

PRODUCT DESCRIPTION:

HEAT TRANSFER printing can allow reduced inventory of pre-printed garments. PLUS Inks are the original "hot-peel" heat transfer ink and can also be applied with a "cold-peel" method. They can be printed on heat transfer release paper and then applied to shirts, baseball caps, and other textiles with a heat transfer press. (Metallic colors are not recommended for heat transfers.)

"Hot-peel" method is where the transfer paper (standard bond type 70) is peeled off the hot transfer IMMEDIATELY after the transfer is applied. When the paper is peeled hot, a portion of the ink remains on the paper and the rest stays on the shirts. Hot-Peel transfers feel just like a direct screen print when made and applied correctly.

"Cold-peel" where the transfer paper (standard silicone release type) is allowed to cool down completely after application and before removing. This gives a semi-gloss, rubbery feel to the print that is commonly found in athletic sports applications.

RECOMMENDED MESH/EMULSION: Any Diazo, Dual-cure, or Pure photopolymer emulsion. Capillary films provide the best and sharpest edge definition and fine detail. Hot-peel is best through 86-110t Mesh. Cold peel is best through 110-180 Mesh.

PRINT TECHNIQUES: Image is printed "mirror image", medium squeegee, medium stroke.

CURING: Prints on heat transfer paper should only be semi-cured only to the extent that the sheets can be handled, stacked, cut and transferred. Over-cure will not allow easy re-gel of ink for best adhesion. The ink will semi-cure when the ink deposit reaches 250-270°F.

Optional use of Unilon-2027 hot-melt powder can improve the bond of plastisol heat transfers to 50/50, nylon, polyester and other synthetic garments, including those with water-proof coatings.

After printing the Ultrasoft Plus Ink on heat transfer paper, apply Unilon-2027 as follows:

1. Fill a rectangular tray with approximately 1/4" of Unilon-2027 Powder.
2. Pass the transfer through the tray, print side up. Unilon will adhere to wet or semi-cured plastisol.
3. Remove powder from the unprinted areas by vigorously shaking the transfer or gently blowing cool air across it. Light brushing with a soft brush (taking care not to smudge the print), may also be used.
4. Semi-cure or gel the ink as described on the Ultrasoft Technical Data Sheet.
5. Transfer on a heat transfer press at temperatures compatible with the garment.

If printing a multi-color transfer, the powder can be applied after all the colors are printed (it will stick well to the last wet color and fair to the cured colors) or after every color and cure in between just as you would for a regular heat transfer.

TRANSFER TIME AND TEMPERATURE:

COLD PEEL TRANSFERS: Transfer at 350°F for 20 seconds or 400 F for 5 seconds at 40-50 p.s.i. Allow transfer to cool completely (10-30 seconds) before stripping off the paper.

HOT-PEEL TRANSFERS: Transfer at 375 F for 10-20 seconds, or 400 F for 5 seconds at 40-50 p.s.i. Quickly strip the release paper IMMEDIATELY after raising the transfer press platen while the shirt remains in the press.

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