

# Technical Data Sheet

## Textile Foil – TSX Series



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### GENERAL INFORMATION

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**TRADE NAME:** Textile Foil – TSX Series (AMAGIC Textile Foils)

**TDS REVISION DATE:** December 14, 2012 (updated)

Textile Foils are a set of brilliant, high-gloss metallic foils especially selected for applications to T-Shirts and other textile fabrics using a heat transfer process.

### SPECIFICATIONS

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**CARRIER:** 16u, 23μ and 50μ Polyester Film

**WIDTH:** Can vary between 12" and 60" inches

**COVERAGE:** Fine to Heavy

**DWELL TIME:** 12 seconds. However it can range from 6 to 30 seconds depending on adhesive system and wash durability requirement.

**PRESSURE:** 80psi (5.6 kg/cm<sup>2</sup>). However it can range from 40 to 100 psi (2.8 to 7 kg/cm<sup>2</sup>)

**TEMPERATURE RANGE:** Typically 320°F However it can range from 280°F to 380°F / 138°C to 195°C

### METHODS OF PREPARATION

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Proper preparation and application of the textile foil and inks will allow the metalized foil finish to adhere only to the desired areas and not to un-printed areas. Using a heat transfer press, the foil is transferred to the fabric on top of a receptive ink or foil adhesive which has been previously applied to the fabric.

### INK/FOIL ADHESIVE REQUIREMENTS

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Textile foil will adhere to many different foil adhesives. It will also adhere to certain acrylic, polyurethane, and water-based inks. Adhesion, flexibility, abrasion resistance and wash-ability may be improved by the addition of additives to inks/foil adhesives, changes to print processes and adjustments to heat press settings.

## FOIL ADHESIVE

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Foil adhesive can be direct screen printed or printed on heat transfer release paper. Screen mesh 61-110T (24-43 metric). Any type of stencil material (film, direct emulsion, etc.) may be used. Heat cure per your ink specifications.

## TRANSFER APPLICATION:

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Recommended Settings:

	Temperature	Pressure	Dwell Time
For Heat Transfer Machines...	290°F - 365°F	Medium/Firm	8 - 15 seconds

1. Prepare garment with foil adhesive. Mesh count should be between 60 (24cm) and 110 (43 cm).
  - *Automatic: flood>print>flood>print* could be used with an 86 mesh, *print>flash>print* would possibly give a better result with 86-110 mesh.
  - *Manual: print>flash>print* with an 86-110 mesh is suggested.
2. Cut the textile foil to the desired shape and place it, color side up, over the area chosen to be foiled.
3. Using the above settings, transfer the foil.
4. Once removed from the transfer machine, use a soft cloth to rub the foil lightly to ensure strong adhesion and full coverage.
5. For best results, cool then peel foil away.

This is a typical transfer process. However it is the customers' responsibility to test the suitability of the respective foil for the field of application they intend it for and under their transferring conditions. Adjust appropriately until desired results are achieved.

## SUGGESTED WASHING INSTRUCTIONS:

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Prints decorated with foil are not as durable as an undecorated print and it should not be expected that they withstand the punishment a regular direct print or transfer can take. Some dulling of the foil is to be expected with laundering, however to minimize this the garment should be hand washed inside out using cool or lukewarm water and dried by hanging, laying flat or rack dried. Do not dry clean.

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