



BE A HERO.

UPDATED 9/28/22

HERO – STYLE #2000 – 100% POLYESTER RTP SHIRT

The World's First Fully NON-Dye-MIGRATING 100% Polyester Shirt

PROCEDURES FOR BEST PRINT RESULTS

PRE PRINTING

- The garment must be completely void of moisture prior to printing
- This can be achieved either by using a heat press or conveyor dryer
 - Use extremely light pressure to avoid any heat press boxes
 - Suggested is about 345F for 30-60 seconds
 - Use a parchment paper to protect the polyester fabric surface
 - Preferably thread the shirt onto the heat press so only one side is heat pressed/dried.
 - If using a conveyor dryer make sure that the area to be printed is completely flat prior to going into the dryer. Test to ensure the shirt is void of all moisture.
- The shirt will be stiff after removing the moisture. *THIS IS NORMAL.*

NOTE: Shirts that are NOT completely dry will exhibit splotchy areas in a solid white under base. This will also inhibit the white ink from kicking over/gelling – which is extremely important in the DTG printing process – especially on the polyester fabric. ALWAYS MAKE SURE THE MOISTURE IS REMOVED FROM THE GARMENT PRIOR TO PRINTING.

PRINTING

- The preferred print loading method for the **HERO** shirt is to thread the shirt onto the platen. This will help eliminate any ink drop through the mesh weave of the fabric onto the inside of the back of the shirt.
- The first white under base should be a light layer of white.
- If using a RIP that allows you to custom setup print layers do the following
 - Do a first layer of white with a light amount
 - i.e. Epson F2100 you can do a NO DOUBLE STRIKE Print – then after printing the first under base of white stop the printer.
 - Then you can PRINT the image like normal.
 - i.e. Epson F2100 print with a NO DOUBLE STRIKE Print

- also max out the WHITE and COLOR Print Quality
 - You DO NOT Need to typically increase White Ink Density if following this procedure.
- You can just PRINT like normal (i.e. on the F2100 just a NO DOUBLE STRIKE print, MAX WHITE & COLOR Quality, NO White Ink Density change (0%)), however the white layer and brightness may be affected by various factors. Experiment with what you find acceptable for your customer's needs.

Note: The concept is to achieve a light white under base as the primer for the actual print. Laying down too much white ink prior to this light under base MIGHT allow the ink to “pool” up.

CURING THE PRINT

The ink MUST be cured like any other print.

HEAT PRESS CURING:

- Use EXTREMELY LIGHT PRESSURE.
 - You may find that by doing this you need to extend out your ink cure time. Typically the common rule of knowledge is TIME, TEMPERATURE & PRESSURE. All three of these act together. The lighter the pressure you won't transfer as much heat into the ink as fast, thus you may need to extend the ink cure time as there should be almost zero pressure on the ink film so as to avoid any heat press box.
 - Also, if possible, thread the shirt ONTO the heat press to cure the ink.

CONVEYOR DRYER CURING:

- Due to the nature of these shirts they LOVE to absorb moisture. You may need to extend your dwell time in the dryer slightly to achieve good, washable results for your ink set.

NOTE: After curing the garment either in the dryer OR the conveyor the shirt will become extremely stiff – **THIS IS NORMAL**. The heat press is typically not as bad as the conveyor dryer because it is a more localized heat application. This will be greatly reduced / go away with the following:

- The fabric will soften with each wash/dry cycled
- You can steam the shirt to remove most of the stiffness (and will get softer as it achieve more moisture content.
- “Handling” the shirt – i.e. crinkling, stretching, balling up the shirt will break down this stiffness
- A combination of all of the above will make the shirt more pliable before washing.

REMEMBER TO DO ALL YOU OWN TESTING PRIOR TO ANY PRODUCTION RUN!