

SOLVENT-DARK 113 FOR DARK COTTON



PRINT SETTINGS

- Only for use in Solvent-Printers, UV-Printers, Offset-Printers and Flexo Printers with Solvent, Solvent-Light, Mild-Solvent or Eco-Solvent inks and UV-hardening inks or UV-hardening Flexo Colors.
- **Maximum Printer Heating:** 35°C (95°F)
- **Suggested Profiles** for ROLAND VersaCAMM SP-Series = SP-M: Matte PET, High Quality (720 x 1440)
ROLAND VersaCAMM VP-Series = FOREVER Profile



TRANSFER PROCESS

- Print the design.
- Cut the outlines.
- Place the application tape (high tack) on the printed areas
- Rub under pressure on it by using a squeegee.
- Remove the backing paper from the transfer foil.
- Weed the unprinted areas off the application tape.
- Place the application tape with the printed areas on the garment.
- Put 5 sheets of normal copy paper on it and press for 5 seconds.
- Remove the application tape after 5 seconds.
- Cover the design silicone paper.
- Press again for 30 seconds and remove the paper while it is warm.



SETTINGS HEAT PRESS

| | AUTOMATIC HEAT PRESS | MANUAL HEAT PRESS |
|-------------|----------------------|-------------------|
| PRESSURE | 5 bar / 70 PSI | maximum |
| TEMPERATURE | 180°C / 356°F | 180°C / 356°F |
| TIME | 5 + 30 seconds | 5 + 30 seconds |



WASHING

- Up to 40°C (cold wash cycle). Inside out. Do not use fabric softener or liquid detergent.



DRYING

- Do not tumble dry! Hang dry or line dry recommended



IRONING

- When ironing cover the print with baking paper

Before starting a **mass production**, we recommend to make **transfer and washing test** with **all materials**. **Important advice for double-sided printing on textiles:** T-Shirts for a **double-sided print** (front side & backside), has to be put over the lower heat plate. In this case only one side will be treated with heat and you avoid that the applied design from the other side will be pressed out again. If your T-Shirt is yellowing, lay a piece of fleece onto it during the transfer process.

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RECOMMENDED PRINT PARAMETERS FOR DIFFERENT APPLICATIONS*

| WASHABLE MATERIALS | | TEMPERATURE | | PRESSURE | 1. PRESSING | 2. PRESSING |
|---|------------------------------|------------------|------------------|----------|---|--------------------------------|
| MATERIAL | COMPONENTS | (°C) | (°F) | bar | covered with 5 sheets of normal paper | covered with silicone paper |
| Cotton T-Shirt (colored) | 100% Cotton | 200°C | 390°F | 5 bar | 5 sec. | 40 sec. |
| Sweatshirt (white) | 50% Cotton, 50% Polyester | 180°C | 360°F | 5 bar | 5 sec. | 30 sec. |
| Polyester (white) | 100% Polyester | 140°C - 160°C | 280°F - 320°F | 5 bar | 5 sec. | 30 sec. |
| Polyester (white) | 95% Polyester, 5% Lycra | 140°C - 160°C | 280°F - 320°F | 5 bar | 5 sec. | 30 sec. |
| Polyamid (white & colored) | 100% Polyamid | 160°C | 320°F | 5 bar | 5 sec. | 30 sec. |
| Perlon (colored) | 100% Polyamid | 160°C | 320°F | 5 bar | 5 sec. | 15 sec. |
| Blended Fabric | 95% Viscose, 5% Lycra | 180°C | 360°F | 5 bar | 10 sec. | 20 sec. |

| NON-WASHABLE MATERIALS | | TEMPERATURE | | PRESSURE | 1. PRESSING | 2. PRESSING |
|-------------------------------|--|-------------|-------|----------|-------------|-------------|
| Backpack- material | | 180°C | 356°F | 5 bar | 5-10 sec. | |
| Neoprene | | 180°C | 360°F | 1 bar | 5 sec. | |
| Synthetic Leather | | 180°C | 360°F | 5 bar | 1 sec. | |
| Leather | | 180°C | 360°F | 5 bar | 5-10 sec. | |
| Coated Paper | | 180°C | 360°F | 3 bar | 5 sec. | |
| Wood | | 130°C | 270°F | 5 bar | 20 sec. | |

* The above mentioned parameters are standard values and do not replace tests with the customer's own printers and inks and especially with their own transfer presses.