General Application Recommendations Heat Transfers

LexTra® BY FIBERLOK

*** IMPORTANT INFORMATION — DO NOT DISCARD! ***

1. Machine Settings

Important: Machine must have one cushioned, soft surface

Lextra® Print Heat Transfers

Temp: 325° F (163° C)

Time: 15 seconds

Pressure: Medium
(25-35psi for heat presses approx.6" x 8";
35-50psi for heat presses approx. 16' x 20")

Lextra® 3D & Lextra® 4D Heat Transfers

Temp: 325-350° F (163-178° C)
(350° F (178° C) may increase adhesion up to 50% and is recommended if the garment or substrate can tolerate this temperature.)

Time: 20 seconds

Pressure: Medium-Firm
(60-80% of the pressure range of most machines.)

NOTE: Above settings are general recommendations. Every material and press varies, please adjust your pressure according to your machine results.
(Please refer to Page 2 for a more rigorous Testing Procedure to determine ideal settings. Staff are available to help with any application issues.)

2. Pre-Test Fabric

Check fabric for melting, scorching, curling or other problems by applying heat at the temperature recommended above. Application to waterproof/water-resistant fabrics, leather or slick nylons is not recommended, due to adhesion or scorching problems. To maximize results, use the Testing Set-Up Procedure on the reverse side.

3. Place Transfer

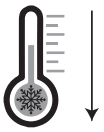
Place transfer on fabric with the adhesive side down. If Lextra® 3D & Lextra® 4D transfers are packed with slick liner paper between them, remove it first.
Optional: Place silicone sheet over item.

4. Apply Heat

Apply heat for 15 seconds, or dwell time based on Testing Procedure results on Page 2.

5. Let Cool

Remove from heat press keeping flat, without pulling or twisting while warm, which can weaken the adhesion. Allow applied transfer to cool to the touch or to room temperature in a flat position.



6. Peel Film

Peel away carrier backing, while checking that design is transferring. If not, repeat steps 3-5. If your transfer appears smashed or if you see an impression around your logo, decrease pressure incrementally and repeat steps 3-5.

7. Test Adhesion

Test transfer adhesion by machine washing with detergent. While still wet, try to pick off design. If the design only comes off in tiny bits, adhesion is satisfactory; if design can be peeled off in continuous, larger pieces, adhesion is not satisfactory. Contact us for assistance.

8. Final Check

Lint roll any excess unadhered flock fibers. Properly applied, FiberLok apparel graphics look clear, feel soft, and will last the lifetime of the garment.

FIBERLOK®
INNOVATION APPLIED

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Heat Application Testing Set-Up Procedure

Quality Window Test Matrix

Temperature					
Dwell Time (seconds)	**275° F (135° C)**	**300° F (149° C)**	**325° F (163° C)**	**350° F (178° C)**	**375° F (191° C)**
4 (secs)	*Test 1*	*Test 7*	*Test 13*	*Test 19*	*Test 25*
8 (secs)	*Test 2*	*Test 8*	*Test 14*	*Test 20*	*Test 26*
12 (secs)	*Test 3*	*Test 9*	*Test 15*	*Test 21*	*Test 27*
16 (secs)	*Test 4*	*Test 10*	*Test 16*	*Test 22*	*Test 28*
20 (secs)	*Test 5*	*Test 11*	*Test 17*	*Test 23*	*Test 29*
24 (secs)	*Test 6*	*Test 12*	*Test 18*	*Test 24*	*Test 30*

Heat Application Testing Set-up Procedure

This procedure is optional and included for optimization

1. Pressure: Set heat press machine pressure to **Medium** for most transfer sizes. For larger transfers, increase pressure to **Medium-High**, which should be approximately 60-80% of the range of settings.
2. Use numbered textile test swatches to correspond to the italicized numbers in the above matrix.
3. Apply each with above settings; wash or pick test.
4. Mark failures in matrix with an "X" and passes with an"O".
5. Note pattern of passes (O), you have now established the Quality Window. Below is an example of a completed Quality Test Matrix.

Quality Window Test Matrix

Temperature					
Dwell Time (seconds)	**275° F (135° C)**	**300° F (149° C)**	**325° F (163° C)**	**350° F (178° C)**	**375° F (191° C)**
4 (secs)	*Test 1*	*Test 7*	*Test 13*	*Test 19*	*Test 25*
8 (secs)	*Test 2*	**X**	**X**	*Test 20*	*Test 26*
12 (secs)	**X**	**O**	**O**	**X**	*Test 27*
16 (secs)	**X**	**O**	**O**	**X**	*Test 28*
20 (secs)	*Test 5*	**X**	**X**	*Test 23*	*Test 29*
24 (secs)	*Test 6*	*Test 12*	*Test 18*	*Test 24*	*Test 30*