



**WATER SLIDE  
DECALS**

**EPTAINKS**



# ◦ ◦ ◦ ◦ ◦ WATER SLIDE DECALS

## WHAT IS A WATER SLIDE DECAL

It is an indirect printing system, based on the realization and application of a graphic transfer, for the decoration of such substrates, which, due to their dimensions or essential features, make direct printing difficult or impossible.



## SUBSTRATES FOR APPLICATION



The essential requirement for this application is the varnishing of the substrate, which may be made of metal, fiberglass or every kind of plastics: polyethylene, polypropylene, PVC, PETG, PC, ABS.





# ° ° ° WATER SLIDE DECALS

## WHEN USING WATER SLIDE DECALS

The application fields are many:



**BIKE FRAMES**



**SPORT EQUIPMENT**



**ITEMS IN GENERAL\***  
\*for high quality merchandising  
with particularly sophisticated  
graphic works.



**HELMETS\***  
\*as an alternative to the  
in-moulding decoration  
process



## WHY USING WATER SLIDE DECALS

- Because it is possible to realize every graphic work. It is ideal for those sectors, which are attentive to communication and are influenced by the designers.
- Because they have a limited thickness [25-30] micron, if compared with the self-adhesive materials [100] micron, so they are perfectly integrated with the object.
- Because the mandatory over-varnishing allows to increase the general fastness, and in particular the mechanical resistance.



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## THE PRINTING STEPS

### SUBSTRATE SPECIAL PAPER

**Special Paper** which assures an excellent register and a high definition

01

#### PRINTING OF THE WHITE INK

Printing of the chosen white ink of the series **Texylon**, which includes 2 white inks dedicated to the realization of the decals

02

#### PRINTING OF THE GRAPHIC WORK

Printing of the colours, according to the chosen graphic work

03

#### PRINTING OF THE TRANSPARENT INK

Printing of the transparent ink, which protects the graphic work

04

#### PRINTING OF THE COLLODION

Printing of the collodion [fixed or peelable], which is the vehicle for transferring the decal from the paper to the substrate to be decorated

DECAL  
APPLICATION

## TRANSFER PREPARATION

01

### PRINTING & CHOICE OF THE WHITE INK

It is possible to choose between:

**58.030  
TEXYLON BIANCO  
DECALS**

Ready to use, opaque,  
flexible and elastic,  
ideal for industrial  
productions.

**58.101  
TEXYLON BIANCO  
COPRENTE**

Opaque, flexible and  
elastic,  
it allows an optimal  
graphic result.



## TRANSFER PREPARATION

01

### PRINTING & CHOICE OF THE WHITE INK

The choice of the white ink depends on the desired final result and the printing tools

PRODUCT	SCREEN		DILUTION	DRYING	
58.101 TEXYLON BIANCO	[Th/cm] 77	Nr Strokes 2	Diluyente 90.924 30%	T. °C 25-30 HR 60%	h 3-4
58.030 TEXYLON BIANCO DECALS	[Th/cm] 77	Nr Strokes 2	Diluyente 90.924 30%	T. °C 25-30 HR 60%	h 3-4

#### Drying must peremptorily take place with air or in a **WICKET** oven

The use of forced drying or different conditions as the ones mentioned in the table has a negative influence:

- **on the flexibility of the transfer**, compromising the final result
- **on the dimensional stability of the paper** [extremely critical factor], compromising the final result.

# ◦ ◦ ◦ ◦ ◦ WATER SLIDE DECALS



## TRANSFER PREPARATION

02

### PRINTING & CHOICE OF THE COLOURS

It is possible to choose among different products offered by the **Texylon** series:

- SIXTEEN FULL COLOURS
- FOUR-COLOUR PROCESS INKS
- SIX TRANSPARENT COLOURS
- METALLIC PIGMENTS
- PANTONE BASES FOR THE REALIZATION OF MORE THAN 900 COLOURS

## TRANSFER PREPARATION

02

### PRINTING & CHOICE OF THE COLOURS

The printing sequence must be chosen according to the graphic work to be realized: the only peremptory condition is the printing of the white ink as first printing colour

PRODUCT	SCREEN		DILUTION	DRYING	
58.000 TEXYLON COLORATI	[Th/cm] 77	Nr Strokes 1	Diluyente 90.924 30%	T. °C 25-30 HR 60%	h 3-4

Wait for the perfect drying of the printed colour, before printing the next one: a bad drying will compromise the register and the stability of the realized transfer

## TRANSFER PREPARATION

03

### PRINTING OF THE TRANSPARENT INK

**Trasparente 59.800** of the series **Texylon** perfectly adjusts itself to every need of flexibility and elasticity required by the process.

PRODUCT	SCREEN	DILUTION	DRYING
59.800 TRASPARENTE	[Th/cm] 77   Nr Strokes 1	Diluyente 90.924 10%	T. °C 25-30 HR 60%   h 12

- The transparent ink must be printed by keeping a 2-3 mm surplus in comparison with the register, in order to assure a perfect completing of the graphic work.
- The additive 90.912 [laying agent] must be added only if it is necessary to improve the laying of the transparent ink.
- In case, add 3% of 90.908 when the decal will be transferred onto a helmet which has to be over-varnished with a soft-touch varnish.

## TRANSFER PREPARATION

04

### PRINTING OF THE COLLODION

**COLLODIO  
SPELLICOLABILE C  
95.867**

it is the ideal choice for  
sophisticated graphic works  
and high range productions



## TRANSFER PREPARATION

04

### PRINTING OF THE COLLODION

The peelable collodion allows to obtain decals having a lower thickness, which assure a better integration with the substrate to be decorated.

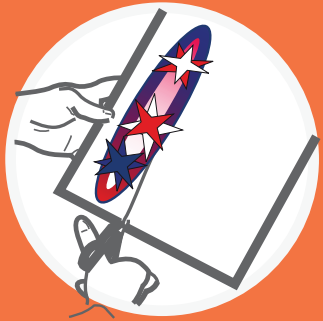
PRODUCT	SCREEN		DRYING	
95.867 COLLODIO SPELLICOLABILE	[Th/cm] 24	Nr Strokes 2	T. °C 25-30 HR 60%	h 24

Drying of the collodion layer is the most critical phase during the realization of the decals: its perfect drying allows to remove it optimally during the application of the decal, which would otherwise result to be difficult.

# ° ° ° WATER SLIDE DECALS

## DECAL APPLICATION

The application of the water slide decal is a very delicate operation, requiring an extreme precision



01

### CUT

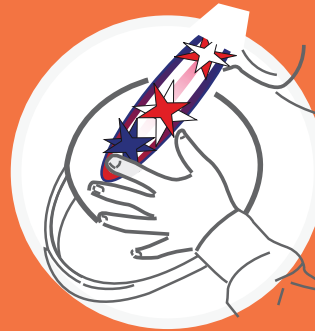
the decal along the border, before dipping it into water, but leaving a 2-3 mm surplus



02

### DIP

the decal into water for 2-3 minutes and then remove it from the substrate paper



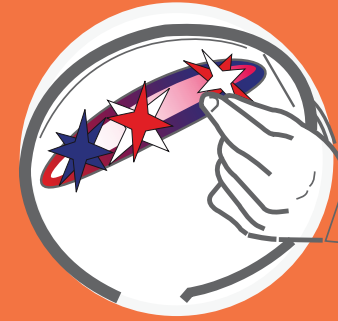
03

### POSITION

the decal onto the object to be decorated and lay it uniformly through a soft rubber spatule with rounded edge

### DRY

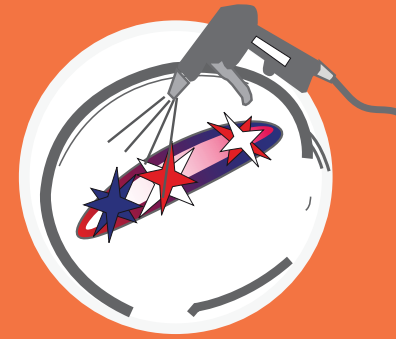
the object into a forced ventilation oven at 60°C during about 1 hour



04

### If PEELABLE COLLODION

was used, lift a corner of the decal to start removing it



05

### FINAL VARNISHING

Use solvent-based or UV varnishes and apply them by spraying



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