



Date :	04-Jul-24	Factory :	101K01
HT color :	D1-White (ET.001)	Fabric No :	JG87W
Reference No :	NBNK18040062	Fabric color :	Caviar 19-4006 TCX
Quality :	SAM	Application Side :	FACE
Glue :	K		
HT Description : (SAM-K)NB19-HF-SAM-FNB1.5			

**CONCLUSION :**

1. Adherence & Surface Appearance after wash-40°C\*10cycles      M      Glue outline visible after application  
Fabric structure visible
2. Elasticity Test      M
3. Dye Migration      M

M = Meet buyer's requirement

N/A = Not applicable

**COMMENTS :**

F = Below buyer's requirement

\* = 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 :	4.0	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

**OVERALL COMMENTS FROM LAB :**

★Press mark appeared after application

The report / application setting of NB19-HF-SAM-FNB1.5, NB24-TEAM2.0 can be referred due to the same quality with similar design.



## OPERATING INSTRUCTIONS

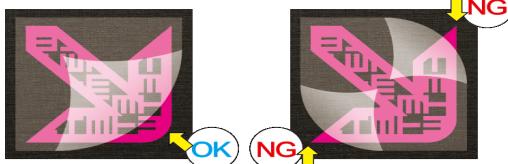
蓋軟縮

**Report No. :** TL11306307-2-3-F      **Application surface :** FACE  
**HT No. :** NBNK18040062      **Code :** SAM-K  
**Item :** (SAM-K)NB19-HF-SAM-FNB1.5  
**Effect :** 超強抗昇華效果 (Super Anti-Migration)/針織布膠 (For Knitted Fabric)  
**Fabric no. :** JG87W

**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> </ul>			
Temperature :	320 °F 160 °C	Temperature :	°F °C
Pressure :	20 Psi 1.41 Kg/cm <sup>2</sup>	Pressure :	Psi Kg/cm <sup>2</sup>
Apply Pressure	Use silicon pad 使用軟墊	Apply Pressure	
Time :	20 sec	Time :	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			

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"

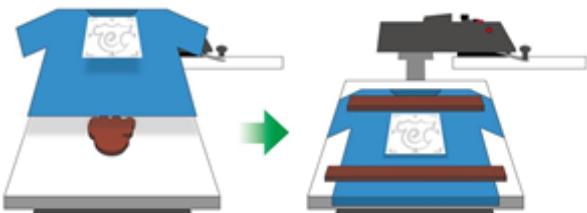
Please review the test specimen by following brand's test manual, and avoid using hard, sharp object such as finger nail to damage the HT. 請依照品牌測試標準文來檢視測試樣，避免使用尖銳硬物像是指甲來破壞轉印標表面

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。

Cut the silicon pad and keep at least 0.3cm margin from the artwork shape. 使用軟墊切割圖形外擴0.3cm大小的形狀。

Silicon pad which thickness 1 cm and hardness 25°. 軟墊厚度1cm，硬度25°。

## Application Graphic :



Layer ①: Heat-pressing machine platen  
Layer ②: Use a silicon pad with 1cm thickness and its dimension is about 0.3cm bigger than the heat transfer for application.  
Layer ③: Panel  
Layer ④: HT

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