

## 3D XPD®

**Description** 3D XPD® is a plotter cut PU material, with polyester backing, that expands when heat transferred.  
The final appearance of the decoration reveals a three-dimensional effect that can be customized according to the use of different transfer parameters (time and temperature).  
Average film thickness before application: **280 micron**  
Maximum thickness at the suggested transfer instructions: **1000 micron**

**Basic information** Due to the many different base materials available on the market, the following instructions are given as a guideline only :  
Plotter settings (eg. with SUMMACUT D60 – ROLAND GX24)  
Blade: **new at 50°**  
Minimum required pressure: **100 gf**  
**Transfer setup**  
**1<sup>st</sup> step** – Temp.: **175°C** Time: **3÷5"** Pressure: medium (3 ÷ 4 bar)  
**2<sup>nd</sup> step** – Temp.: **175°C** Time: **15÷25"** Pressure: depending on the desired effect

**Application instructions** **N.B.: we highly recommend cutting details not smaller than 1 cm.**

Remove the protective layer  
Mirror cut the material  
Weed the exceeding material  
Place the material on the garment with its polyester backing  
Heat apply for the first 3÷5 seconds  
Remove the support and proceed with the following 15÷25 seconds in order to

**Suitable textiles** Cotton, polyester and blends of these materials  
(not suited for treated and dye sublimation fabrics)

**Washing instructions** Wait **24h** after the heat transfer  
**30°C Max** - inside out  
Do not use bleach or other aggressive chemical agents.  
Dry clean: **no**  
Tumble dry: **no**



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N.B.  
All information given in this sheet are based on our experience.  
We always recommend performing a test before starting standard production.  
For best results we recommend to store the product away from direct sunlight.

The product meets the Italian and EU regulations relating to its proper use, and to the (EU) regulation n. 1907/2006/EU REACH (Registration, Evaluation, Authorization and Restriction of Chemical substance). This document can be subject to variations. Updated versions are available on our website www.siser.it. For further information, please contact our Sales Office.  
Thank you.