



Date : 06-Sep-25 Factory : 122T03
 HT color : I1-Slate Grey 000-55-00/ET.703F Fabric No : RV2211062-2
 Reference No : NBFK24070120 Fabric color : SHADOW
 Quality : ST Application Side : FACE
 Glue : K
 HT Description : (ST-K)NB25-HDKlutch0.75_K logo_0.75in x 0.96in

CONCLUSION :**COMMENTS :**

1.Adherence & Surface Appearance after wash-40°C*10cycles M Surface appearance slightly worn after wash.

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 :	4.0	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

4.CF to Rubbing

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

OVERALL COMMENTS FROM LAB :

The issue of fabric color change and press mark after heat applied which have already been improved through the some press mark-solving ways.

Suggest inside out wash to protect heat transfer surface.

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

TECHNICAL MANAGER : jau.chiou

PREPARED & CHECKED BY : Chu



OPERATING INSTRUCTIONS

蓋宣墊縮回

Report No. : TL11409017-1-1-F **Application surface :** FACE
HT No. : NBFK24070120 **Code :** ST-K
Item : (ST-K)NB25-HDKlutch0.75_K logo_0.75in x 0.96in
Effect : 一般效果 (Standard)/針織布膠 (For Knitted Fabric)
Fabric no. : RV2211062-2

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

<1st-step application>

<2nd-step application>

• 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。	• 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。
• 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。	• Reapply on the face side of heat transfer to enhance the durability. 正面回壓：增加轉印標牢度。
• 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。	

Temperature : 160 °C 320 °F	Temperature : 160 °C 320 °F
Pressure : 40 Psi 2.8 Kg/cm ²	Pressure : 40 Psi 2.8 Kg/cm ²
Apply Pressure Use fabric mat 使用墊布	Apply Pressure
Time : 15 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 :

如有任何壓燙或壓痕問題請找我司協助處理。

If there is any further application or press-mark questions,
 please do not hesitate to contact us. Thank you!