



Industrial Workwear Transfers

Industrial Workwear Transfers are specifically designed for applications where maximum mechanical strength and wash resistance is required.

Transfers are made by printing catalysed (2-pack) solvent-based inks onto release paper and overprinting with a screen-printable adhesive. A heat press is then used to produce prints capable of withstanding industrial washing at 95°C. The transfers are intended for logos or identification on work garments and overalls.

Workwear transfers are not suitable for use on Nylon or for application with rotary presses.

Production of Workwear Transfers

Inks are printed onto specialised transfer paper, then transferred with a heat press onto the garment. For some applications excellent resistance to boil-washing can be attained.

The production of Workwear Transfers involves the use of Nylotex NX solvent-based inks and XTA05, a special water-based transfer adhesive. For best results, backing of the colours with a flexibility layer consisting of NB033, or alternatively a 50:50 blend of Nylotex white and extender base, is recommended.

Note: when producing Phthalate Compliant⁽¹⁾ transfers, ensure that the correct adhesives and thinners are used to avoid contamination.

Due to the complex nature of decorating garments with transfers, customers must confirm suitability through pre-production testing.

Nylotex NX inks

Catalyst: 5% Addition of NB Catalyst.

Thinning: If required, up to 20% ZE805 Nylo Thinner. Hot-shop conditions, up to 10% ZE806 Nylo Retarder.

Mesh: 34 – 77

Drying: Heat set on paper until touch dry. Typically 120°C for 40-80 seconds.

Recommended Paper: TRB08, TRB20 transfer paper.

Catalysed ink left over at the end of the printing run should be discarded. Typical pot-life, 8 hours.

XTA05 Special Transfer Adhesive

Catalyst: Not required

Thinning: If required, up to 5% water. Hot-shop conditions, up to 5% ZE592 WB Retarder.

Mesh: 21-27

Drying: Heat set on paper until touch dry. Typically 120°C for 40-80 seconds. For best results leave to air dry.

Transfer Schedule

190-200°C for 15-30 seconds.

Fastness/Resistance

Wash: Up to 95°C.

Dry Clean: Recommended.

Industrial: Recommended.

Direct Iron: Ironable with a cool iron

Transfer Equipment

Flat-bed Transfer Press.

Products Required

Colours

Nylotex NX solvent-based inks (see relevant Product Information sheet).

Adhesives

XTA05 Special Transfer Adhesive
Available in 5 ltr containers.

Additives

NB386 NB Catalyst
Available in 1 ltr and 0.2 ltr containers.

ZE A09 Flow Aid

Available in 1 ltr containers.

Solvents

ZE805 Nylo Thinner
ZE806 Nylo Retarder
ZE592 WB Retarder
Available in 5 ltr containers.

Transfer Papers

Transfer papers suitable for producing industrial workwear transfers:

TRB08 T75 Transfer Paper

700 x 1000 mm size

Packs of 250 sheets

T75 (75 gsm) transfer paper is most suitable for use with single-colour images.

TRB20 T105 Transfer Paper

700 x 1000 mm

Packs of 250 sheets

T105 (105 gsm) transfer paper is used where maximum stability on paper is required. This is most suitable for use with multi-colour images where registration is critical and shrinkage is to be kept to a minimum.

Fujifilm Speciality Ink Systems Ltd

- Has certification to the International Environmental Standard, ISO 14001.
- Is committed to minimising the risk to users of our products, and also to minimising the impact of our activities on the environment, from formulation through to production and supply.
- Research & development team, work to an in house Health, Safety and Environmental policy, termed 'Design for Health, Safety and Environment', with the aim of proactively developing products with the least impact on health, safety and the environment.
- Regularly review and monitor our impacts and activities, setting objectives and targets as part of a continual improvement process.
- Is committed to reducing waste through better use of raw materials, energy, water, re-use and recycling.

Safety and Handling

Nylotex NX Inks:

- Are formulated to be free from any chemicals toxic to health, carcinogenic, mutagenic or reprotoxic according to Directive 67/548/EC.
- Are formulated free from lead and other heavy metals and are tested to comply to the EN71-3: 1995 Toy Safety Standard.
- Have a flashpoint greater than 55°C and are therefore not classified as "dangerous substance" under the Dangerous Substances and Explosive Atmospheres Regulations (DSEAR).
- For optimum shelf-life, all products should be stored at moderate temperatures, between 5°C and 30°C. Storage outside of these temperatures may lead to deterioration in the performance of the product.

NB Catalyst:

- Contains isocyanate and should not be used by persons suffering from bronchitis or asthmatic symptoms.

XTA05:

- Is not routinely tested, but is formulated to comply with the EN71-3 1995 Toy Safety Standard.

Comprehensive information on the safety and handling of XTA05 and Nylotex NX screen inks is given in the appropriate Safety Data Sheets.

Environmental Information

Nylotex NX Inks:

- Do not contain ozone depleting chemicals as described in the Montreal Convention.

XTA05:

- Does not contain ozone depleting chemicals as described in the Montreal Convention.
- Is formulated free from aromatic hydrocarbons.

Öko-Tex Standard 100

Contact your Fujifilm supplier for the latest information concerning the compliance of Sericol inks.

(1) Phthalate Compliant means that the products listed in this Product Information Sheet are formulated not to contain the Phthalates restricted for use by Council Directive 76/769/EEC (as amended).

The information and recommendations contained in this Product Information sheet, as well as technical advice otherwise given by representatives of Fujifilm Speciality Ink Systems Limited and its associated companies, whether verbally or in writing, are based on our present knowledge and believed to be accurate. However, no guarantee regarding their accuracy is given as we cannot cover or anticipate every possible application of our products and because manufacturing methods, printing stocks and other materials vary. For the same reason our products are sold without warranty and on condition that users shall make their own tests to satisfy themselves that they will meet fully their particular requirements. Our policy of continuous product improvement might make some of the information contained in this Product Information sheet out of date and users are requested to ensure that they follow current recommendations.

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