



Flash Cure & Dryer Temperature Guide

These are common **starting points**. The technical data sheet for your exact ink always overrides them.

1 · INK

Ink type

Plastisol (standard)



Show in

°F



Typical cure range (check your ink's TDS)

260–330 °F

Plastisol (standard)

CURE

About 260–330 °F by ink (sources differ), through the whole ink film. Many standard inks list about 320 °F; check your ink's TDS.

FLASH

Flash to a gel (dry to the touch). Typically a few seconds; depends on flash unit, distance and platen temp.

DRYER

Dwell long enough for the full ink thickness to reach temp. Thick deposits and puff need more.

Confirm with a temp probe and a wash test before production.

Reference table (starting points)

INK	TYPICAL FULL CURE	FLASH GOAL	NOTES
Plastisol (standard)	~260–330 °F (127–166 °C) by ink (sources differ), reached through the whole ink film. Check the ink's TDS.	Gel: dry to the touch, not fully cured	Plastisol does not air dry; it must reach fusion temperature. Many standard inks list about 320 °F; follow the number on your ink's TDS.
Plastisol (low-cure)	~250–300 °F (121–149 °C) by ink; many lines ~270–300 °F. Check the ink's TDS.	Gel only	Made for heat-sensitive fabrics and to reduce dye migration on poly. Use the maker's exact number.
Water-based	Per the ink's TDS. Many list ~320 °F (160 °C) for 2–3 min after the water has evaporated; some allow lower temps with longer dwell.	Partial dry (light flash) between colors	Needs the water driven off <i>and</i> curing heat, so dwell is usually longer than plastisol. Forced-air dryers help. Some inks use additives that change cure.
Discharge	Per the ink's TDS. Typically ~320–350 °F (160–177 °C) for about 90 s–3 min to fully activate and cure.	Light flash	Works only on discharge-able (dye-reactive) cotton garments. Mix in activator per the maker's pot life. Ventilate the dryer area.

How to verify cure

- Measure the **ink film** temperature, not just the dryer setting: use a thermometer probe, temperature strips or a donut probe through the tunnel.
- Do a stretch test on plastisol after the print cools: cracking suggests under-cure.
- Do a wash test on a sample before running the order.
- Heavier deposits, darker garments, airflow and belt speed all change how hot the ink actually gets.

Flash tips

- Flash just until the ink is dry to the touch. Over-flashing can cause scorching, platen heat build-up and poor intercoat adhesion.
- Platens warm up during a run, so flash times often get shorter as the job goes on.