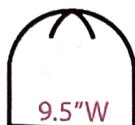
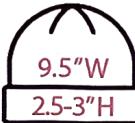


SIZE +/- 0.25"**TIME****CLASSIC****30s**

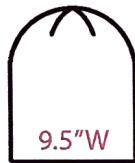
120/hr

**1m**

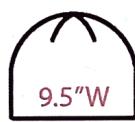
60/hr

CUFF

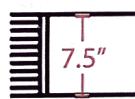
Use 10"W board

**SLOUCH****30s**

120/hr

**SKULL****30s**

120/hr

**SCARF****2m**

30/hr

MATCH TO PROOF**Knit QC**

- Cuff design centered (priority vs cuff size)
- Jump line is steamed on the side
- Clean up loose yarn (pick/trim)

Embroidery QC

- Remove extra topping (brush/pick)
- Trim loose threads
- Placement/logo matches proof

Label/Patch QC

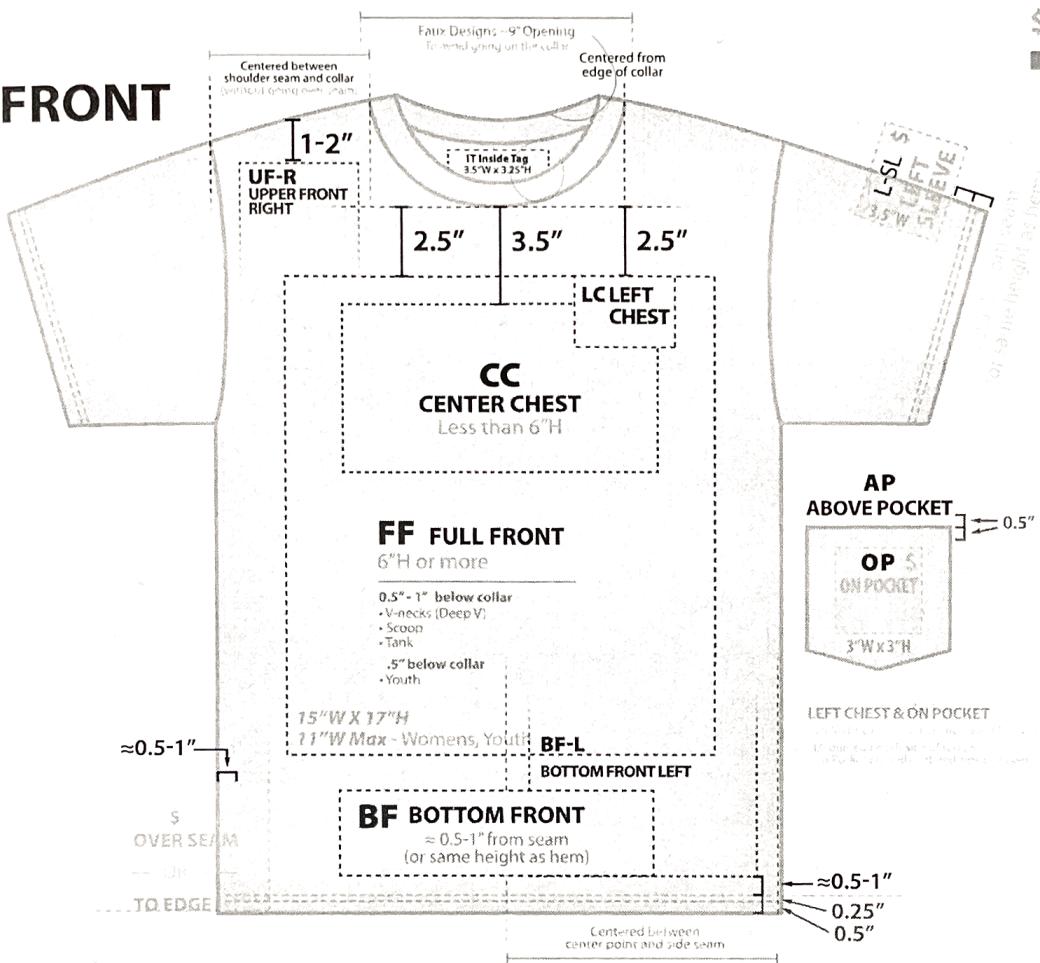
- Stitch color matches label color
- Placement matches proof

PRINT LOCATIONS

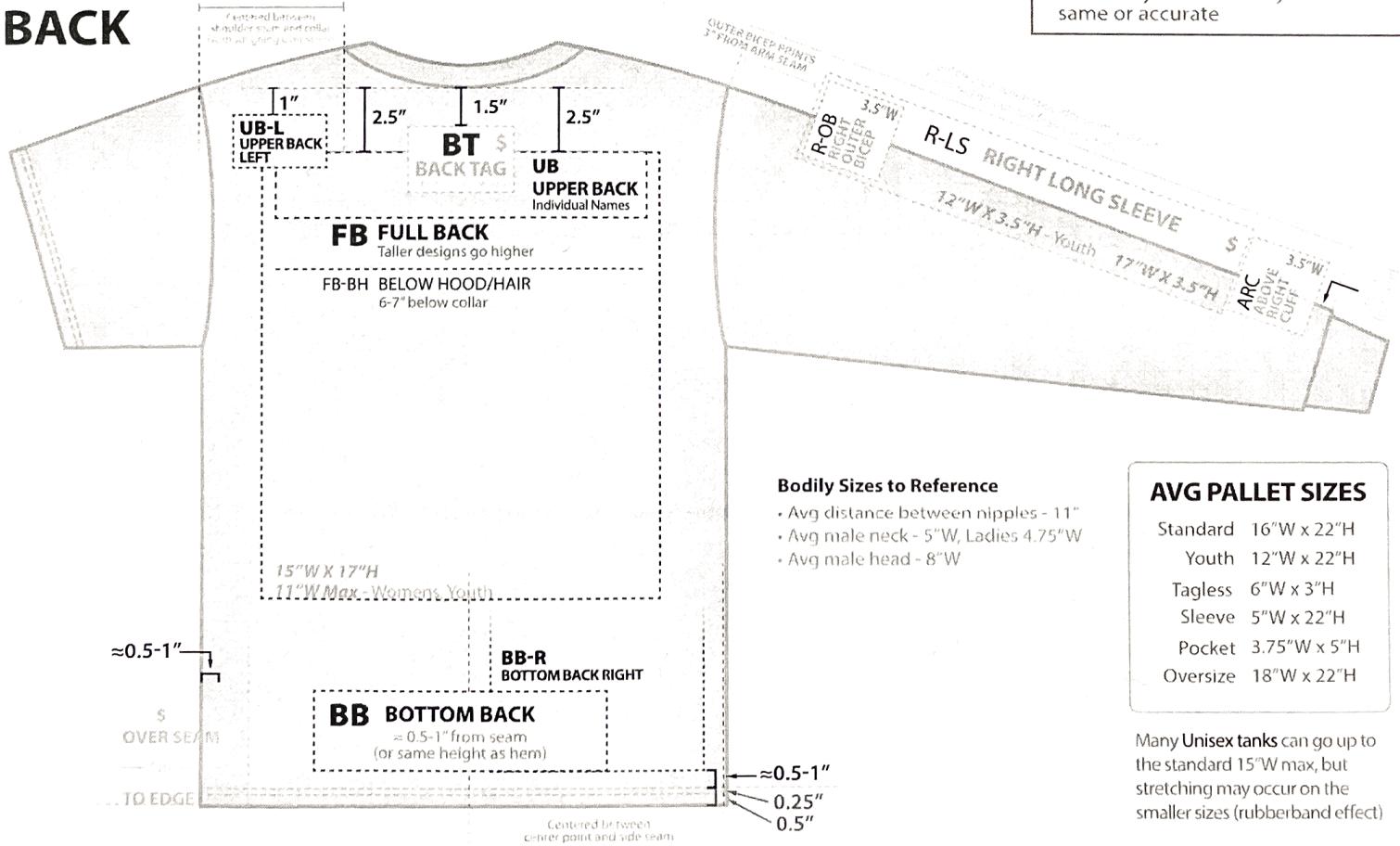
Measurements may be adjusted per design, shape, garment type, size, and client preference. Unless specified this guide will be used to determine print placement.

GUIDE

FRONT



BACK



\$ = Difficulty Charge

■ = MAX SIZE

Always double-check individual garment notes

15" W x 15" H - Max - Minds Eye

15" W x 17" H - Standard

17" W x 19.5" H - Oversize - Pacific S

16" W x 20" H - Standard - PSP \$18

15" W x 17" H - Kotis

15" W x 22" H - Kotis Oversize

19" W x 23" H - Oversize - Pacific S

19" W x 26" H - Oversize - PSP \$38

Call Ditch City Mfg.
11" W x 17" H - Standard
15" W x 22" H - Kotis

Call Ditch City Mfg.
11" W x 17" H - Standard
15" W x 22" H - Kotis

NOTES

Size M: All measurements based on print placement for adult Medium

Non Standard: Measurements called out with exact points (inches)

Adjust per garment size

- 1/4" up/down for most locations (LC, CC, FF, FB, etc.)
- Unless noted as **Static** (location stays the same on all sizes)
- Standard static locations: Left/Right Sleeve, Bottom Front/Back

1/8" acceptable location variance

Womens: 1/2" higher front prints

Location names refer to **wearer**

Folds in the Shirt cannot be used for aligning or measuring since they are not always the same or accurate

AVG PALLET SIZES

Standard 16" W x 22" H

Youth 12" W x 22" H

Tagless 6" W x 3" H

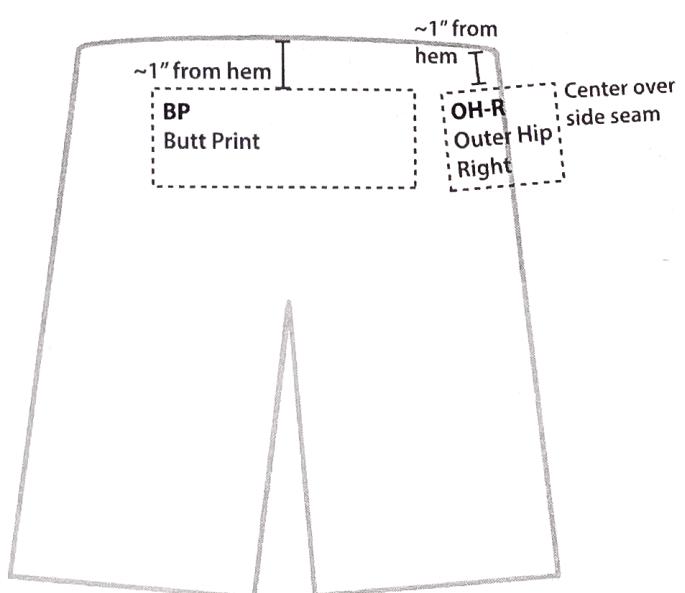
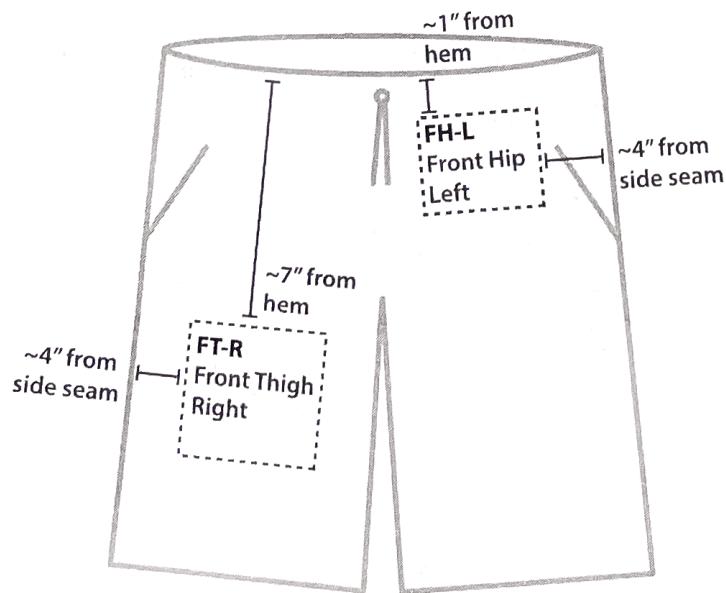
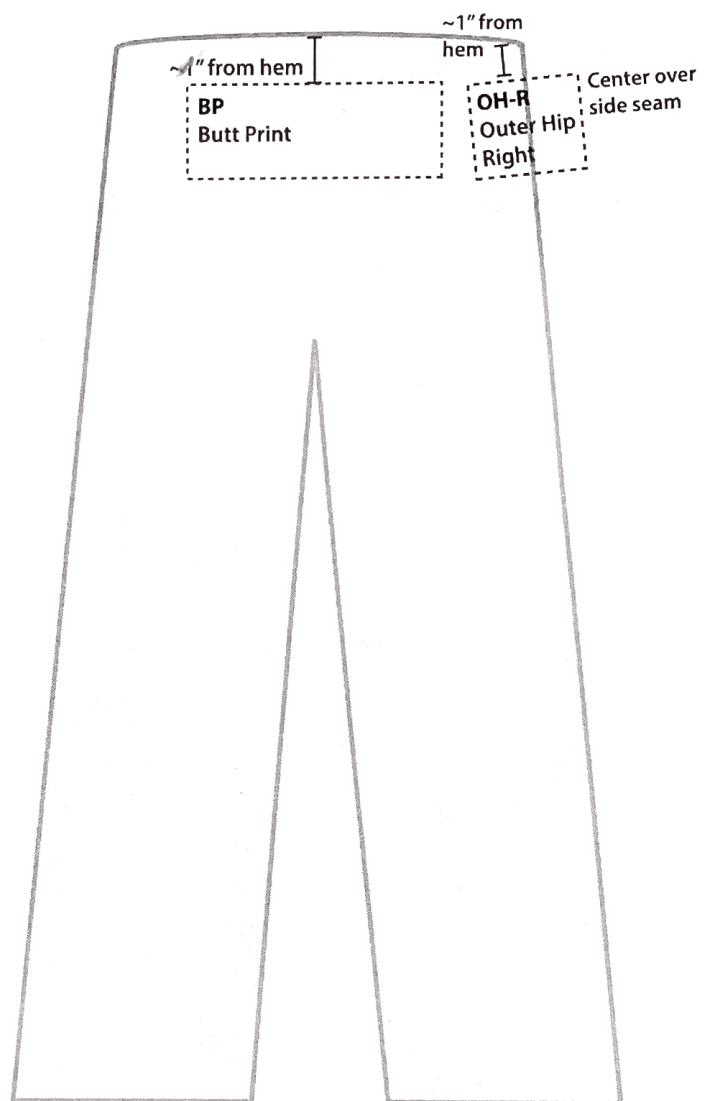
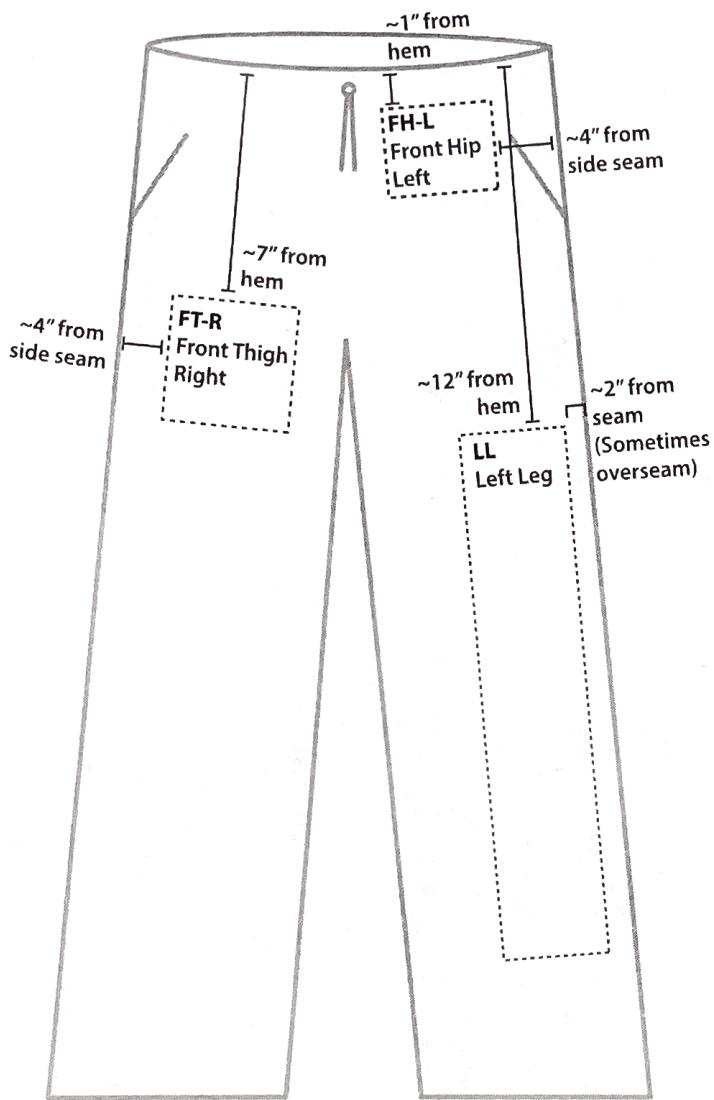
Sleeve 5" W x 22" H

Pocket 3.75" W x 5" H

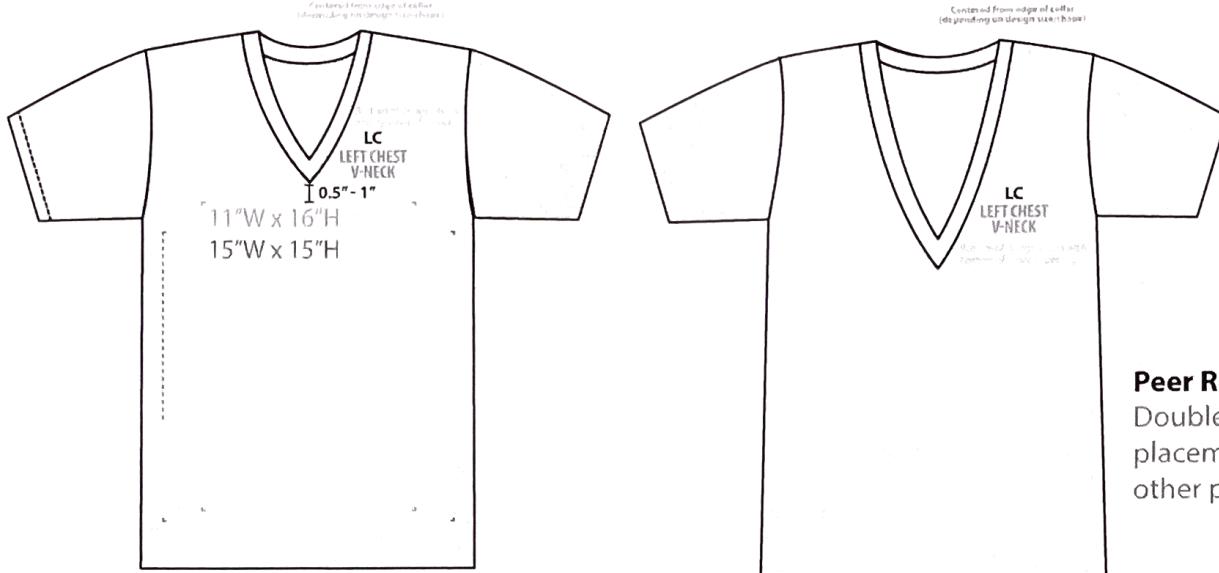
Oversize 18" W x 22" H

Many Unisex tanks can go up to the standard 15" W max, but stretching may occur on the smaller sizes (rubberband effect)

PRINT LOCATIONS - PANTS



V-NECKS



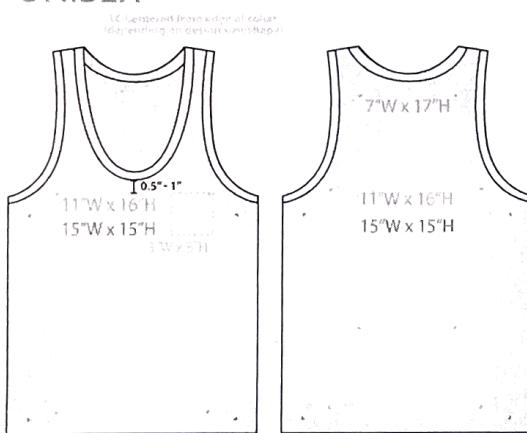
Peer Review

Double-check placement with two other people

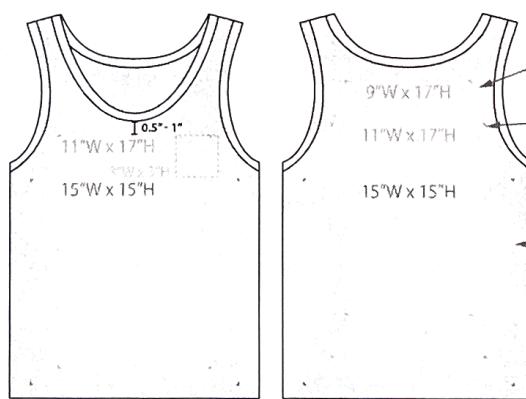
TANKS

UNISEX

ICONS BASED ON SMALLS



Edge of LC point to edge of collar (depending on design size/shape)



UFB-T
Upper Back (or Back Tag)

FB-T
Full Back (as high as possible)

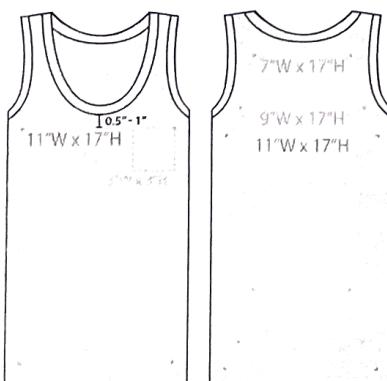
FBBA-T
Full Back Below Armholes

AMERICAN APPAREL

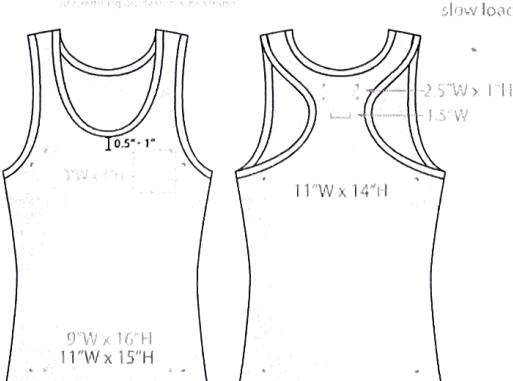
GILDAN

WOMENS

LC Centered from edge of collar (depending on design size/shape)



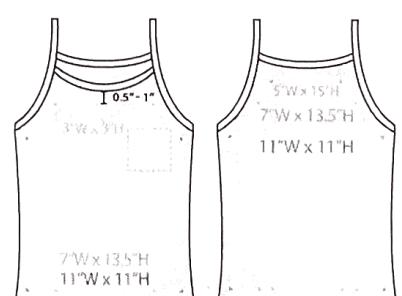
LC Centered from edge of collar (depending on design size/shape)



Tag Print on Racerback - \$

It's a very precise location that requires extra pallet prep and a slow load ($\approx 50\%$ slower)

LC Centered from edge of collar (depending on design size/shape)



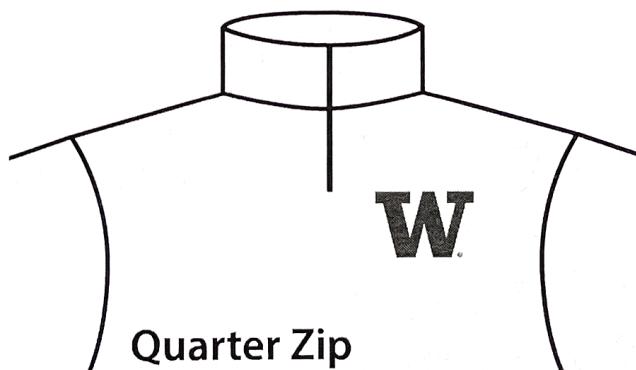
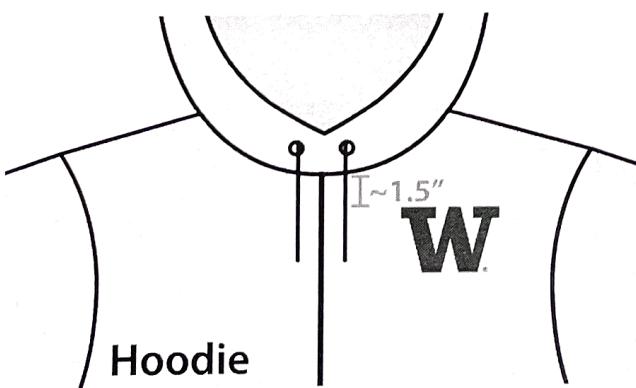
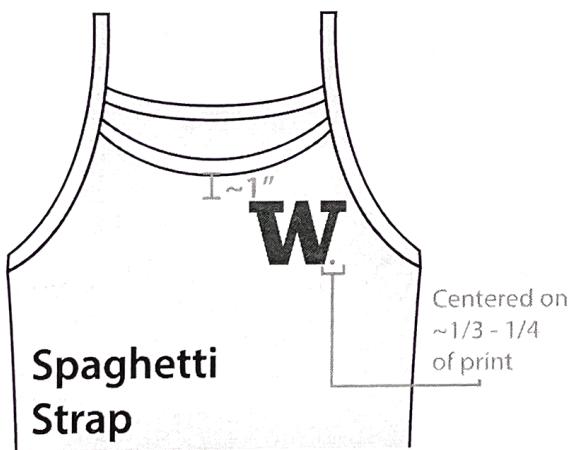
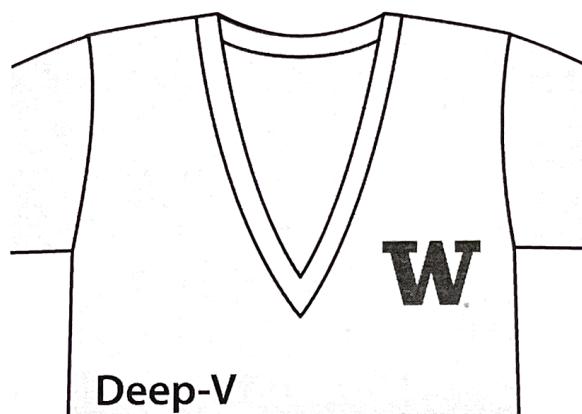
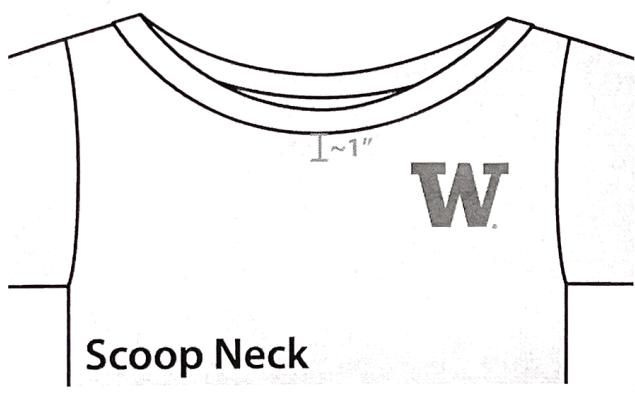
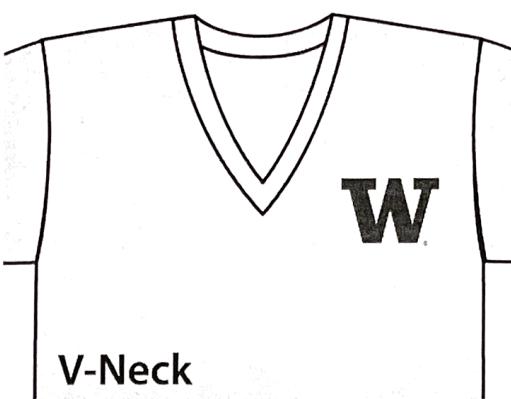
STANDARD

RACERBACK

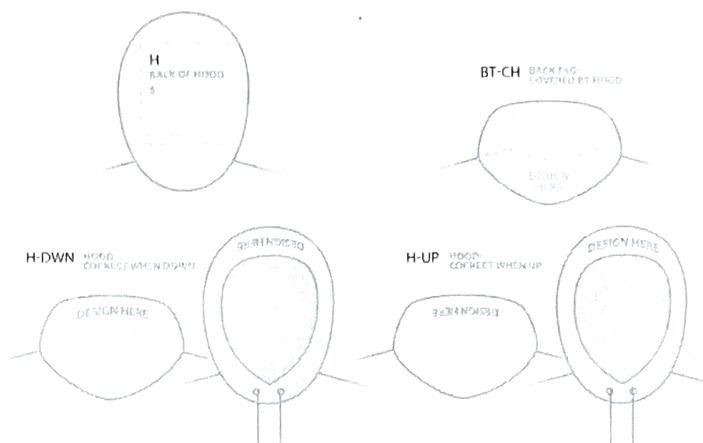
SPAGHETTI

LEFT CHEST - VARYING GARMENTS

Every garment is a little bit different.
Below is only a GUIDELINE to determine what may
be the best placement for your Left Chest prints.

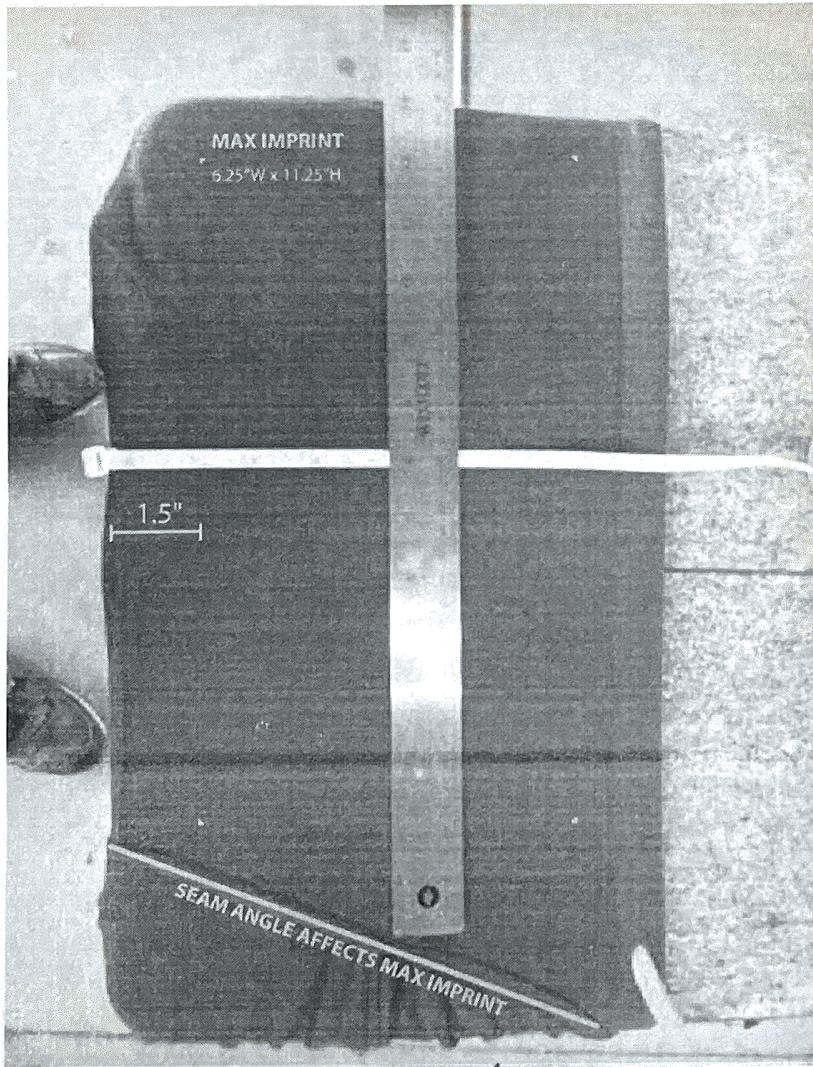


HOODIES



Side Hood

- One layer of fabric:
 - No clamps needed
 - Multiple colors
- Two layers of fabric:
 - Clamps needed for multiple colors
 - Only one color/one hit without clamps (KPS)
- Hood slides onto board until it hits back seam
- Seam determines angle of hood on board
- Need 1.5" from top of board to side of print



Note on Hood Pocket

- 1 color KPS w/ standard pallet

Zipped Hoodie

- Can't print past zipper pull as it pops screens
- Open faced zipper need to be taped up or they will pop screens

Center Chest – Over Zipper (CC-Z)

- 1 color over zipper unless design is ok'd by produciton

16" Pallet

EXCEPTIONS TO THE RULES

Visual Center vs. Mathematical Center

Finding the correct location for a print involves understanding what the main element of the design is. Think critically about where the intended focus of attention is in order to determine proper placement.

Print is ~0.5"
from collar

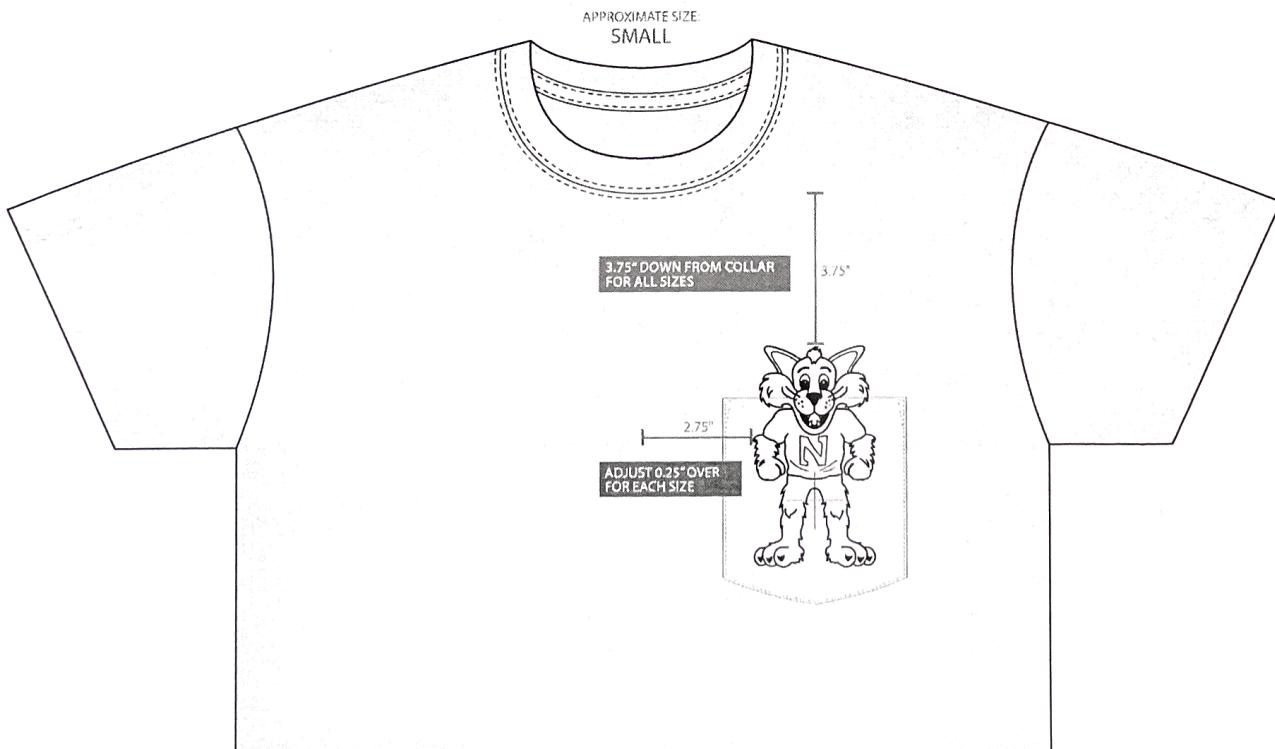
Centered on
SEATTLE text
instead of
space needle

Prints past
the collar and
centered to
SEATTLE text



BEHIND POCKET PRINT

The proof will tell you exact measurements of where to place the print. You will see a measurement down from the collar and a measurement from the center of the garment.





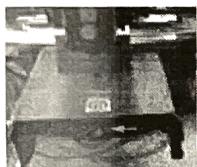
Back Tag

1.5" below collar
Tag sizes are 1.5-2H



Issues with printing on top of tags:

- Tag may show through the design (as a line)
- Potential mis-registration since pallet glue sticks to the tag instead of the shirt, so the garment pulls up in that spot



LOADING OPTIONS

§ 1) Tag hangs off pallet

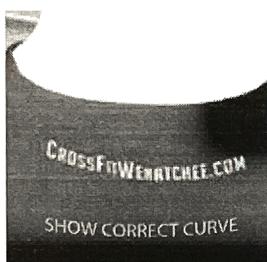
- Reposition pallets forward
- Load so the tag hangs off the front edge of the pallet
- Design will be ≈0.5" from top edge of pallet
- Shirt tends to wrinkle in that area and needs to be smoothed out (= slower load times)

§ 2) Flip out tags

- Tags can be flipped during loading
- However, production runs slower

Tags Centered?

- Tags are not always centered when sewn in
- Can NOT use them to align the design
- We measure to how design looks visually when worn



Designs following the collar curve do not need much of a curve

Left Chest & Center Chest - SEPARATE LOCATIONS

Manual Press: With side clamps, you don't have the lateral movement to go more than ~2" left and right. So it is almost impossible to move a left chest all the way to a center chest position.

Auto Press: It's a little easier on the auto that clamps top and bottom and is open on the sides but you probably only have a max 4" lateral before you hit the other head (don't even know that you can move the squeegee over that far due to how they are slotted and fit into the carriage clamp). Diagram showing this?

Faux Prints

Faux designs will typically print ~0.5"-1" away from the shoulder seams



PRODUCTION NOTES

Triple Pallet - No long sleeves

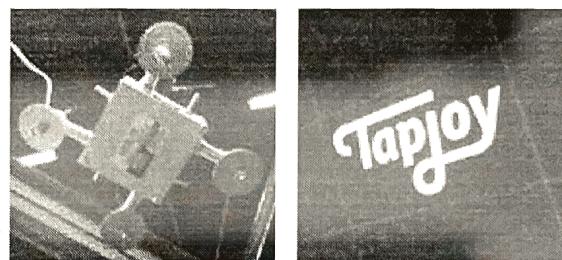
- Garments are too heavy and will fall off when swinging over to the flash
- Fleece: Would have to use lots of glue if we were to swing the pallet (fleece is heavy). It may work for no-flash prints
- Too much fabric in between the fingers so you can only load the outer two (which is still better than 1) so no hard fast rule yet

→ If you have a pallet with long sleeves, you can only load the outer two pallets.

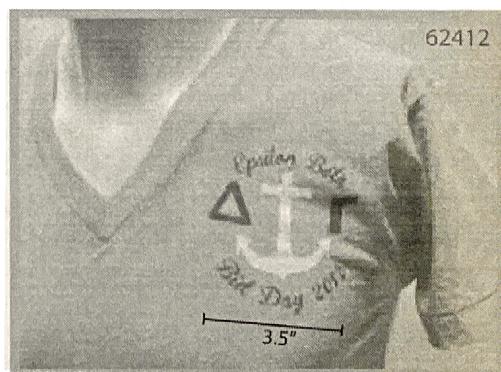
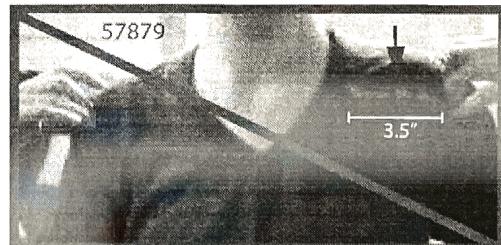
Lasers

Each auto has 4 independently positionable crosshair lasers which allows us to have more accurate loads:

- Above hem
- Above pocket
- Between racer back straps
- Avoiding labels on tag prints
- Align to multiple anchor points (side of collar, bottom button on a 1/4 zip, etc)



Left Chest Placement Error



Circular LC Design

Larger than 3" on V-Necks can look quite big (and start pushing the print into the armpit for smaller sizes). We recommend reducing circular /square designs to less than 3".