

# TEXTILE APPLICATIONS

## INSTRUCTIONS FOR USE

### SUITABLE INK SYSTEMS

Water-based dye sublimation inks.

### PROCESS PARAMETERS

#### Temperature

For dye sublimation transfer with S-RACE® higher calendering temperatures are beneficial. For best results we recommend to use a transfer temperature of 205°C to 210°C. Using this temperature will enhance the transfer quality e.g. optical densities and line sharpness.

#### Transfer time

Sublimating with S-RACE® at 205°C to 210°C only needs a transfer time of 25–40 sec. for optimal results:

• S-RACE® Look 55		55 g/m <sup>2</sup>		25 sec.
• S-RACE® Active 75		75 g/m <sup>2</sup>		30 sec.
• S-RACE® Tacky Protect 80		80 g/m <sup>2</sup>		30 sec.
• S-RACE® Tacky 100		100 g/m <sup>2</sup>		35 sec.
• S-RACE® Tacky Ultra 100		100 g/m <sup>2</sup>		35 sec.
• S-RACE® Allround 100		100 g/m <sup>2</sup>		35 sec.
• S-RACE® Dynamic 60		60 g/m <sup>2</sup>		30 sec.
• S-RACE® Dynamic 75		75 g/m <sup>2</sup>		30 sec.

If a lower transfer temperature is required the transfer time has to be increased.

Please note: The above is a general recommendation. Results can vary per fabric. Testing is essential.

### STORAGE

Store material only in original packaging under normal climatic conditions (23°C, 50% RH).

Protect material from direct sunlight. It is recommended to adapt the material to indoor climate at least 24 hours before usage.

[s-race.com](https://www.s-race.com)

