

Recommended Initial Settings For S-F164 Film and S-Powder

Step 1 – Printing on S-F164 Direct Transfer System Film

- Using the VersaSTUDIO BN-20D inkjet printer, load S-F164 Direct Transfer System Film onto the roll holder
- For Dark shirts
 - print color image on the S-F164 film
 - print white image layer on top of the color image
- For Light shirts:
 - print color image on the S-F164 film

Step 2 – S-POWDER Application

- Apply the S-POWDER Direct Transfer System hot-melt powder uniformly on top of the wet print
- This white colored S-POWDER may be used for all applications, whether it's for dark or light t-shirts
- Powder may be sprinkled manually onto the print in a tray and agitated to cover print completely
 - **NOTE:** An automated commercial shaker may also be used for powder application
- Ensure that the powder is evenly spread over the printed surface of the S-F164 film
- Carefully remove excess S-POWDER
- **NOTE: Keep opened pouches of S-POWDER moisture free; use desiccant packs in opened pouches is recommended.**

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Step 3 – Melting S-POWDER

- Place the S-F164 film with the printed image and the applied powder in a Curing Oven and heat for 2-3 minutes at 210°-230°F

OR

- Place the S-F164 film inside a heat press, hovering and not applying pressure. (Stahls' Hotronix Hover Press is recommended.) A 4 to 7 mm gap between the film and the heat press top plate is recommended, for 3-5 minutes at 285°-300°F. Do not completely close the press.

Step 4 – Application to T-shirt: Pre-pressing

- Pre-press the fabric prior to transfer of the image by the film for 2 to 5 seconds
 - Pre-pressing will flatten the fabric and remove excess humidity contained in the fabric
 - Pre-pressing helps in successful transfer of the image from the film onto the fabric

Step 5 – Application to T-shirt: Transfer

- The S-F164 film with the image and the melted S-POWDER is placed on the pre-pressed fabric in the heat press
- Press/Cure the image to the fabric for 10-20 seconds at 320°-360°F

Step 6 – Cold Peel

- Allow the film/image attached to the fabric to cool completely
- Separate the film from the fabric, leaving the desired image on the fabric

Step 7 – Post-pressing

- A post-press process for 10-20 seconds at 320°-360°F is highly recommended for best results and high-performance parameters such as wash and rub fastness