



Date : 09-Dec-25 Factory : 122T03  
 HT color : A1-Slate Grey 000-55-00 Fabric No : JG49R  
 Reference No : NBFK23040077 Fabric color : CAVIAR 19-4006 TCX  
 Quality : SAM Application Side : FACE  
 Glue : K  
 HT Description : (SAM-K)NB24-2.5REF\_Flying NB 2.5cm

**CONCLUSION :****COMMENTS :**

- |   |   |                    |
|---|---|--------------------|
| 1.Adherence & Surface Appearance after wash-40°C*10cycles | M | Obvious glue edge. |
| 2.Elasticity Test   | M |                    |
| 3.Dye Migration   | M |                    |
| 4.CF to Rubbing   | M |                    |

M = Meet buyer's requirement

F = Below buyer's requirement

N/A = Not applicable

\* = No specified requirement or fair

**1.After Wash**

-Washing Temperature(°C) : 40  
 -Washing Cycle : 10  
 -Drying : LOW  
 -Drying Cycle : 10

	GRADING	REQUIREMENT
-Adherence :	5.0	4.0
-Surface Appearance :	4.0	4.0
-Color Change :	5.0	3.5
-Color Staining :	4.5	3.5

**2.Elasticity Test**

	RESULT	REQUIREMENT
-Before wash :	ACCEPTED	No Cracking
-After wash :	ACCEPTED	No Cracking

**3.Dye Migration**

-Temperature(°C) : 70  
 -Operation Time(hr) : 48

	GRADING	REQUIREMENT
-Color Change :	5.0	4.0
-Self Staining :	4.5	4.5

**4.CF to Rubbing**

	GRADING	REQUIREMENT
-Color Staining(DRY) :	4.5	4.0
-Color Staining(WET) :	4.5	3.0

**OVERALL COMMENTS FROM LAB :**

After pressing, the appearance of the other side of the fabric has changed from the original.

The report / application setting of NB24-2.5REF, NB24-FNB4CM can be referred due to the same quality with similar design.



## OPERATING INSTRUCTIONS

蓋墊縮回

**Report No. :** TL11412062-1-2-F      **Application surface :** FACE  
**HT No. :** NBFK23040077      **Code :** SAM-K  
**Item :** (SAM-K)NB24-2.5REF\_Flying NB 2.5cm  
**Effect :** 超強抗昇華效果 (Super Anti-Migration)/針織布膠 (For Knitted Fabric)  
**Fabric no. :** JG49R

**Real touch Heat transfer condition: 實際接觸轉印標壓燙條件**

## &lt;1st-step application&gt;

## &lt;2nd-step application&gt;

<ul style="list-style-type: none"> <li>Cover with a Teflon, white paper, or release paper on the top to reduce the static electricity. 壓燙時，需覆蓋白紙/鐵氟龍/離型紙以降低靜電。</li> <li>Please pre-heat fabrication 10 secs with below suggested 1st step temp. and pressure condition. 請依第一步驟的壓燙溫度及壓力，預先縮布10秒。</li> <li>Pls follow the suggested peeling time show on heat transfer package after 1st heat press, and followed by 2nd heat apply ASAP. 第1段壓燙後請依照撕紙時間撕紙，勿久置。並盡速完成第2段壓燙。</li> </ul>		<ul style="list-style-type: none"> <li>Cover with a teflon or release paper on the top to prevent the glue from adhering to the plate. 壓燙時，需覆蓋離型紙/鐵氟龍以避免汙染壓燙台。</li> <li>Reapply on the face side of heat transfer to enhance the durability. 正面回壓：增加轉印標牢度。</li> </ul>	
Temperature :	150 °C 302 °F	Temperature :	150 °C 302 °F
Pressure :	40 Psi 2.8 Kg/cm <sup>2</sup>	Pressure :	40 Psi 2.8 Kg/cm <sup>2</sup>
Apply Pressure	Use fabric mat 使用墊布	Apply Pressure	
Time :	8 sec	Time :	15 sec
Peeling Time :	Peeling time is instructed by heat transfer package. Cold Peel: wait 2-5 min Warm-Cold Peel: wait 20-60 sec Warm Peel: wait 10-30 sec Hot Peel: wait 5-10 sec		

**When peel off the release paper (PET), please peel from arc part of graphic instead of sharp angle to prevent the damage of heat transfer.** 撕紙時須從圖形結構為圓弧處撕起，避免從尖角處容易造成損壞。

**After pressing the heat transfer, please do not throw the cloth as the glue is not yet completely cooling.** 壓燙後，因膠未完全冷卻，請勿甩布。

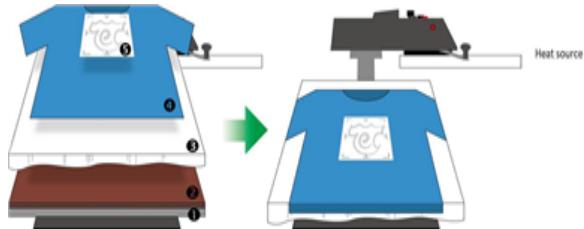
**In-house Heat Transfer Application Machinery Model:** Hotronix Air Fusion(Platen 16"X20", Air Cylinder 6").  
**Please ensure the application temperature within 2.5°C (5°F) range of suggested temperature.** 依田使用的壓燙機型號為Platen 16"X20", Air Cylinder 6"，請確保壓台溫差可保持在建議壓燙溫度2.5°C(5°F)以內"

**Please review the test specimen by following brand's test manual, and avoid using hard, sharp object such as finger nail to damage the HT.** 請依照品牌測試標準文來檢視測試樣，避免使用尖銳硬物像是指甲來破壞轉印標表面

**Due to the variety of fabric composition and structure, please follow above suggested conditions to ensure the glue can be completely melted to present the best appearance and quality.** 因布的組織與結構多元，為確保膠能充份熱熔，以呈現最好的外觀品質與牢度，請依照指示操作。

**Suggestion:** Use "fabric-mat" with the thickness of 3mm~4mm to provide a buffer and even pressure to ensure the application durability. 使用3mm~4mm厚度的布墊來平均壓力以確保牢度

**Fabric with mesh hole or with obvious texture requires this application method.** 網紗布或紋路起伏較大的布種，建議使用此壓燙方式。

**Application Graphic :**

Layer ①: Heat-pressing machine platen

Layer ②: A full page of silicon pad (10MM)

Layer ③: Fabric-Mat

Layer ④: Panel

Layer ⑤: HT

\* Please see the back page for important remark 請參照背面注意事項說明 \*