

# endura<sup>flame</sup>tex Galaxy

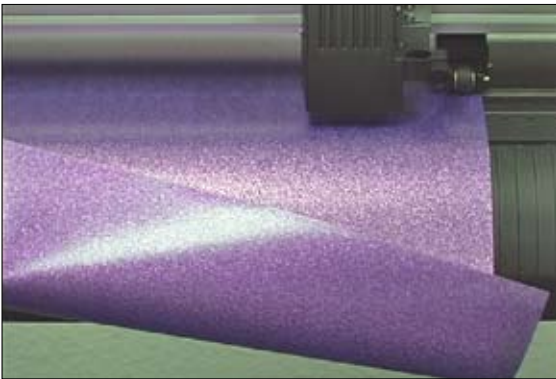
from SIGNWarehouse® 800-899-5655

#### Tools Needed:

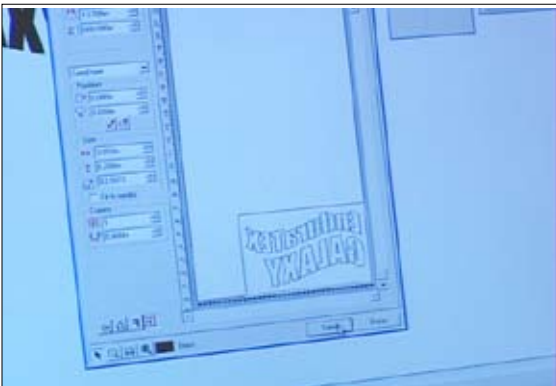
- Vinyl Cutter
- Sign Making Software  
Vinyl Express LXi
- 60° or 45° Blade (See step 3)
- Kraft Paper or Teflon Sheet

#### Recommended Fabrics:

- Cotton
- Polyester
- Similar Fibers



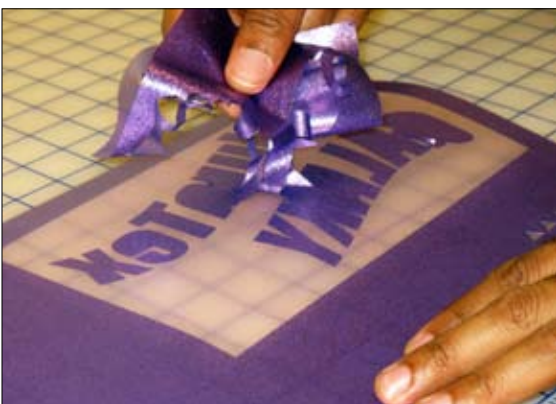
**1** When using EnduraTEX Galaxy, you will notice that the release liner is clear. When you cut, load the shiny side downwards into your cutter, allowing the matte side to be facing upwards.



**2** After designing your graphic, click the send to plotter button. Verify proper film sizing, then click your “reverse image”, “mirror” or “flip” icon. This will reverse the image on your screen and allow for image reversal when cutting. For this tutorial, we are using Vinyl Express LXi. The reverse icon in Vinyl Express LXi is an F, for “flip”.

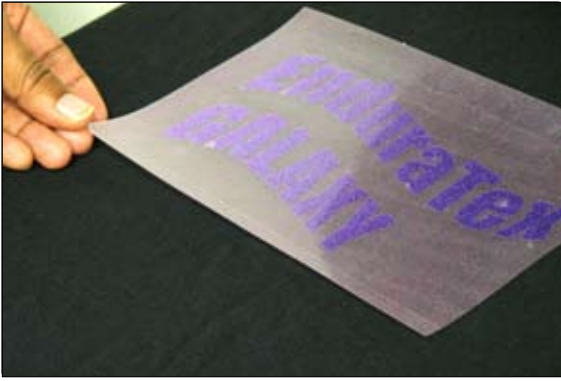


**3** Next load media into the cutter. Make sure to load the media with the shiny side facing down and the matte side facing up. After loading the film and setting the proper cutting conditions on your plotter, perform a test cut to make sure you have proper blade depth and a weedable graphic. For cutting EnduraTEX Galaxy, we suggest a standard 60° blade at about 70 grams of force. Please note, however, that you may use a 45° blade, but be aware that the cut line may be very difficult to see. This is due to the extreme amount of metal flake that is found in the material.



**4** After you have performed a satisfactory test cut, send the job from your sign making software. Your plotter will cut a mirror image of the original design into the garment film. When the cut-job is complete, advance the material forward and remove from the cutter using the Xacto, Olfa, or other utility or hobby knife. Using your preferred weeding tool, weed the excess material from the release liner. You may note that some metal flakes may remain on the liner during weeding, but this will not transfer onto the garment or diminish the appearance of the garment in any way.

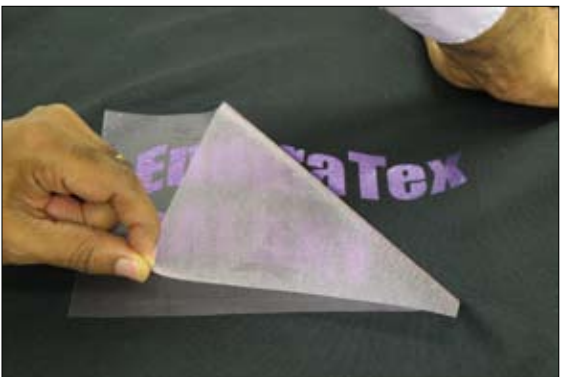
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**5** On your heat press, verify that your temperature is set between 300° and 340°F. If your heat press has a built in timer, set it for 15-20 seconds. Place the weeded graphic onto the cotton, polyester, or similar fabric with the release liner facing upward.



**6** Place the Teflon sheet over the graphic, then close the heat press. After 15-20 seconds, open the press.



**7** Allow the garment to cool to room temperature before removing the release liner. At this time you may remove the garment from the heat press and place in a location out of the way to allow for a second shirt pressing if desired. After the application has cooled, slowly peel the release liner away from the shirt. The garment film should remain on the fabric resulting in an image with a soft feel.



**8** To keep your graphic garment lasting longer, wash cool, inside out and tumble dry at up to 140° F. This concludes the tutorial on how to use and apply the EnduraTEX Galaxy.

**endura****tex**  
**Galaxy**

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