

# TEXTILE APPLICATIONS

## INSTRUCTIONS FOR USE

### Suitable ink systems

Water-based dye sublimation inks.

### Process parameters

#### TEMPERATURE

For dye sublimation transfer with S-RACE® higher calendering temperatures are beneficial. For best results we recommend to use a transfer temperature of 205°C to 210 °C. Using this temperature will enhance the transfer quality e.g. optical densities and line sharpness.

#### TRANSFER TIME

Sublimating with S-RACE® at 205°C to 210 °C only needs a transfer time of 25–40 sec. for optimal results:

› S-RACE® Look 55	55 g/m <sup>2</sup>	25 sec.
› S-RACE® Active 75	75 g/m <sup>2</sup>	30 sec.
› S-RACE® Active Protect 80	80 g/m <sup>2</sup>	30 sec.
› S-RACE® Tacky Protect 80	80 g/m <sup>2</sup>	30 sec.
› S-RACE® Tacky 100	100 g/m <sup>2</sup>	35 sec.
› S-RACE® Allround 100	100 g/m <sup>2</sup>	35 sec.
› S-RACE® Tacky Protect 105	105 g/m <sup>2</sup>	35 sec.
› S-RACE® Allround Protect 105	105 g/m <sup>2</sup>	35 sec.
› S-RACE® Allround 130	130 g/m <sup>2</sup>	40 sec.

If a lower transfer temperature is required the transfer time has to be increased.

*Please note: The above is a general recommendation.  
Results can vary per fabric. Testing is essential.*

### Storage

Store material only in original packaging under normal climatic conditions (23°C, 50 % RH). Protect material from direct sunlight. It is recommended to adapt the material to indoor climate at least 24 hours before usage.