



## Sericol Textile Transfer Systems

Sericol Textile Transfer Systems have been developed, by our applications specialists, utilising readily available Sericol products to provide a comprehensive solution for customising and decorating garments. The products comprise inks, adhesives and additives used to produce a variety of transfer types for applications that include sportswear and industrial clothing – requiring high mechanical and wash resistance.

### Textile Transfer Printing

In the simplest terms, textile transfers are an indirect method of producing a print onto garments. Inks are printed onto a special paper, dried and then transferred under a heat press onto the garment. Therefore, the printing process is similar to any other paper printing process and, ideally, requires the use of a vacuum bed printing press.

The main types, or categories, of transfers are as follows :

#### 1. Plastisol Transfers see pages 2 & 3.

Made by printing plastisol inks onto a special transfer paper, then heat setting each colour. The transfer is applied to a garment using a heat press and a combination of time and pressure to effect the transfer. The end uses for plastisol transfers include most garments which are made of cotton or blends of at least 50% cotton. There are at least three variations of plastisol transfers including Cold Peel, Litho and Hybrid.

#### 2. Workwear Transfers (Badges) see page 4.

Made by printing catalysed (2-pack) solvent-based inks onto release paper and applying screen-printable adhesive onto the print. A heat press is then used to produce prints capable of withstanding industrial washing at 95°C. The transfers are intended for logos or identification on work garments and overalls. A number of optional systems exist.

#### 3. Sportswear Transfers see page 5.

A speciality transfer system, which has been developed to enable the generation of high stretch products for use on previously sublimated materials such as football / sports shirts. The system combines the use of Nylotex NX ink colours plus special dye blocking layers and a selection of specialised adhesives. The combination minimises discolouration of the transferred print by the dyed fabric.

#### 4. Foil Transfers see page 6.

Uses a combination of direct printing and heat pressing to produce highly metallic effects on garments. A Metatran adhesive is first printed and partially cured on the fabric. Then Metatran foil, carried on a polyester film, is applied by heat press. Removing the polyester carrier film leaves the metallic foil adhered to the printed adhesive. The end uses of foil transfers are novelty and fashion.

#### 5. Sublimation Transfers see page 7.

Made by printing Subliscreeen HQ Dye Concentrates, blended into a water or solvent-based medium, onto a non-release paper and drying. Under the high temperature and pressure of the heat press, the dye turns to a gas and colours the fabric directly in contact with the print. The resulting print is of high colour brilliance and the handle of the fabric is unchanged. End uses include garments made from synthetic fabrics such as cycle / swimwear and replica football kits.

#### 6. Flock Transfers see page 8.

A special combination of a pre-fibred sheet and suitable water-based adhesives. The combination of direct printing onto the fibre, followed by transferring using a heat press allows the creation of soft feel transfers. Multi-colour transfers can be created by first printing onto white fibred sheets using Texiscreen Aqua AJ, water-based inks, followed by the adhesive. Flock transfers typically have end uses in fashion and sportswear garments.

### Transfer Papers

See **Transfer Papers Summary** on Page 9.

# 1. PLASTISOL TRANSFERS

Plastisol Transfers use the highly versatile range of Texopaque Classic OP and Advantage ON inks combined with MultiTran XM and Advantage TJ transfer adhesives. They enable printers to produce a variety of plastisol transfers including, Cold Peel, Lithographic, Hybrid and more.

## Overview

### Products Required

#### Colours

Texopaque Classic OP plastisol inks  
OPA01 Special Expanding Base may be used to increase opacity on dark fabrics.

Texopaque Advantage ON plastisol inks  
(formulated on non-phthalate plasticisers)  
(see page 11 for full colour ranges)

#### Adhesives

XM451 MultiTran White Adhesive  
XM452 MultiTran Clear Adhesive  
TJ452 Advantage Clear Adhesive (formulated phthalate free)  
XM011 Litho Back-Up White.  
XMA08 Special Litho Back-Up White  
TJ012 Advantage Litho Back-Up White (formulated on non-phthalate plasticisers)  
TO012 Pioneer Litho Back-Up White (formulated PVC and Phthalate Free)  
TO458 Pioneer Transfer (water-based) Adhesive (formulated PVC and Phthalate free)  
Available in 5 ltr containers.  
XM378 Transfer Adhesive Powder.  
Available in 1 kg containers.

#### Reducer

ZE591 Plastisol Flow Thinner  
Available in 5 and 1 ltr containers.  
ON591 Advantage Thinner  
Available in 5 ltr containers  
ZE592 Water Based Retarder  
Available in 1 ltr containers

#### Paper

See relative section

#### Fastness/Resistance

**Wash** Up to 60°C.  
**Dry Clean** Not suitable.  
**Direct Iron** Not suitable.  
**Industrial** Not suitable.

#### Recommended Transfer Equipment

Flat-bed Transfer Press  
Rotary Presses

**It is important not to over cure, especially with multi-colour transfers, as adhesion and transfer properties can be affected.**

## Cold Peel Transfers

Cold Peel transfers are those in which the whole of the printed ink film is transferred to the garment.

#### Transfer

This is done with a heat press, typically set between 160-190°C depending on the type of transfer method used (see following sections for recommended transfer schedules).

Place the garment on the lower platen and position the transfer on top, print side down. Close the heat press and leave for 10-15 seconds. Open the press, carefully remove the garment with the transfer still in place and allow to cool. When cold, carefully peel the paper from the garment, to leave the print attached.

Cold Peel transfers produce prints that are usually flexible and wash-resistant but, as with all plastisol prints, they are not resistant to ironing. These properties will vary depending on the ink and printing conditions used.

## Cold Peel Method

Use Texopaque Classic OP or Texopaque Advantage ON ink unthinned to gain maximum opacity and adhesion.

To further improve opacity on dark garments, 5-10% of OPA01 Special Expanding Base can be added.

**Mesh Count** 21-62 (or up to 120 if a back-up white or adhesive is used).

**Drying** Heat set on paper until touch dry. Typically 110-120°C for 30-60 seconds dependent on the heat source.

**Thinning** If required, up to 5% ZE591 Plastisol Flow Thinner or ON591 Advantage Thinner.

**Recommended paper** TRB08, TRB20, TRW28 siliconised transfer papers.

**Recommended Transfer Schedule** 185-190°C, 10-15 seconds, high pressure, wait until paper has cooled prior to removal. When using an adhesive, 160-170°C is recommended (see section on printable adhesives and adhesive powder)

**Note: when producing Advantage ON phthalate free transfers, ensure the correct adhesive is selected to avoid phthalate contamination.**

## Litho Back-up Method

'Litho' back-up transfers are a combination of lithographic offset inks, and a white or clear back-up plastisol adhesive. This unique process allows the generation of 'photo-like' transfers.

**Lithographic Inks** Oxidation Drying Inks

**Plastisol Back-up Adhesives** XM451, XM452, XM011 and XMA08

**Mesh** 27-43

**Drying (adhesives)** Heat set on paper until touch dry. Typically 120-130°C for 30-60 seconds dependent on the heat source.

**Thinning** If required, up to 5% ZE591 Plastisol Flow Thinner.

<b>Recommended paper</b>	TRB08, TRB20 siliconised transfer papers.
<b>Recommended Transfer Schedule</b>	175-190°C, 10-15 seconds, medium pressure, wait until paper has cooled prior to removal.

#### Tips – Litho Back-up Method

Oxidation Drying Lithographic inks once printed must be backed with the plastisol white within a short period of time, typically 2-7 days (dependent on the Litho inks used). If the prints are left beyond this time, the litho inks will harden, with a resultant loss in wash fastness. Only the areas of the litho print covered by the back-up adhesive will transfer to the garment.

### Phthalate Free Litho Back-up Method

<b>Plastisol Back-up Adhesives</b>	TJ012
<b>Mesh</b>	27-43
<b>Drying (adhesives)</b>	Heat set on paper until touch dry. Typically 120-130°C for 30-60 seconds dependent on the heat source.
<b>Thinning</b>	If required, up to 5% ON591 Advantage Thinner.
<b>Recommended paper</b>	TRB08, TRB20 siliconised transfer papers.
<b>Recommended Transfer Schedule</b>	175-190°C, 10-15 seconds, medium pressure, wait until paper has cooled prior to removal.

### PVC and Phthalate Free Litho Back-up Method

<b>Water-based Adhesives</b>	TO012 Litho Back-up White TO458 Adhesive
<b>Catalyst</b>	RY386
<b>Mesh</b>	28-32
<b>Drying (adhesives)</b>	Heat set on paper until touch dry. Typically 120-130°C for 30-60 seconds dependent on the heat source.
<b>Thinning</b>	If required, up to 5% ZE592 Water Based Retarder
<b>Recommended paper</b>	TRB08, TRB20 siliconised transfer papers.
<b>Recommended Transfer Schedule</b>	180-185°C, 10-15 seconds, medium to firm pressure wait until paper has cooled prior to removal.

#### Tips – PVC/Phthalate Free Litho Back-up Method

The oxidation drying lithographic inks once printed must be dry before being backed up. The inks must be left at least 8 days before being backed up. Leaving the prints for less than this will result in poor wash fastness.

The inks are backed up with two layers of water-based adhesive. The first layer consists of TO012 Pioneer Litho Back-up White with the addition of 5% RY386 Catalyst.

**It is imperative that the catalyst is added to the first layer. The first layer must then be backed-up with TO458 Adhesive to ensure maximum adhesion.**

Please note, two layers of TO012 can be used to improve opacity. To further improve durability, RY386 catalyst can also be added to the second layer of TO012. Do not add catalyst to the TO458 adhesive.

**Due to the variable nature of litho inks, no guarantee as to the compatibility of the ink systems can be given. All prints should be thoroughly tested for acceptability before production is commenced.**

### 'Imitation' Litho Method

Utilising solvent-based graphic screen inks onto siliconised transfer paper can lead to print quality / definition approaching that of lithographic transfers, whilst maintaining the benefits and practicality of the screen process.

<b>Inks Required</b>	Plastijet XG / TL.
<b>Plastisol Back-up</b>	XM451, XM452.
<b>Mesh</b>	Colours: 120-140. Plastisol Back-up: 34-43.
<b>Recommended paper</b>	TRB08, TRB20 siliconised transfer papers.
<b>Recommended Transfer Schedule</b>	160-170°C, 10-15 seconds, medium pressure, wait until paper has cooled prior to removal.

### Gloss Transfers

Utilising the Cold Peel method onto a high gloss transfer paper allows the creation of high impact gloss transfers, of particular appeal to the fashion and speciality markets.

<b>Mesh Count</b>	21-62 (or up to 90 if a back-up white or adhesive is used)
<b>Recommended paper</b>	TRQ97 siliconised transfer paper
<b>Recommended Transfer Schedule</b>	170-190°C, 10-15 seconds, high pressure, wait until paper has cooled prior to removal.

### Glitter Effects

Incorporating a flaked, coated polyester glitter into conventional translucent/clear plastisol products, leads to striking, high impact transfers. A variety of flake sizes are available, with maximum impact being generated by 0.008 sq inch (0.2 mm) glitter flakes.

<b>Mesh Count</b>	10.5 for 0.008 sq inch (0.2 mm) flakes. 24 can be utilised with 0.004 sq inch (0.1 mm) flakes
<b>Recommended paper</b>	TRQ97
<b>Recommended Transfer Schedule</b>	170-190°C, for 10-15 seconds, medium pressure, wait until paper has cooled prior to removal.
<b>Mixing Ratio</b>	Up to 25% Glitter (by weight) may be added.

### Printable Adhesives and Adhesive Powder

XM451 (white) and XM452 (clear) adhesives can be used to overprint OP colours and TJ452 to overprint ON colours to give better adhesion to synthetic substrates or to reduce the transfer temperature to as low as 160°C.

<b>Recommended Mesh</b>	21-43
<b>Recommended Transfer Schedule</b>	160-170°C for 10-15 seconds.

Maximum adhesion onto synthetic garments can be achieved using the XM378 Transfer Adhesive powder. To use this process, print the plastisol print as recommended, sprinkle the back of the wet ink with the adhesive powder prior to setting. Vacuum/Shake to remove excess. Transfer would then be as recommended for printable adhesives.

**Due to the variable nature of synthetic coatings, prints should be fully tested for suitability before commencing production.**

## 2. WORKWEAR TRANSFERS (Badges)

Workwear Transfers or Badges are specifically designed for applications where maximum mechanical and wash resistance are required.

### Overview

#### Products Required

##### Colours

Nylohex NX solvent-based inks (see page 11 for full colour range).

##### Adhesives

XTA01 Special Adhesive – White  
 XTA07 Special Adhesive – Clear  
 Available in 5L containers.

##### Additives

NB386 NB Catalyst  
 Available in 1 ltr and 0.2 ltr containers.  
 ZE811 Hold Out Additive  
 Available in 0.2 kg containers.  
 ZEA09 Flow Aid  
 Available in 5 ltr and 1 ltr containers.

##### Solvents

ZE805 Nylo Thinner  
 ZE806 Nylo Retarder  
 ZE592 S.303 WB Retarder  
 Available in standard 25, 5 and 1 ltr containers.

##### Papers

TRB08, TRB20 Siliconised Transfer paper.

#### Fastness/Resistance

**Wash** Up to 95°C.  
**Dry Clean** Recommended.  
**Industrial** Recommended.

#### Transfer Equipment

Flat-bed Transfer Press.

#### Nylohex NX inks

<b>Catalyst</b>	5% Addition of NB Catalyst.
<b>Thinning</b>	If required, up to 20% ZE805 Nylo Thinner. Hot-shop conditions, up to 10% ZE806 Nylo Retarder.
<b>Mesh Count</b>	34 – 77
<b>Drying</b>	Heat set on paper until touch dry. Typically 120°C for 40 - 80 seconds.
<b>Recommended Paper</b>	TRB08, TRB20 siliconised transfer paper.

**Catalysed ink left over at the end of the printing run should be discarded. Typical pot-life, 8 hours.**

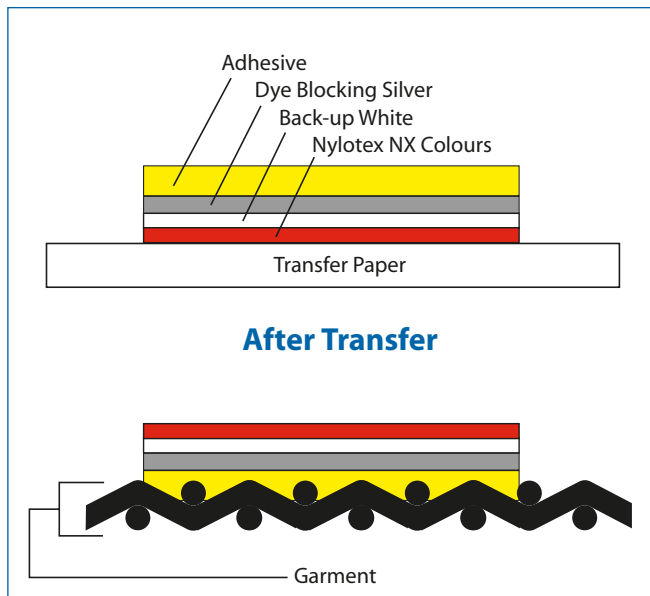
#### XTA01, XTA07 Adhesives

<b>Catalyst</b>	Not required
<b>Thinning</b>	If required, up to 5% water. Hot-shop conditions, up to 5% ZE592.
<b>Mesh Count</b>	21-27
<b>Drying</b>	Heat set on paper until touch dry. Typically 120°C for 40 - 80 seconds. For best results leave to air dry.

#### Transfer Schedule

190-200°C for 15-30 seconds.

**Workwear transfers are not suitable for use on Nylon or for application with rotary presses.**



#### Workwear Transfers – Printing Information

Inks are printed onto specialised transfer paper, then transferred with a heat press onto the garment. For some applications excellent resistance to boil-washing can be attained. The production of Workwear Transfers involves the use of two distinct systems : Nylohex NX solvent-based inks and XT water-based adhesives. For best results, backing of the colours with a flexibility layer consisting of 50:50 blend of Nylohex white and extender base is recommended. White and clear adhesives are available, with clear adhesives being recommended to maximise wash resistance.

## 3. SPORTSWEAR TRANSFERS

Sportswear Transfers are used for decorating previously sublimated materials such as Sportswear including football shirts, cycle wear etc.

### Overview

#### Products Required

##### Colours

NyloTEX NX solvent-based inks (see page 11 for full colour range).

##### Dye Blocking Silver

VVX44 Special Nylobag Silver

Available in 5 ltr containers.

##### Adhesives

XM451 MultiTran Plastisol Adhesive – White

XM452 MultiTran Plastisol Adhesive – Clear

TJ452 Advantage Transfer Clear Adhesive (formulated phthalate free)

T0458 Pioneer Transfer (water-based) Sportswear Adhesive (formulated PVC & phthalate free)

Available in 5 ltr containers.

##### Additives

NB386 NB Catalyst

Available in 1 ltr and 0.2 ltr containers.

ZE811 Hold Out Additive

Available in 0.2 kg containers.

ZEA09 Flow Aid

Available in 5 ltr and 1 ltr containers.

##### Solvents

ZE805 Nylo Thinner

ZE806 Nylo Retarder

ZE591 Plastisol Flow Thinner

Available in standard 5 and 1 ltr containers.

ON591 Advantage thinner available in 5ltr containers

ZE592 water based retarder available in 1 ltr containers.

##### Papers

TRB08, TRB20 Siliconised Transfer Paper.

#### Fastness/Resistance

**Wash** Up to 60°C.

**Dry Clean** Not Suitable.

**Industrial** Not Suitable.

#### Transfer Equipment

Flat-bed Transfer Press

### Sportswear Transfers – Printing Information

Production of Sportswear Transfers involves the use of two distinct ranges: NyloTEX NX solvent-based inks backed up with Multitran XM plastisol adhesives or Advantage Transfer TJ or T0458 Pioneer Transfer TO adhesives. For best results, backing of the colours with a flexibility layer consisting of 50:50 blend of NyloTEX NX white and extender base is recommended. Use of dye blocking layers are required when transferring onto sublimated materials, or substrates that are prone to dye bleed.

White and clear adhesives are available, with clear adhesives being recommended to maximise wash resistance.

**When producing PVC free or phthalate free transfers ensure that the correct adhesives and thinners are used to avoid contamination.**

### NyloTEX NX inks

#### Catalyst

5% Addition of NB catalyst

#### Thinning

If required, up to 20% ZE805 Nylo Thinner. Hot-shop conditions, up to 10% ZE806 Nylo Retarder.

#### Mesh Count

34 – 77

#### Recommended Paper

TRB08, TRB20 siliconised transfer paper

#### Drying

Heat set on paper until touch dry. Typically 120°C for 40 - 60 seconds depending on the heat source.

**Catalysed ink left over at the end of the printing run should be discarded. Typical pot-life, 8 hours.**

### Dye Blocking Layer

#### Ink

VVX44 Special Nylobag Silver

#### Catalyst

5% NB Catalyst

#### Extender Base

Base back with 15-25% of NX381 Extender base to improve adhesion and flexibility

#### Mesh Count

43-55

**(For best results VVX44 should be air dried overnight rather than force dried).**

### Adhesive Layer, XM451, XM452, TJ452 or T0458

#### Catalyst

Not required

#### Thinning

Adhesive: If required, up to 5% ZE591, ON591 or ZE592 (water-based). Best results are achieved unthinned.

#### Mesh Count

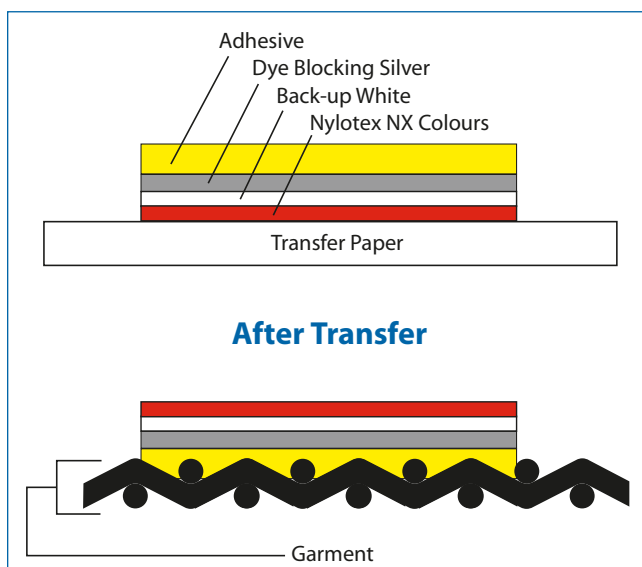
21-43 depending on detail and opacity required.

#### Drying

Heat set on paper until touch dry. Typically 120°C for 40 - 60 seconds depending on the heat source.

### Transfer Schedule

XM451, XM452 and TJ452-160-170°C for 10-15 seconds, medium to firm pressure. T0458-150-160°C for 10-15 seconds, medium to firm pressure



## 4. FOIL TRANSFERS

Foil Transfers comprise a screen printable adhesive plus heat transfer foils, for the production of mirror finish metallic prints onto cotton and many synthetic fabrics.

### Foil Transfers – Printing Information

Two options are available for the production of foil transfers, these are as follows :

#### Overview

##### Products Required

###### Metatran Transfer Foils

Standard Packing

KFT23	Gold
KFT24	Silver
KFT26	Metallic Red
KFT27	Metallic Blue
KFT28	Metallic Green
KFT32	Bronze
KFT33	Copper
KFT34	Metallic Fuchsia

Rolls 750mm x 100m.

###### Metatran Adhesive

FT421 Metatran Adhesive

Available in 5 ltr containers.

###### Reducer

ZE591 Flow Thinner

Available in 5 and 1 ltr containers.

##### Fastness/Resistance

<b>Wash</b>	Up 40°C.
<b>Dry Clean</b>	Not Suitable.
<b>Direct Iron</b>	Not Suitable.
<b>Industrial</b>	Not Suitable.

##### Transfer Equipment

Flat Bed Transfer Press

### Method 2 : Two Step Transfer Process

Print Metatran Adhesive image onto siliconised transfer paper, then transfer onto the garment. Allow to cool, then transfer Metatran foil onto the adhesive.

<b>Thinning</b>	If required, up to 5% ZE591.
<b>Mesh</b>	34 – 62.
<b>Drying</b>	Heat Set 110-120°C for 20-30 seconds
<b>Paper</b>	TRW28, TRB08 siliconised transfer paper.

### Transfer Schedule

170-180°C for 7-10 seconds

Allow adhesive transfer and foil transfer to cool before removing carrier.

### Method 1: Hybrid Transfer System

(Print image using Metatran Adhesive directly onto the fabric, set and then apply Metatran foil to adhesive image using a transfer press).

<b>Mesh</b>	34-62.
<b>Thinning</b>	If required, up to 5% ZE591.
<b>Drying</b>	Heat Set 120-140°C for 1-2 minutes.

### Transfer Schedule

170-180°C for 7-10 seconds.

(Allow the transfer to cool before removing the foil).

## 5. SUBLIMATION TRANSFERS

The Sericol Sublimation Transfers System comprises a range of dye concentrates and an extender base. When blended together they provide ready to print inks for the production of transfers for polyester and other synthetic fabrics.

### Overview

#### Products Required

##### Subliscree Aqua HQ Dye Concentrates

HQ001	Ultra Black
HQ057	Primrose
HQ103	Orange
HQ153	Carmine
HQ154	Fuchsia
HQ132	Violet
HQ218	Azure
HQ206	Deep Blue
HQ236	Reflex Blue
HQ053	Fluorescent Yellow
HQ139	Fluorescent Pink

Available in 1 kg containers.

##### Extender Base

HQ381	Extender Base (water-based).
HQ382	Extender base 2000 (solvent-based).

Available in 5 kg and 15 kg containers.

##### Thinner

ZC656	Detail Thinner
ZV552	Low Odour Thinner

Available in 5ltr and 15 ltr containers.

##### Paper

115-150 gsm matt coated cartridge.

#### Fastness/Resistance

<b>Wash</b>	60°C
<b>Dry Clean</b>	Recommended.
<b>Direct Iron</b>	Not Suitable.
<b>Industrial</b>	Not suitable.

#### Transfer Equipment

Flat-bed Transfer Press

### Sublimation Transfers – Printing Information

Water-based and solvent-based extenders are available for use with the dye concentrates. For lower grammage papers solvent-based extender HQ382 should be used to minimise paper cockle.

<b>Extender Bases</b>	HQ381, HQ382
<b>Thinning</b>	HQ381, up to 10% ZC656 HQ382, up to 10% ZV552.
<b>Mesh</b>	120–150.
<b>Drying</b>	Air drying, 3-5 mins. Can be force dried at 40-50°C for 15-20secs.
<b>Paper</b>	90-150 gsm matt coated cartridge paper is recommended

#### Transfer Schedule

200-210°C for 30-40 seconds

#### Colour Strength / Mixing Ratios

A ratio of 90 parts extender base to 10 parts dye concentrate is recommended to give good colour strength and economy of use. Colours with higher levels of dye concentrate may have reduced rub/scuff resistance.

NOTE: Due to the natural transparency of the dyes, best sublimation results will only occur when transferred onto white uncoloured substrates. Because of the wide range of synthetic substrates, it is vital to check suitability before commencing production.

To maximise tack levels to synthetic garments during the transfer process, and thus reduce the likelihood of shadowing or “blurred” edges, overprinting with a layer of extender base is recommended. For this application the extender base should be thinned 10% with the appropriate thinner (ZC656 Detail Thinner for HQ381 water-based extender and ZV552 Low Odour Thinner for HQ382 solvent-based extender).

#### Storage

When stored in a cool environment:

- HQ Dye Concentrates are expected to have a shelf-life of 24 months from the date of manufacture.
- HQ381/2 Extender Bases are expected to have a shelf-life of 12 months from the date of manufacture.
- should be stored away from heat.

## 6. FLOCK TRANSFERS

Flock Transfers are a combination of a screen printable flock transfer paper and a water-based inks/adhesive. Flock Transfer Papers are supplied either coloured, or available in white for screenprinting with colours.

### Overview

#### Products Required

##### Colours

Texiscreen Aqua AJ water-based inks (see page 11 for full range).

##### Binder Concentrate

AJ432 Binder Concentrate

Available in 1 ltr containers.

##### Adhesives

FT404 Flock Transfer Adhesive

Available in 5 ltr containers.

FT409 Flock Transfer Adhesive Powder

Available in 1 and 10 g containers.

##### Additives for Texiscreen Aqua

ZT635 WB Flow Thinner

ZE592 S303 WB Retarder

ZE596 WB Thickener

Available in 1 ltr containers.

PW386 PW Catalyst

RY386 Reflec Catalyst

Available in 500 g containers.

##### Flock Paper

Single Colour, 0.5 mm Flock Transfer Paper.

Multi-colour, 0.3 mm Flock Transfer Paper.

#### Fastness/Resistance

**Wash** 60°C

**Dry Clean** Recommended.

**Direct Iron** Not Suitable.

**Industrial** Not Suitable.

### Flock Transfers – Printing Information

Flock Transfer Papers are available at various fibre lengths. For single colour flock transfers 0.5mm Flock Transfer Paper is recommended, and is suitable for use with Sericol water-based adhesives. For multi-colour flock transfers, 0.3mm flock transfer papers should be utilised in combination with Texiscreen Aqua AJ water-based inks.

**Drying** 160°C for 2-3 minutes (for best results, sheets should be racked for 30-60 mins. before curing).

**Thinning** If required, up to 5% ZE592.

**Mesh** Inks, 34-62  
Adhesive, 21-27.

### Single Colour Flock Transfers

The recommended procedure is as follows :

1. Use 0.5mm flock transfer paper
2. Print FT404 through a 21-27 mesh
3. Whilst still wet, powder with FT409 Adhesive
4. Set at 110-120°C for 2-3 minutes
5. Brush excessive powder from image
6. Cure at 160°C for 2-3 minutes
7. Transfer at 180-190°C for 10-15 seconds

Final cure temperature, for the AJ colours, can be reduced by the addition of up to 5% of PW386 or RY386 catalyst.

### Multi-colour Flock Transfers

The following procedure should be utilised :

1. Use 0.3mm flock transfer paper
2. Print Texiscreen Aqua AJ Colour
3. Cure at 130-140°C for 1-2 minutes
4. Repeat stages 2&3 as required (each colour should be fully dried before overprinting)
5. Print FT404 through a 21-27 mesh
6. Whilst still wet, powder with FT409 Adhesive
7. Set at 110-120°C for 2-3 minutes
8. Brush excessive powder from image
9. Cure at 160°C for 2-3 minutes
10. Transfer

### Suitability of Transfers

Almost all textiles and many papers and boards can be decorated with flock transfers, but users should satisfy themselves that the transfers are compatible with the material to be decorated before commencing production.



# TRANSFER PAPERS SUMMARY

## Papers for Cold Peel Transfers

Cold peel transfers can utilise a variety of ink systems based on both plastisol and solvent chemistries. Siliconised transfer papers are the recommended products. Most papers have an optimum print side - facing up when the pack is opened. Confirmed with your paper supplier.

TRW28 Vegetable Parchment Paper  
700 x 1000 mm Packs of 250 sheets

Vegetable Parchment Paper is the thinnest transfer paper and is an economical option for single or non-registered colour transfers, Multi-colour transfers are not recommended for use with Vegetable Parchment Paper.

TRB08 T75 Transfer Paper  
700 x 1000 mm size Packs of 250 sheets

T75 (75 gsm – grammes per square metre) siliconised transfer paper is the standard recommendation for cold peel transfers. The wide format of application leads to suitability for both plastisol and solvent-based ink systems.

TRB20 T105 Transfer Paper  
700 x 1000 mm Packs of 250 sheets

T105 (105 gsm) siliconised transfer paper is used where maximum stability in paper is required. This is most suitable for use with multi-colour images where registration is critical and shrinkage is to be kept to a minimum.

TRQ97 Glitcote Transfer Paper  
635 x 965 mm Packs of 500 sheets

High gloss transfer paper can be used in combination with plastisol inks to generate high gloss prints. The transfer paper is single sided with the reverse side having no silicon coating. Glitcote Transfer paper can be used as a post-press process, to give a gloss finish.

## Transfer Paper Selector

Product Code	Transfer Type						
	Single Colour CP	Plastisol		Gloss Cold Peel	Litho	Workwear/Sportswear	
		Multi Colour Cold Peel				Single Colour	Multi-colour
TRW28	✓						
TRB08	✓	TEST		✓	✓	TEST	
TRB20	✓	✓		✓	✓	✓	
TRD16	✓	✓		✓	✓		
TRQ97		✓	✓				

## COLOUR RANGE

The list below details the inks used to produce the transfers described. Each ink range has a separate Information Sheet outlining full applications details.

	Texopaque Classic OP	Texopaque Advantage ON	Nylotex NX	Texiscreen Aqua AJ
Black	OP001†*	ON001*	NX001†*	AJ001†*
White	OP021†*	ON021*	NX021†*	AJ021†*
Opaque White	OP025†*	-	-	AJ025†*
Coating White	-	-	-	-
Light Chrome	OP042†*	ON042*	NX042†	-†*
Mid Chrome	OP043†*	ON043*	NX043†	-
Yellow	OP045†*	-	NX045†	-
Seritone Yellow (Green Shade)/Primrose	-	-	-	AJ057†*
Seritone Yellow (Red Shade)/Golden Yellow	-	-	-	AJ046†*
Seritone Orange/Orange	-	-	-	AJ103†*
Seritone Red (Yellow Shade)/Scarlet	OP134†*	ON134	-	AJ122†*
Light Orange	OP101†*	-	NX101†	-
Light Red	OP162†*	ON162*	NX162†	-
Red	-	-	NX134†	-
Deep Red	-	ON124*	NX124†	-
Brick Red	-	-	-	AJ152†*
Seritone Red (Blue Shade)/Carmine	OP124†*	-	-	AJ153†*
Fuchsia	OP154†*	-	NX154†	-
Seritone Magenta/Fuchsia	OP165†*	ON165*	-	AJ154†*
Deep Violet	OP127†*	-	NX127†	-
Seritone Violet/Violet	OP166†*	ON166*	-	AJ132†*
Seritone Blue/Azure	OP203†*	ON203*	-	AJ218†*
Light Blue	-	ON206*	NX227†	-
Blue	OP212†*	-	NX212†	-
Seritone Blue RS/Deep Blue	OP206	ON 206	-	-
Navy Blue	OP207	-	-	-
Oxford Blue	-	-	-	AJ219†*
Bright Green	OP283	-	-	-
Emerald Green	-	-	-	AJ315†*
Seritone Green/Sea Green	OP285†*	ON285*	-	AJ316†*
Green	OP320†*	-	NX320†	-
Brown	-	-	-	AJ343†*
Terracotta	OP342	-	-	-
Metallic Gold	-	-	-	AJ475†*
Metallic Silver	-	-	-	AJ476†*
Extender Base	-	ON381*	NX381*	AJ381*
Extender Base (Opaque)	-	-	-	-
Opaque White Base	-	-	-	AJ403*
Metallic Ink Medium	-	-	-	AJ382*
Transparent Split Additive	-	-	-	-
Expanding Base	-	-	-	-
Fluorescent Yellow L	-	-	-	AJ053*
Opaque Fluorescent Yellow L	OP077*	-	-	-
Fluorescent Orange M	-	-	-	AJ105*
Opaque Fluorescent Orange M	OP119*	-	-	-
Fluorescent Red M	-	-	-	AJ137*
Opaque Fluorescent Red M	OP179*	-	-	-
Fluorescent Magenta M	-	-	-	AJ139*
Opaque Fluorescent Magenta M	OP180*	-	-	-
Fluorescent Green M	-	-	-	AJ312*
Opaque Fluorescent Green M	OP294*	-	-	-
Trichromatic Yellow	OP058*	-	-	AJ052*
Trichromatic Cyan	OP215*	-	-	AJ215**
Trichromatic Magenta	OP135*	-	-	AJ135*
Trichromatic Black	OP004*	-	-	AJ004*
Trichromatic Extender Base	OP396*	-	-	-
Transparent Glitter Base	-	XM397*	-	-

† Available in 1 ltr containers. \*Available in 5 ltr containers. †\*Available in 1 and 5 ltr.

Do not use AJ025 Opaque White with AJ333 Cold Cure Catalyst.

## Fujifilm Sericol UK Limited

- Has certification to the International Environmental Standard, ISO 14001.
- Is committed to minimising the risk to users of our products, and also to minimising the impact of our activities on the environment, from formulation through to production and supply.
- Research & development team, work to an in house Health, Safety and Environmental policy, termed 'Design for Health, Safety and Environment', with the aim of proactively developing products with the least impact on health, safety and the environment.
- Regularly review and monitor our impacts and activities, setting objectives and targets as part of a continual improvement process.
- Is committed to reducing waste through better use of raw materials, energy, water, re-use and recycling.

## Safety and Handling

MultiTran XM, Nylotex NX, Taxiscreen Aqua AJ screen Inks, Metatran Adhesive and Subliscreen HQ Dye Concentrates & Extender Base:

- are formulated to be free from any chemicals toxic to health, carcinogenic, mutagenic or reprotoxic according to Directive 67/548/EC (as amended).
- For optimum shelf-life, all products should be stored at moderate temperatures, between 5°C and 30°C. Storage outside of these temperatures may lead to deterioration in the performance of the product.

Multritrans XM, Nylotex NX and Taxiscreen AJ:

- are formulated free from lead and other heavy metals and are tested to comply to the EN71-3: 1995 Toy Safety Standard.

Nylobag NB, Metatran Adhesive, Subliscreen HQ Dye Concentrates and Extender base:

- are not routinely tested, but are formulated to comply with the EN71-3 1995 Toy Safety Standard.

MultiTran XM, Nylotex NX, Taxiscreen Aqua AJ screen inks, Metatran Adhesive and Subliscreen HQ Dye Concentrates & Extender Base:

- have a flashpoint greater than 55°C and are therefore not classified as a "dangerous substance" under the Dangerous Substances and Explosive Atmospheres Regulations (DSEAR).

Taxiscreen Aqua AJ

- **do not use AJ333 Cold Cure Catalyst in AJ Metallic Colours as this can lead to an exothermic reaction, which could cause the container to explode.**
- **MP477 and MP478 Bright Metallic Gold and Silver Powders should not be poured, as this can give rise to electrostatic discharges. These powders should be ladled when transferring from one container to another.**

Comprehensive information on the safety and handling of MultiTran XM, Nylotex NX & Nylobag NB, Taxiscreen Aqua AJ screen inks, Metatran Adhesive and Subliscreen HQ Dye Concentrates & Extender Base are given in the appropriate Sericol Safety Data Sheets.

Due to the complex nature of decorating garments with transfers, customers must confirm suitability through pre-production testing.

## Environmental Information

MultiTran XM, Nylotex NX & Nylobag NB, Taxiscreen Aqua AJ Inks and Metatran Foils and Adhesive:

- do not contain ozone depleting chemicals as described in the Montreal Convention.

MultiTran XM, Taxiscreen Aqua AJ inks and Subliscreen HQ381 Extender Base:

- are formulated free from aromatic hydrocarbons which are known to have an adverse effect on the environment.
- are free of any volatile solvent and are therefore beneficial to the environment when compared to solvent-based products.

*The information and recommendations contained in this Product Information Sheet, as well as technical advice otherwise given by representatives of our Company, whether verbally or in writing, are based on our present knowledge and believed to be accurate. However, no guarantee regarding their accuracy is given as we cannot cover or anticipate every possible application of our products and because manufacturing methods, printing stocks and other materials vary. For the same reason our products are sold without warranty and on condition that users shall make their own tests to satisfy themselves that they will meet fully their particular requirements. Our policy of continuous product improvement might make some of the information contained in this Product Information sheet out of date and users are requested to ensure that they follow current recommendations.*

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More than ink...Solutions.



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