



380S SERIES

TECHNICAL INFORMATION

SHORT DESCRIPTION

380S Series is our softest transfer system yet! You no longer have to choose between good coverage or soft prints when you use our 380S Series combined with our 380S Clear Base.

BENEFITS

- Delivers soft prints without being too sticky.
- Easy to properly gel.
- Custom colors are available.
- 380S Clear Base enhances the stretch and durability of your prints.

TIPS & TRICKS

- Test gel temperature with a #8 thermolabel applied to the center of your transfer paper.
- Use OSI Softpeel paper if you want to hot-peel your transfers.
- Pre-heat transfer paper to avoid shrinking in the dryer.
- Squeegee durometer impacts ink deposit. Soft squeegees print thick deposits while hard squeegees print thinner deposits.

COMPLIANCE

All of the inks manufactured by One Stroke Inks are phthalate compliant and in accordance to Proposition 65. For more information or to download individual Safety Data Sheets visit <https://www.onestrokeinks.com/shopcompliance.asp>

PRECAUTIONS

- These parameters have been set under lab conditions. We recommend doing a test run to account for variables we cannot control during our testing process.
- Avoid transferring on areas with collars or seams. Uneven pressure will cause the print to fail.
- Check for hot/cold spots on your heating element with an infrared gun.
- If you print with any screen mesh other than what we recommend please pre-test. Thicker ink deposits will likely require more time under the heat press.
- If your print is cracking or peeling, it is very likely that your print is too thin or you have over-gelled the ink.
- Release times will vary depending on which transfer paper you use. Test the release time for transfer paper other than OSI Softpeel paper.

RECOMMENDED PROCEDURE

- We recommend using OSI Softpeel paper for hot-peeling transfers.
- Print a single or multi-color design with a 110 mesh and gel at 220°F
- Print 380S Clear over the entire design with a 110 mesh and gel at 220°F
- Heat press at 375°F with medium pressure for 10 seconds.
- Peel immediately.

QUICK SPECIFICATIONS

FABRIC TYPES

- 100% Cotton
- Poly/Cotton

MESH COUNT

- 86 to 125

GEL INSTRUCTIONS

- 220°F

HEAT PRESS INSTRUCTIONS

- 375°F
- Medium Pressure
- 10 Seconds
- Peel immediately

SQUEEGEE

- 70 Durometer

CLEAN UP

- PW-4 or IR-26

For best results, stir inks vigorously before each use. Adjust viscosity to your preference. Washing and drying your prints is the ultimate test of durability. Always preform a test run to check that cure conditions have been properly set. If you have further questions, contact us at 800-942-447. We are happy to help you!

CHECK US OUT



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