

# HiTranz<sup>®</sup> Reflective Garment & Textile Transfers

TekSpec<sup>®</sup>  
Product technical details



## PRODUCT DETAILS

### Transfer Dimensions:

- **Minimum** transfer size is **0.5" x 0.5"** (1.27cm x 1.27cm).
- **Maximum** transfer size is **18" x 25"** (45.7cm x 63.5cm).

### Design Lettering Dimensions:

The text within a design should not be less than 2mm (0.08") in height. Smaller text may need to be altered to transfer slightly larger.



### Substrate Type:

**100% polyester clear carrier.**

### Design Colours:

HiTranz® Reflective transfers are produced with retro-reflective glass bead inks, which provide a high level of reflectivity when exposed to direct light in dark conditions. The reflective ink is generally printed in a silver tone, however the reflective ink formulations can be applied to other colours. The production process uses innovative methods that provide accurate registration, very fine details, small text and vibrant Pantone® formulated colours.

## ORDERING GUIDELINES

### Artwork & Set-up Fees:

**No fees\*.** Emblemtek will provide artwork on new emblem orders for customer Approval prior to production. There are no artwork or set-up fees when existing, electronic or physical designs or samples are provided to Emblemtek. Artwork fees may apply when designs are created from scratch.

### Order Quantities:

**Minimum 25.** The minimum order quantity is 25 transfers.

### Pre-production Samples:

**Available \$.** Electronic (scan) or physical pre-production samples (single unit) are available for approved designs. Samples fees are applicable, relative to design detail and emblem size. See price guide for more information.

### Pricing:

**Charted & quoted.** Charted pricing is available up to a certain size threshold, with larger quantities and larger transfer sizes custom quoted. See price guide for more information.

### Delivery Times:

Delivery times are relative to order quantity. See price guide for more information.

### Ordering Guidelines:

**Order specifics.** During the design, artwork and ordering processes, there are specific details that we require in order to proceed with your request, such as:

Transfer Type • Design Colours • Dimensions • Quantity • Special Delivery Needs

### Accepted Design / Artwork File Types:

The chart below lists the various graphic and design file types that Emblemtek will accept for artwork and production purposes. Certain file types are preferred as noted.

#### Graphic File Types:

- CorelDraw ver.13 / ver.X3 (.cdr) *pref*
- Adobe Illustrator ver.CS3 (.ai) *pref*
- Encapsulated PostScript (.eps) *pref*
- Adobe Portable Document File (.pdf) *pref*
- Joint Photographic Experts Group (.jpg) *pref*
- Portable Network Graphics (.png) *pref*
- Adobe Photoshop ver.CS3 (.psd)
- Corel Photo-Paint ver.13 / ver.X3 (.cpt)
- Targa Bitmap (.tga)
- Tagged Image File Format (.tiff)
- Windows Bitmap (.bmp)
- CompuServe Bitmap (.gif)



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## APPLICATION & WASH GUIDELINES

### Application Methods

**Heat seal.** HiTranz® Garment and Textile Transfers can be heat sealed on to garments and other textile products using a heat seal machine.

HEAT SEAL APPLICATION			
HiTranz® Reflective	320°F to 356°F (160°C to 180°C)	65 to 80 PSI (4.5 to 5.5 Bar)	12 to 15 seconds

These recommended settings are based on manually operated or air operated heat seal machines with top iron heat only.

### Heat Seal Notes & Tips:

Place the garment or textile on the bottom platen of the heat seal machine and ensure that the area that is to be transferred is as flat and smooth as possible. Place the transfer carrier over the area to be transferred and position the transfer so that the design is aligned to the garment or textile as required. Cycle the heat seal machine based on the temperature, pressure and time settings noted above. When the heat seal cycle is complete, remove the transfer carrier slowly from the garment or textile while still warm.

*Due to the diverse nature of fabrics and textiles in the market place, customers are advised to carry out application, wash and any technical tests (including flame retardant) prior to placing orders.*

- **Thicker fabrics**, which may absorb excess heat, may require longer cycle times as charted above.
- **White materials** (knits or blends) may scorch if heat seal temperatures are too high. It is recommended that fabrics be tested first.
- **Pique knit and fleece** materials may be sensitive to heat and pressure, with the possibility of being crushed.
- **Rib-knit and stretch fabrics** may pucker or distort when transfer are heat sealed to them. Transfers may not apply correctly to items such as toques and scarves. It is recommended that these fabrics be tested first.
- **Terry knit materials** such as towels and bathrobes may not provide a smooth enough surface for proper heat seal application.
- **Treated fabrics** finished with coatings, sizing or repellants may not allow for proper heat seal bonding. Items made with leather, suede, nylon, synthetics, nylon-shell, interlinings, rubberized coatings and reflective fabrics, such as jackets and luggage, may react poorly to heat seal temperatures depending on thickness, weave, texture and weight. It is recommended that these fabrics be tested first, with possible heat seal time and temperature adjustments.
- **Caps** can sometimes be difficult to work with for heat seal applications. To achieve a higher potential for heat seal application success on caps, it is recommended that transfers not be greater than 2-1/4" in height and 4" in width.

### Washing & Drying Guidelines

	WASH TYPE	WASH TEMPERATURE		DRY TYPE	
HiTranz® Reflective	Commercial	Wash in commercial machine in water not exceeding 140°F (60°C)		Tumble dry at medium heat not exceeding 150°F (65°C)	



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For complete product details, please visit  
[emblemtek.com/tekspec/](http://emblemtek.com/tekspec/)

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**Your notice of**  
2013-10-16

**Your reference**  
e-mail

**our reference**  
CR/2393\_2013

**date**  
2013-12-23

## Certification report

### 1. Description of the tested article as indicated by the client:

quality name: Reflective Transfer FR on fabric  
dimension: 2cm x 15cm  
description: fabric : blue Nomex BV185  
label : Polymark Reflective Transfer FR

### 2. Executed tests:

tests from EN ISO 14116	requirements	result	pass/fail and level
flame spread on logo after 5*(75°C proc 4.8 + tumble dry (80°C)) ISO15797			
Index 1	No flaming to the top or either side edge No flaming debris No afterglow shall spread in the undamaged area	No flaming to the top or either side edge No flaming debris No afterglow	Pass Index 1
Index 2	No flaming to the top or either side edge No flaming debris No afterglow shall spread in the undamaged area No hole formation	No flaming to the top or either side edge No flaming debris No afterglow  No hole formation	Pass Index 2

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tests from EN ISO 14116	requirements	result	pass/fail and level
Index 3	No flaming to the top or either side edge No flaming debris No afterglow shall spread in the undamaged area No hole formation After flame of each individual specimen $\leq 2s$	No flaming to the top or either side edge No flaming debris No afterglow  No hole formation No after flame	Pass Index 3

tests from EN ISO 11611	requirements	result	pass/fail and level
flame spread on logo after 5*(75°C proc 4.8 + tumble dry (80°C)) ISO15797	Mean after flame ( $\leq 2s$ ) Mean afterglow ( $\leq 2s$ ) in the undamaged area No flaming debris No molten debris No flaming to the top or either side edge No hole formation	No after flame No afterglow  No flaming debris No molten debris No flaming to the top or either side edge No hole formation	Pass

tests from EN ISO 11612	requirements	result	pass/fail and level
flame spread on logo after 5*(75°C proc 4.8 + tumble dry (80°C)) ISO15797	Mean after flame, ( $\leq 2s$ ) Mean afterglow ( $\leq 2s$ ) in undamaged area No flaming debris No melting or molten debris No flaming to the top or either side edge No hole formation	No after flame No afterglow  No flaming debris No molten debris No flaming to the top or either side edge No hole formation	Pass

Detailed results can be found in:

Centexbel: analysis report 13.03627.01 of 2013-09-13

Kristina De Temmerman  
By order of Inge De Witte  
Certification Manager