

# **TRANSFER PAPER**

## *Rotogravure*

### *Product Description ENG*

Date 07.10.2024

#### **DESCRIPTION**

Transfer paper printed with rotogravure process for heat transfer printing.

#### **SUPPORT**

- Paper weight: 20-30-40 g/m<sup>2</sup>
- Print width: 1600-1860 mm
- Core diameter: 70-75 mm
- Roll diameter: 90 mm to 220 mm
- Roll length: 500-750-1000 m

#### **PRINTING**

Rotogravure printing with disperse dyes, ethanol-based inks.

#### **APPLICATION SYSTEM**

It's possible to apply the product both with flat press than calenders.

The standard Miroglio parameters for the application on fabric are

	Temperature	Time	Pressure	Speed
Flat press	205 [°C]	25 [sec]	2-3 [bar]	
Calender	205 [°C]	25 [sec]	2-3 [bar]	( equation below )

#### **Equation for calculating diameter / speed of calendering**

Execution temperature 401°F and 26 sec

$$\frac{[(\emptyset \text{ mt heated cylinder} \times 3.14) - 0.20(\text{standard drawing})]}{\text{Contact time ( sec )}} \times 60 = \text{optimum transfer speed in calender ( mt/min )}$$

It is recommended to optimize the operating conditions through tests carried out with the actual production, depending on the means of transfer and the nature of the fabric to process.

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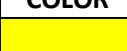


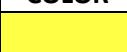
Before transferring the paper/film product, the support and the product paper/film must be checked, so that the print transfer process works correctly. The responsibility of the supplier is limited to the first 25 meters of transferred fabric/support.

### **QUALITY AND R&D**

Internal quality checks are performed through application of comparative tests with the master (first standard production) for the evaluation of the color shade on the decorated fabric surface.

### **TIPICAL LIGHT FASTNESS VALUES OF PIGMENTS**

SUBLIMATIC COLOR	COLOR	TIPICAL LIGHT FASTNESS
YELLOW		5
YELLOW AS		6
RED		6
BLUE / VIOLET		6
BLUE / GREEN		5
BLUE AS		6
BLACK		4/5

SUBLIMATIC FLUO COLOR	COLOR	TIPICAL LIGHT FASTNESS
YELLOW FLUO		3
RED FLUO		3

The effective solidity values, for any design/colourway depend on the following:

- amount of ink / colour used in that design / engraving
- varnish dilution (colour intensity)
- type of fabric
- transfer conditions

The best printing conditions must be evaluated on the final application of the product in order to assure the longest "service life" of the final product.

### **STORAGE**

Keep the product in a cool and dry place and away from sources of heat.

### **PRODUCT EXPIRY DATE**

6 months in the above-mentioned conditions.

### **PACKAGING**

Wrapped rolls in polyethylene film and boxed in recycled cardboard.

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**NOTICE AND ADVICE**

Handle the printed product with gloves so as not to mark the print. Sublitex is not responsible for irregular applications that have not followed the operating specifications of storage provided.

***State of Art***

The above information, reflect our current "State of Art", and are disclosed by us without obligation. However possible future changes and revisions according to the evolving technology and business are possible. We invite the buyer to the verification of the information given on the basis of its technology and engineering.

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# TRANSFER PAPER

## Digital

### *Product description*

Date 17.10.2024

### **DESCRIPTION**

Coated paper printed with sublimatic inks on digital printers.

Available in the following versions:

- coated paper with digital printing of sublimatic inks;
- coated paper with digital printing (total or partial) of fluorescent sublimatic inks (see table in "Quality and R&D" FLUO series);
- coated paper with digital printing of sublimatic inks for applications that require higher light fastness (see table in "Quality and R&D" HS series).

### **PROPERTIES**

- paper weight : 39 gr/mt<sup>2</sup> - 45 gr/mt<sup>2</sup>
- roll width : 1620 mm
- print width : 1600 mm
- core diameter : 70 mm
- roll diameter : 150mm (with roll lenght of 500mt)
- roll lenght : until 500 mt in the cardboard boxes

### **PRINTING**

Digital printing of sublimatic inks water base.

#### **APPLICATION SYSTEM**

It is possible to apply the product either with flat press than calenders.

The standars Sublitex parameters of application on polyester fabric are :

	Temperature	Time	Pressure
Flat press	205 [°C] 401 [°F]	25 [sec]	2-3 [bar] 200-300 [KPa]

	Temperature	Time	Speed
Calender	205 [°C] 401 [°F]	25 [sec]	( equation below )

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## Equation for the calculation of the speed in calendering

Execution temperature 401°F and 26 sec

$$\frac{[(\text{Ø mt heated cylinder} \times 3.14) - 0.20(\text{standard threading})]}{\text{Contact time ( sec )}} \times 60 = \text{optimun transfer speed in calender ( mt/min )}$$

It is recommended to optimize operating conditions through tests carried out with the actual production, depending on the means of transfer and the nature of the fabric to process.

Before transferring the paper/film product, the support and the product paper/film must be checked, so that the print transfer process works correctly. The responsibility of the supplier is limited to the first 25 meters of transferred fabric/support.

### **QUALITY AND R&D**

Internal quality checks are performed through application of comparative tests with the master (first standard production) for the evaluation of the color shade on the decorated fabric surface.

#### FASTNESS VALUES (STANDARD INKS)

INK	COLOR	FASTNESS - EN ISO		
		105B02	105C10	105E04
BLACK		5/6	4/5	4/5
MAGENTA		6/7	4/5	5
CYAN		5/6	4/5	4/5
YELLOW		6/7	4/5	4/5

#### FLUO SERIES

INK	COLOR	FASTNESS – EN ISO		
		105B02	105C10	105E04
BLACK		5/6	4/5	4/5
MAGENTA		6/7	4/5	5
PINK FLUO		4	4/5	5
BLUE		6	4/5	5
CYAN		5/6	4/5	4/5
TURQUOISE		6	5	5
YELLOW		6/7	4/5	4/5
YELLOW FLUO		4	4/5	5

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HS SERIES				
INK	COLOR	FASTNESS - EN ISO		
		105B02	105C10	105E04
BROWN		6/7	4/5	4/5
MAGENTA		6/7	4/5	5
BLUE		6	4/5	5
YELLOW		6/7	4/5	4/5

FASTNESS - EN ISO	105B02	LIGHT FASTNESS
	105C10	WASHING FASTNESS
	105E04	PERSPIRATION FASTNESS

Tests were carried out on 100% polyester fabric by an external laboratory according to UNI EN ISO regulations.

The effective fastness changes according to :

- sublimation temperature
- amount of ink
- type of substrate / fabric to decorate

The best printing conditions are evaluated according to the design/colorway for ensure the best high resistance of the final product.

#### **STORAGE**

Keep the product in a dry place and away from heat sources and sunlight.

#### **PRODUCT EXPIRY DATE**

6 months in the above-mentioned conditions.

#### **PACKAGING**

Wrapped rolls in polyethylene film and boxed in recycled cardboard.

#### **NOTICE AND ADVICE**

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#### **State of Art**

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