

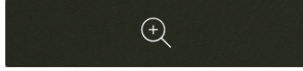
# FABRIC GUIDE & SCREEN PRINTING TIPS

Below you will find fabric details and printing instructions per fabrication. A test sample run is always recommended before printing large quantities.

**\*For best results we suggest using a poly ink and/or poly blocker for all fabric containing polyester**

## Fabric Care Instructions

### RETAIL JERSEY



#### × FABRIC DETAILS

100% Airlume combed and ring-spun cotton, 32 single 4.2 oz/yd<sup>2</sup>, 142 g/m<sup>2</sup>. Custom fabrications apply for Athletic Heather, Marble Colors, and Striped colors.

#### × PRINTING TECHNIQUES

RETAIL JERSEY PRINTING TECHNIQUES: PLASTISOL-320 degrees, medium flashing temperature, 10-15% reducer/finesse WATER BASE INK-300/310 degrees, medium flashing temperature, soft hand/ curable reducer at 5%. Heat Transfer Vinyl Tips: 320 degrees, 15 seconds, medium pressure, Stahls' CAD-CUT Fashion Film

### HEATHER CVC\*



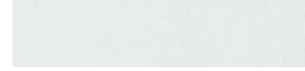
#### × FABRIC DETAILS

52% Airlume Combed and ring-spun cotton 48% polyester 32 Singles 4.2 oz/yd<sup>2</sup>.

#### × PRINTING TECHNIQUES

HEATHER CVC PRINTING TECHNIQUES: Plastisol 320 Degrees, Medium flashing temperature, 10-15% reducer. WATER BASE INK-300/310 degrees, medium flashing temperature, soft hand reducer/curable reducer at 5%.

### TRIBLEND JERSEY\*



#### × FABRIC DETAILS

**Tees** - 50% polyester, 25% Airlume combed and ring-spun cotton, 25% rayon, 40 single 3.8 oz/yd<sup>2</sup>, 115 g/m<sup>2</sup>. **Jackets** - 50% polyester, 25% Airlume combed and ring-spun cotton, 25% rayon, 30 single 5.6 oz/yd<sup>2</sup>, 190 g/m<sup>2</sup>. **Cardigan** - 50% polyester, 37.5% Airlume combed and ring-spun cotton, 12.5% rayon, 30 single 5.6 oz/yd<sup>2</sup>, 190 g/m<sup>2</sup>. **Black Heather Triblend Fabrication** - 70% Airlume combed and ring-spun cotton, 15% polyester, 15% rayon.

#### × PRINTING TECHNIQUES

TRIBLEND JERSEY PRINTING TECHNIQUES: PLASTISOL-320 degrees, low flashing temperature, viscosity reducer, low cure ink/flash additive, stretch additive, soft hand/curable reducer at 5% WATER BASE INK-300/310 degrees, low flashing temperature, retarder at 5%. For best results on Solid Black Triblend we suggest using a poly ink and/or poly blocker. Heat Transfer Vinyl Tips: 280 degrees, 8-10 seconds, medium pressure, Stahls' CAD-CUT Premium Plus

### FLOWY POLY VISCOSE\*



#### × FABRIC DETAILS

65% polyester, 35% viscose, 32 single 3.7 oz/yd<sup>2</sup>, 125 g/m<sup>2</sup>. Custom fabrications apply for Athletic Heather, Marble Colors, and Striped colors.

#### × PRINTING TECHNIQUES

POLY VISCOSE PRINTING TECHNIQUES: PLASTISOL-320 degrees, low/medium flashing temperature, soft hand/curable reducer at 5% WATER BASE INK-320 degrees, low flashing temperature, retarder at 5%. Heat Transfer Vinyl Tips: 280 degrees, 8-10 seconds, medium pressure, Stahls' CAD-CUT Premium Plus

### POLY-COTTON FLEECE\*



#### × FABRIC DETAILS

52% Airlume combed and ring-spun cotton, 48% polyester fleece, 7.0 oz/yd<sup>2</sup>, 220 g/m<sup>2</sup>.

#### × PRINTING TECHNIQUES

POLY-COTTON FLEECE PRINTING TECHNIQUES: PLASTISOL-320 degrees, medium flashing temperature, soft hand extender, soft hand/curable reducer at 5% WATER BASE INK-300/310 degrees, medium flashing temperature, soft hand reducer, stretch additive, low ink viscosity, retarder at 5%. We recommend the use of a poly blocker and/or poly ink for the best results.

### TRIBLEND SPONGE FLEECE\*



#### × FABRIC DETAILS

50% polyester, 37.5% Airlume combed and ring-spun cotton, 12.5% rayon, 32 single 8.2 oz/yd<sup>2</sup>, 278 g/m<sup>2</sup>.

#### × PRINTING TECHNIQUES

TRIBLEND SPONGE FLEECE PRINTING TECHNIQUES: PLASTISOL-320 degrees, low flashing temperature, low mesh counts, soft hand/curable reducer at 5% WATER BASE INK-300/310 degrees, low flashing temperature, low mesh counts, retarder at 5%.

### POLY-COTTON JERSEY\*



#### × FABRIC DETAILS

52% Airlume combed and ring-spun cotton 48% polyester, 40 single 3.6 oz/yd2, 122 g/m2.

#### × PRINTING TECHNIQUES

POLY-COTTON JERSEY PRINTING TECHNIQUES: PLASTISOL-320 degrees, medium flashing temperature, extender base in place of white underbase, soft hand reducer/curable reducer at 5% WATER BASE INK-300/310 degrees, high/low flashing temperature, discharge additive suggested. We recommend the use of a poly blocker and/or poly ink for the best results. Heat Transfer Vinyl Tips: 320 degrees, 15 seconds, medium pressure, Stahls' CAD-CUT Fashion Film

### SHEER JERSEY



#### × FABRIC DETAILS

100% Airlume combed and ring-spun cotton, 40 single, 3.2 oz/yd2, 110 g/m2. Custom fabrication applies for Athletic Heather

#### × PRINTING TECHNIQUES

SHEER JERSEY PRINTING TECHNIQUES: PLASTISOL-320 degrees, low flashing temperature, 10-15% reducer/finesse WATER BASE INK-300/310 degrees, medium flashing temperature, soft hand/curable reducer at 5%.

### 1X1 BABY RIB & 2X1 RIB



#### × FABRIC DETAILS

100% Airlume combed and ring-spun cotton, 30 single 1x1 baby rib knit, 5.8 oz/yd2, 195 g/m2. Custom fabrication applies for Athletic Heather.

#### × PRINTING TECHNIQUES

1X1 BABY RIB & 2X1 RIB PRINTING TECHNIQUES: PLASTISOL-320 degrees, low flashing temperature, stretch additive, soft hand/curable reducer at 5% WATER BASE INK-300/310 degrees, medium flashing temperature, stretch additive, low ink viscosity, retarder at 5%. Heat Transfer Vinyl Tips: 280 degrees, 8-10 seconds, medium pressure, Stahls' CAD-CUT Premium Plus

### SLUB\*



#### × FABRIC DETAILS

50% polyester, 37.5% Airlume combed and ring-spun cotton, 12.5% rayon, 32 single 4.0 oz/yd2, 136g/m2.

#### × PRINTING TECHNIQUES

SLUB PRINTING TECHNIQUES: PLASTISOL-320 degrees, low flashing temperature, soft hand/curable reducer at 5% WATER BASE INK-300/310 degrees (120 sec), low flashing temperature, retarder at 5%. Heat Transfer Vinyl Tips: 280 degrees, 8-10 seconds, medium pressure, Stahls' CAD-CUT Premium Plus.

### MARBLE JERSEY\*



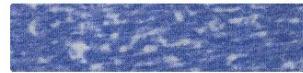
#### × FABRIC DETAILS

**Womens-** 91% polyester, 9% Airlume combed and ring-spun cotton, 40 single 3.5 oz/yd2, 119 g/m2 **Mens-** 91% polyester, 9% Airlume combed and ring-spun cotton, 30 single 4.0 oz/yd2, 136 g/m2.

#### × PRINTING TECHNIQUES

MARBLE JERSEY PRINTING TECHNIQUES: PLASTISOL-320 degrees, low/medium flashing temperature, soft hand/curable reducer at 5% WATER BASE INK-320 degrees, low flashing temperature, retarder at 5%. Heat Transfer Vinyl Tips: 280 degrees, 8-10 seconds, medium pressure, Stahls' CAD-CUT Premium Plus

### ACID WASH\*



#### × FABRIC DETAILS

52% Airlume combed and ring-spun cotton, 48% polyester, 32 single 4.4 oz/yd2, 149 g/m2.

#### × PRINTING TECHNIQUES

ACID WASH PRINTING TECHNIQUES: PLASTISOL-320 degrees, low/medium flashing temperature, soft hand/curable reducer at 5% WATER BASE INK-300/310 degrees (120 sec), low/medium flashing temperature, retarder at 5%. Heat Transfer Vinyl Tips: 320 degrees, 15 seconds, medium pressure, Stahls' CAD-CUT Fashion Film.

### MINERAL WASH



#### × FABRIC DETAILS

100% Airlume combed and ring-spun cotton, 32 single 4.4 oz/yd2, 149g/m2.

#### × PRINTING TECHNIQUES

MINERAL WASH PRINTING TECHNIQUES: PLASTISOL-320 degrees, medium flashing temperature, soft hand/curable reducer at 5% WATER BASE INK-300/310 degrees (120 sec), medium flashing temperature, retarder at 5%. Heat Transfer Vinyl Tips: 320 degrees, 15 seconds, medium pressure, Stahls' CAD-CUT Fashion Film.

### SPECKLED\*



#### × FABRIC DETAILS

50% polyester, 25% Airlume combed and ring-spun cotton, 25% rayon, 32 single 4.0 oz/yd2, 136 g/m2.

#### × PRINTING TECHNIQUES

SPECKLED PRINTING TECHNIQUES: PLASTISOL-320 degrees, low flashing temperature, soft hand/curable reducer at 5% WATER BASE INK-300/310 degrees (120 sec), low flashing temperature, retarder at 5%. Heat Transfer Vinyl Tips: 280 degrees, 8-10 seconds, medium pressure, Stahls' CAD-CUT Premium Plus.

### THERMAL\*



#### × FABRIC DETAILS

MENS/WOMENS - 55% Airlume combed and ring-spun cotton, 45% polyester, 40 single 4.5 oz/yd2, 150 g/m2. BABY - 60% Airlume combed and ring-spun cotton, 40% polyester, 40 single 4.5 oz/yd2, 150 g/m2.

#### × PRINTING TECHNIQUES

THERMAL PRINTING TECHNIQUES: PLASTISOL-320 degrees, low flashing temperature, soft hand/curable reducer at 5% WATER BASE INK-300/310 degrees, low flashing temperature, extender base, stretch additive, low ink viscosity, soft hand reducer, retarder at 5%.

### DIGITAL FLEECE\*



× FABRIC DETAILS

100% polyester, 32 single 7.0 oz/yd<sup>2</sup>, 220 g/m<sup>2</sup>.

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× PRINTING TECHNIQUES

DIGITAL FLEECE PRINTING TECHNIQUES:  
PLASTISOL-320 degrees, medium flashing temperature, soft hand extender, soft hand/curable reducer at 5% WATER BASE  
INK-300/310 degrees, medium flashing temperature, soft hand reducer, stretch additive, low ink viscosity, retarder at 5%.

### MARBLE FLEECE\*



× FABRIC DETAILS

85% Airtume combed and ring-spun cotton, 15% polyester, 32 single 7.0 oz/yd<sup>2</sup>, 220 g/m<sup>2</sup>.

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× PRINTING TECHNIQUES

MARBLE FLEECE PRINTING TECHNIQUES:  
PLASTISOL-320 degrees, medium flashing temperature, soft hand extender, soft hand/curable reducer at 5% WATER BASE  
INK-300/310 degrees, medium flashing temperature, soft hand reducer, stretch additive, low ink viscosity, retarder at 5%.