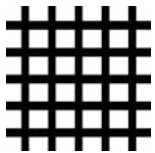


**TECHNICAL DATA SHEET****SHORT DESCRIPTION:**

Hot split transfers are easy with the 380 Series inks. With a huge color selection and creamy ink viscosity, 380 Series will print, gel, press and peel easier than any other transfer ink. The finished hot split product will be soft, flexible, and have a suede-like feel.

**QUICK SPECIFICATIONS:****MESH COUNT**  
86 to 110

380 Series requires 86 or 110 screen mesh. If you print finer screen mesh, please pre-test. So much ink will remain on hot split paper, thin ink deposits will simply not be durable. Consider our 380 Printable Adhesive as an underbase if you need more ink deposit.

**HEAT ON PAPER**  
240°F to 250°F

The ink needs to be dry to the touch but not so dry that the curing process has begun. Measure with a Thermolabel #4 stuck to the paper to be sure the temperature is correct. Over-gelled prints will not split evenly from the paper.

**HEAT PRESSING**  
375°F - 8 sec.  
Firm Pressure  
Peel Hot

Washing and drying your prints to is the ultimate test of durability. It is critical to check for even pressure as a collar or seam under the heating element will cause a print to fail. Check for hot/cold spots on the heating element with an infrared gun.

**SQUEEGEES**  
70 Durometer

Squeegees are one of many variables controlling your ink deposit. Softer squeegees are capable of printing thicker while hard squeegees allow for better print resolution. 60 durometer is soft. 70 durometer is medium. 80 durometer is hard.

**CLEAN UP**  
PW-4 or IR-26

Many cleaning products will remove plastisol ink. We recommend Saatchem PW-4 for cleaning on-press. The IR-26 is ideal when cleaning in a washout booth. Cleaning the ink out of the screen immediately after printing is always recommended.



**TECHNICAL DATA SHEET**

**380 SERIES BENEFITS:**

- The most trouble-free hot split transfer ink.
- Easiest ink to properly gel.
- Soft, flexible finish.
- Huge color selection.
- Capable of printing hot split, hot peel, and cold peel transfers.

**IDEAL HEAT PRESSING GUIDELINES:**

Press at the temperatures listed below with firm pressure. Remember, heat pressing is a time, temperature, and pressure process. All three variables must be considered along with ink thickness.

100% Cotton	Poly/Cotton	Polyester	Nylon/Stretch	100% Nylon	Polypropylene	Rayon
375°F	375°F	X	X	X	X	X

\*Although the 380 Series will adhere to 100% polyester as a hot split transfer, due to dye migration this is not recommended. If you are heat pressing white polyester, press at 375°F for 8 seconds with firm pressure. Be careful not to damage the fabric.

**TIPS AND TRICKS:**

- Test cure temperature with a Thermolabel applied to the transfer paper.
- Pre-heat the paper to prevent shrinking and humidity problems. Transfer powder will often stick to the paper if moisture is present.
- Hot peel and cold peel transfers do not require adhesive powder. However, adding adhesive powder will increase durability and bleed resistance.
- If you are getting easy cracking or peeling, it is very likely that your print is too thin, your ink is over-gelled, or your heat press pressure is not even.

Always perform a pretest print and test cure conditions on the fabric to be printed to establish the best results. Stir inks vigorously before each use. Viscosity may need adjusting for best results. If there is ever a question about a print job, call us at 800-942-4447. We are always happy to help!