






EN14 - How To Transfer Cotton Apparel/Clothing with A Hand Iron

		 HIGHEST
		30-40 SECONDS
		5 – HIGH
	VIDEO: http://youtu.be/w-INeMVUzZ4	

Before You Start

This is a guide only, based on production with Sawgrass ChromaBlast Cotton Transfer Inks and Media - times, pressures and temperatures will vary and you will need to experiment to find the optimum combination for your production system. Remember that cotton transfer requires high temperatures so take appropriate care when handling substrates and equipment.

Key Points:

Digital transfer printing allows you to create customized and personalised full colour images on a variety of cotton and poly-cotton products that rival those produced by direct-to-garment printing systems.

ChromaBlast™ utilizes heat and pressure during the production process to create a cross-link between the cotton, the inks and the media which transfers the image into the fibers of the garment. The result is a garment with a soft hand, vibrant colour and superior washability.

- Always read the manufacturer's instructions for the press and the substrate - settings may vary between brands.
- Apparel is normally done with reduced time, pressure and temperature settings.
- Different brands and styles of apparel/clothing may require different settings.
- ChromaBlast is recommended for white or light colored 100% cotton fabrics.

Minimum Equipment Required

- Sawgrass Supported Printing System
- Sawgrass ChromaBlast Cotton Transfer Inks
- Sawgrass ChromaBlast Transfer Media
- Standard Hand Iron - does not need steam
- Quality Cotton Apparel/Clothing ('the garment')
- Protective Teflon Sheets or Clean Absorbent Paper
- Clean Cotton Textile Sheet - such as a pillowcase
- Scissors
- Lint Roller
- Hard, Smooth Surface - do not use an ironing board



Instructions

- 1 Carefully measure the image area of your garment.
Create your image using a standard graphics program in RGB mode.
The ideal design and print resolution is 300dpi.



- 2 Print the image in reverse (mirrored) on to cotton transfer paper.



- 3 Trim the transfer print leaving about 3-5mm gap around the image.












- 4 Preheat the iron to the 'linen' or the highest temperature setting.
Protect your work surface with a sheet of clean cotton textile. Do not use an ironing board.



- 5 Place the garment, face-up, on the protected work surface and smooth out any folds and wrinkles.



6	Use a lint brusher or roller to remove any dust from the garment.	
7	Pre-iron the garment to remove any wrinkles.	
8	Place the transfer print on the garment, image side down.	
9	Cover with a Teflon sheet or clean absorbent paper to protect the garment.	
10	Press with the iron to transfer, using firm and heavy pressure. Press small areas at a time for 30-40 seconds* using a circular motion. Ensure all areas of the transfer are pressed.	

11	Finish by going over the entire transfer and edges for an additional 10 seconds prior to removal of the transfer.	
12	Peel the transfer off quickly and smoothly in one even motion while the garment is still hot. <i>Cold peel transfer removal is not recommended.</i>	
13	Stretch the image area from top to bottom and side to side to reduce the hand on the fabric.	
14	Cool the garment in accordance with the manufacturers' instructions.	

Recommendations

1	Make a Test Piece.	Test your settings for color, temperature, pressure and time as different cotton fabrics will exhibit slightly different results.
2	Create a Production Reference Log.	Make a log of the optimum settings for each substrate for future reference. Include substrate and manufacturer, temperature, pressure and time settings.
3	Check Printable Areas of Each Garment Size.	Take note of the variation of printable areas of different garment sizes. You may need to adjust your transfer size for each shirt size or design to suit all variables.

4	Trim Excess Media from Printed Graphic	Trim the non-printed media around the printed image before transferring to garments leaving a ¼" / 6mm margin around the printed area is recommended for light-colored garments.
5	Avoid Pressing Any Zippers, Buttons or Other Plastic Decorations	If possible, avoid pressing any zippers, buttons or other plastic decorations attached to the garment. The heat and pressure needed to bond the ink to the cotton fabric may cause these to crack or melt.
6	Pressing Time	If immediately after pressing, the paper is not easily peeled from the garment and resists removal because the transfer is somewhat tacky, increase the amount of time in the press.
7	Pressing Temperature	<p>If immediately after pressing, the transferred image has a slick or shiny appearance, increase the amount of pressure used.</p> <p><i>If the time/temperature combination is not correct it will stop ChromaBlast from completely adhering to the cotton fibers, this will result in the image washing out and cracking after a short period.</i></p>
8	ChromaBlast Media Storage	Store ChromaBlast Media in a cool, dry environment. Do not remove media from protective packaging until ready to use. Once packaging has been opened, store media in the plastic bag provided.
9	Storing Pre-Printed ChromaBlast Transfers	If a large number of transfers are printed in advance of use, place printed transfers in an airtight bag to minimize curl during storage.

Substrate	Manufacturer	Temp	Time Mins : Secs	Pressure Low - High	Notes
				1 2 3 4 5	
				1 2 3 4 5	
				1 2 3 4 5	
				1 2 3 4 5	