals Plastics Synthetic board Paper board Metallic board	Direct or indirect heat lamination: roll, vacuum or platen press	220-300 F	3'/minute or 2 minutes dwell	Art or trade show graphics; retail, real estate or yard signs; permanent or temporary applications, specialty graphics	Straight lamination to substrate; drymount tissue, thermal, PSA or primer solution** can be used if straight heat bond is insufficient; soap & water solution* can be used for temporary graphics

*** Soap/water solution**

Directions:

- 1 Mix 1 drop of dishsoap with 1 gallon of tap water
- 2 Spray above mixture on glass
- 3 Remove from carrier and apply graphic face to glass surface and smooth from center out using squeegee
- 4 Let dry

**** Primer solution**

Directions:

- 1 Slowly mix 50% proprietary primer with 50% IPA .
- 2 Apply 2 coats of above primer solution to substrate surface; dry each layer (white fluid turns clear when dry). A third coat can be applied if required.
- 3 Heat prepared substrate surface to 250 F for 1 minute using oven or heat gun.
- 4 Remove carrier; apply graphic to treated hot surface; Avatrex will mold itself to the hot surface. Smooth or finish with soft cloth.
- 5 A platen press can be used to apply heat and pressure for bonding; if flat substrate a t-shirt transfer press can be used.
- 6 More heat can be applied to surface if required; a small course brush can be used to further mold into small crevices if required.

All instructions are preliminary and represent a starting point; they can be modified to perfect specific applications.



For further information contact LexJet 941-906-3195

