TRANSFER PRINTING

EPTAINKS
TOPICS

WHAT IS A “TRANSFER SET”

WHY AND WHEN CHOOSING A TRANSFER PRINTING

TRANSFER PREPARATION

EXAMPLES OF TRANSFERS

FAQ

HOW TO SELECT THE MOST SUITABLE TRANSFER
WHAT IS A “TRANSFER SET”

A transfer set is a succession of ink layers, chemically similar or different, that are first applied on a substrate and then transferred through heat onto a fabric.
<table>
<thead>
<tr>
<th>WHY AND WHEN CHOOSING A TRANSFER PRINTING</th>
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<tbody>
<tr>
<td>In case a design has to be applied on different types of substrates</td>
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<td>In case a design has to be repeated in different times and in a limited quantity</td>
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<td>It allows to get a definition which is really close to the “graphic” printing one</td>
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<tr>
<td>It helps optimizing stocks of ready made garments</td>
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<tr>
<td>It allows to make decorations where direct printing cannot be done</td>
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</tbody>
</table>
The substrates on which to create the transfer are:

- Silicone
- Paper
- Polyester
# SUBSTRATES

The substrate should have the following features:

- High stability to heat
- High stability to the inks being used
- High release capacity
  The Transfer must not be damaged during the release
It assures adhesion between fabric and transfer

It protects the transfer design from possible colour migration of synthetic fabrics

It grants opacity onto dark substrates

Colours which compose the design (specular image)

Transparent layer for a higher fastness
The printing method for transfers is wet on dry: each ink layer needs to be dried before the application of the successive one.

The squeegee should always have a correct hardness in relation to the required effect:

- **HARD**
  - high DEFINITION
  - low DEPOSIT
- **SOFT**
  - low DEFINITION
  - high DEPOSIT

The screen should have a correct out of contact to achieve right printability and definition.
The Transfer onto fabric occurs by means of **heat** and **pressure**. The Transfer adhesive melts and penetrates into the fabric; once cold, it turns back solid and physically binds to the fabric.

Transfer conditions are the following:

- **Temperature**
- **Time**
- **Pressure**
TRANSFER PRINTING

CLASSIFICATION

- TRANSFER WITH PLASTISOL INKS
- TRANSFER WITH WATER-BASED INKS
- TRANSFER WITH SOLVENT-BASED INKS
- TRANSFER FOR SPECIAL EFFECTS
TRANSFER WITH PLASTISOL INKS

- Traditional Plastisol Transfer
- Hot Split Transfer
- Off Set Transfer

EPTAINKS
TRANSFER WITH WATER-BASED INKS

- Transfer for Working Clothes
- Transfer for Elastic Fabrics
- Transfer for Sportswear

EPTA INKS
TRANSFER WITH SOLVENT-BASED INKS

“GRAPHIC” TRANSFER

TRANSFER FOR NYLON FABRICS
TRANSFER FOR SPECIAL EFFECTS

GLITTER TRANSFER

PUFF TRANSFER
TRANSFER WITH PLASTISOL INKS

TRADITIONAL PLASTISOL TRANSFER

<table>
<thead>
<tr>
<th>ADHESIVE</th>
<th>TEXIPLAST TRANSFER TRASPRENTE PF</th>
<th>[32-34]</th>
<th>[110° -120°C] 90”/60”</th>
</tr>
</thead>
<tbody>
<tr>
<td>BACKGROUND WHITE</td>
<td>TEXIPLAST 7000 WHITE SUPER BRIGHT</td>
<td>[34-55]</td>
<td>[110° -120°C] 90”/60”</td>
</tr>
<tr>
<td>GRAPHIC</td>
<td>TEXIPLAST 7000 MS or TEXIPLAST 7000 OP (COLOURS)</td>
<td>[34-120]</td>
<td>[110° -120°C] 90”/60”</td>
</tr>
</tbody>
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<table>
<thead>
<tr>
<th>SUBSTRATE</th>
<th>INK</th>
<th>SCREEN (Th/cm)</th>
<th>DRYING</th>
</tr>
</thead>
<tbody>
<tr>
<td>SILICONE PAPER</td>
<td></td>
<td></td>
<td></td>
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</tbody>
</table>

TRANSFER CONDITIONS

- TEMPERATURE: 180°C
- TIME: 12 SECONDS
- PRESSURE: 4 bar
- PEEL – OFF: COLD
### Transfer Conditions

**Temperature:** 180°C  
**Time:** 10 seconds  
**Pressure:** 4 bar  
**Peel-off:** Hot

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### Transfer with Plastisol Inks

**Adhesive:** Texiplast Transfer Trasparente PF  
**Background:** White  
**Graphic:** Texiplast 7000 or Texiplast 7000 MS (colours)  
**Substrate:** White Super Bright  
**Ink:** [32-34]  
**Screen (Th/cm):** [34-55]  
**Drying:** [110° - 120°C] 90°/60°
TRANSFER PRINTING

TRANSFER WITH PLASTISOL INKS

ADHESIVE: TEXIPLAST 7000 LYTHO TRANSFER BIANCO
[32-34] [110° -120°C] 90º/60º

GRAPHIC: INCHIOSTRI OFF SET

PROTECTIVE LAYER: TEXYLON TRASPARENTE
[43-90] [110° -120°C] 90º/60º

SUBSTRATE

INK

SCREEN (Th/cm)

DRYING

TRANSFER CONDITIONS

TEMPERATURE: 180°C
TIME: 12 SECONDS
PRESSURE: 4 bar
PEEL – OFF: COLD
TRANSFER WITH WATER-BASED INKS

**TRANSFER FOR WORKING CLOTHES**

**ADHESIVE**
- TEXIFLOCK AR
- [32-34] [100° -120°C] 90°/60”

**BACKGROUND WHITE**
- TEXILAC BIANCO LUCIDO
- [32-43] [110° -120°C] 90°/60”

**GRAPHIC**
- TEXILAC TRASP LUCIDO +5%
- TEXILAC COLORANTI or ECOTEX P PIGMENTI
- [43-90] [110° -120°C] 90°/60”

**PROTECTIVE LAYER**
- TEXILAC TRASPARENTE LUCIDO
- [90-100] [110° -120°C] 90°/60”

**SUBSTRATE**
- SILICONE PAPER or POLYESTER

**INK**
- SCREEN (Th/cm)

**DRYING**
- PRESSURE: 4 bar
- PEEL – OFF: COLD

**TRANSFER CONDITIONS**
- TEMPERATURE: 180°C
- TIME: 15 SECONDS
TRANSFER WITH WATER-BASED INKS

ADHESIVE
- TEXIFLOCK E-FF
- [32-34]
- [110° - 120°C]
- 90°/60"

BACKGROUND WHITE
- TEXILAC E-LF EXTRA WHITE
- [34-55]
- [110° - 120°C]
- 90°/60"

GRAPHIC
- TEXILAC E-LF BASE or TRASP + 5% TEXILAC COLORANTI or ECOTEX P PIGMENTI
- [34-90]
- [110° - 120°C]
- 90°/60"

SUBSTRATE: POLYESTER

INK

SCREEN (Th/cm)

DRYING

TRANSFER CONDITIONS
- TEMPERATURE: 180°C
- TIME: 15 SECONDS
- PRESSURE: 4 bar
- PEEL – OFF: COLD
TRANSFER WITH WATER-BASED INKS

TRANSFER FOR SPORTSWEAR

ADHESIVE: TEXIFLOCK E-FF

ANTI-BLEEDING BARRIER: +30% 96.125 ARGENTO
AQUA WHITE NO LEAFING

BACKGROUND WHITE: AQUA WHITE

GRAPHIC: AQUA BASE or TRASPARENTE
+ 5% TEXILAC COLORANTI or ECOTEX P PIGMENTI

SUBSTRATE: POLYESTER

INK: [32-34] [32-55] [34-55] [34-90]

SCREEN (Th/cm)

DRYING: [100° -120°C] 90”/60”

TRANSFER CONDITIONS

TEMPERATURE: 180°C

TIME: 15 SECONDS

PRESSURE: 4 bar

PEEL – OFF: COLD
TRANSFER WITH SOLVENT-BASED INKS

**ADHESIVE**
- TEXIPLAST TRANSFER TRASPARENTE PF
- [32-34]
- [100° -120°C]
- 90°/60°

**BACKGROUND WHITE**
- TEXIPLAST 7000 WHITE SUPER BRIGHT
- [43-55]
- [100° -120°C]
- 90°/60°

**GRAPHIC**
- VINILFLAT (COLOURS)
- [77-120]
- [100° -120°C]
- 90°/60°

**PROTECTIVE LAYER**
- VINILFLAT TRASPARENTE
- [90-100]
- [100° -120°C]
- 90°/60°

**INK**

**SUBSTRATE**
- SILICONE PAPER

**TRANSFER CONDITIONS**
- TEMPERATURE: 180°C
- TIME: 15 SECONDS
- PRESSURE: 4 bar
- PEEL – OFF: COLD
TRANSFER WITH SOLVENT-BASED INKS

- **ADHESIVE**: TEXITON STICK [32-43] [100° -120°C] 90°/60°
- **GRAPHIC**: TEXITON (COLOURS) [55-120] [100° -120°C] 90°/60°
- **PROTECTIVE LAYER**: TEXITON TRASPARENTE [90-100] [100° -120°C] 90°/60°

**TRANSFER CONDITIONS**
- **TEMPERATURE**: 160°C
- **TIME**: 15 SECONDS
- **PRESSURE**: 4 bar
- **PEEL – OFF**: COLD

**SILICONE PAPER**
TRANSFER FOR SPECIAL EFFECTS

- **ADHESIVE**: TEXIPLAST TRANSFER TRASPIRENT PF
  - **INK**: TEXIPLAST GT TRASPIRENT + 20% GLITTERS
  - **SCREEN**: 120
  - **DRYING**: [110° - 120°C] 90°/60°

- **GRAPHIC “BACKGROUND”**: TEXIPLAST 7000 PROCESS
  - **INK**: TEXIPLAST GT TRASPIRENT + 20% GLITTERS
  - **SCREEN**: [12-32]
  - **DRYING**: [110° - 120°C] 90°/60°

- **GRAPHIC “DESIGN”**: TEXIPLAST 7000 PROCESS
  - **INK**: TEXIPLAST GT TRASPIRENT + 20% GLITTERS
  - **SCREEN**: 120
  - **DRYING**: [110° - 120°C] 90°/60°

**TRANSFER CONDITIONS**
- **TEMPERATURE**: 180°C
- **TIME**: 12 SECONDS
- **PRESSURE**: 4 bar
- **PEEL – OFF**: COLD
TRANSFER FOR SPECIAL EFFECTS

ADHESIVE
- TEXIPLAST TRANSFER TRASPERENTE PF
- [32-34]
- [110° -120°C] 90°/60°

BACKGROUND WHITE
- TEXIPLAST 7000 WHITE SUPER BRIGHT + TEXIPLAST ADD. RIGONF. PF
- [34-43]
- [110° -120°C] 90°/60°

GRAPHIC
- TEXIPLAST 7000 MS o TEXIPLAST 7000 OP (COLOURS)
- [34-120]
- [110° -120°C] 90°/60°

SUBSTRATE
- SILICONE PAPER HOT SPLIT

INK
- [110° -120°C] 90°/60°

SCREEN (Th/cm)
- [110° -120°C] 90°/60°

DRYING

TRANSFER CONDITIONS
- TEMPERATURE: 180°C
- TIME: 10 SECONDS
- PRESSURE: 4 bar
- PEEL – OFF: HOT

PUFF TRANSFER
<table>
<thead>
<tr>
<th>FAQ REGISTER TROUBLES</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>THE PAPER MOVED DUE TO OVERHEATING</strong></td>
</tr>
<tr>
<td>01</td>
</tr>
<tr>
<td><strong>THE PAPER IS NOT ENOUGH STABLE OR UNSUITABLE FOR THE INK BEING USED</strong></td>
</tr>
<tr>
<td>02</td>
</tr>
<tr>
<td><strong>SCREEN MESH WITH INSUFFICIENT TENSION</strong></td>
</tr>
<tr>
<td>03</td>
</tr>
<tr>
<td><strong>PAPER “ CURLING ” - WATER-BASED PRINTING</strong></td>
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<tr>
<td>04</td>
</tr>
</tbody>
</table>
## FAQ

### TRANSFER DIFFICULTY

<table>
<thead>
<tr>
<th></th>
<th>EXCESSIVE DRYING OF THE ADHESIVE</th>
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<tbody>
<tr>
<td>01</td>
<td>Check drying conditions of the adhesive. Too high conditions can damage irreparably the adhesive</td>
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<thead>
<tr>
<th></th>
<th>UNSUITABLE TRANSFER CONDITIONS</th>
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</thead>
<tbody>
<tr>
<td>02</td>
<td>Pressure, time and temperature have to be appropriate. If pressure cannot be increased, transfer time has to be longer</td>
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<thead>
<tr>
<th></th>
<th>UNCORRECT TRANSFER RELEASE</th>
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<tbody>
<tr>
<td>03</td>
<td>Handle with care the piece before peeling off the transfer. In case the transfer foil tends to raise when the piece is taken from the heat press, image borders could come off from the piece</td>
</tr>
</tbody>
</table>
FAQ
POOR WASH RESISTANCE

01 UNCORRECT COMPOSITION OF THE TRANSFER
Print as first layer a transparent ink, which assures a higher mechanical wash resistance

02 UNCORRECT FILM PREPARATION TO PRINT THE ADHESIVE
Prepare the screen for the adhesive with a film which has a slightly larger dimension than the one of the design
HOW TO SELECT THE MOST SUITABLE TRANSFER
TRANSFER WITH HIGH DEFINITION

The Transfer prepared with Vinilflat (“graphic” transfer) is the one with the highest definition; excellent results can be achieved anyway with the Transfer prepared with Texylon (transfer for nylon fabrics).
HOW TO SELECT THE MOST SUITABLE TRANSFER
TRANSFER WITH HIGH STABILITY IN THE SCREEN

Transfer prepared with Texiplast does not present any drying of the ink on the screen.

TRANSFER WITH PLASTISOL INKS

- TRADITIONAL PLASTISOL TRANSFER
- HOT SPLIT TRANSFER
BE NATURAL, BE FREE!

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