

# HEAT ADHESIVE WORK WEAR

## PRODUCT INFORMATION

### SCREEN ADHESIVE Water Based Single pack system

#### For application onto:

Polyester  
Nylon  
Cotton Twill  
Cotton



List of suitable Screen machines on request.

Substrates to be printed must be tested for suitability with the Adhesive prior to production runs being carried out.

#### Product Code

### 82-HA-WW

Water based adhesive which has been specially formulated to produce highly Durable & Washable Industrial grade transfers for Work Wear application. Suitable for use with **FABRIFAST® Screen DE2** solvent based 2-pack ink systems only.

*Application to various substrates is dependant on the Heat Adhesive used.  
Refer to Heat Adhesive Selection & Application Chart.*

#### Properties

Good Adhesion & Flexibility on suitable substrates  
Excellent Washability & Dry Clean resistances  
Washable up to 95°C, No. of cycles 100

Excellent Screen Stability  
Non UV curing system

**Environmentally responsible products, manufactured in facilities operating to ISO9001 Standards.**

#### Usage

Adhesive should be applied as 2 coats using a **36T - 43T** screen onto final layer of the transfer.

Ensure that the ink film is fully dry before applying the adhesive.

Dry thoroughly between adhesive layers and after second adhesive layer.

When printing is completed, or if printing is interrupted for more than 15 minutes, the screen mesh must be thoroughly cleaned. Failure to clean properly will result in this reactive adhesive permanently damaging the screen.

**USE IN WELL VENTILATED AREAS**

#### Application

Temperature °C	Dwell Time secs.	Platen Pressure Bar
190 – 200 (374 – 392 °F)	9 - 12	2

For information: 1Bar = 14.5 psi (lb/in<sup>2</sup>) = 1.02 kg/cm<sup>2</sup> = 100000 pascals (Pa) = 1000 hectopascals (hPa) = 1000 millibars (mbar)

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**Supplied** Supplied as a ready to use single pack system.

**Additives** Adhesive becomes thick due to drying / evaporation      add water      ↑ 3 - 5%  
Adhesive dries too fast in the screen &/or small designs      add Retarder      (82-AD-RE-V2)      ↑ 5%

**Drying** Adhesive should be dried after printing in a drying tunnel at 75°C between layers.  
As customers drying and heat curing equipment can vary from continuous production to batch production techniques, it is essential to ensure that all types of dryer/oven MUST be fully and correctly ventilated with the equipment being supplied with adequate fresh air ventilation, such that effective and full drying/curing can take place.  
It is recommended that customers satisfy themselves fully with respect to drying/curing times, temperatures and ventilation of their drying equipment and to ensure that the end products are fully satisfactory before using this product.

**Cleaners** ECOTRANS® Performance Cleaner **99-10-82** for cleaning Screen.  
Available in 25L & 200L pack sizes.  
**99-10-HCC** Citrus hand cleaner for cleaning ink off hands. Environmentally friendly & Hypo-Allergenic. Available in 5kg & 200kg pack sizes.

**DO NOT PUT CLEANERS INTO INK**

**Shelf Life** Keep containers closed.  
Shelf Life: Use within 12 months of opening.  
For maximum shelf life store in a cool environment between **10°C (50°F)** and **25°C (77°F)**, out of direct sunlight & away from any heat sources.  
Products should be thoroughly mixed prior to use as settling of the adhesive may occur during transportation & storage.

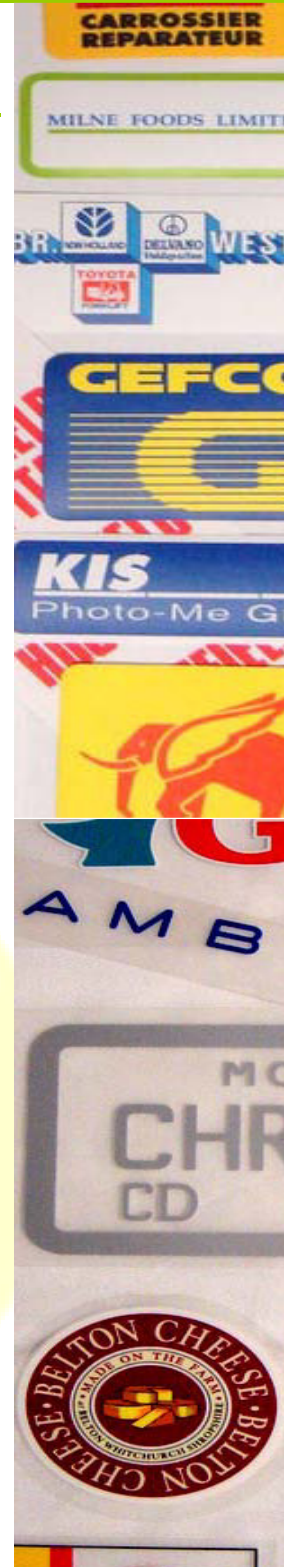
**Notes** Quality Control tests carried out to **PERFECTOS®** specifications.  
The durability of prints will depend on the whether the inks have been used as a 2-pack ink system, the curing conditions & on the substrate printed.  
Screen Emulsion must be suitable for use with water-based screen adhesive  
For Screen flat bed printing, it is recommended that a medium (Shore hardness 70-75°) square-edged squeegee.  
ECOTRANS® Performance Cleaner **99-10-82** may cause staining on parts which include Aluminium.  
For best results leave the finished transfer to stand for 24 hours before applying to garment and a further 24 hours before washing.

**Not suitable for use with ECOTRANS® Water Based Screen Inks.**

**MOQ** Minimum ordering quantity, 15kg. Available as Ex Stock.

**Coverage** Typical all over coverage of non absorbent transfer film can range from 55g/ m<sup>2</sup> to 70g/m<sup>2</sup>.  
*Coverage is dependant on screen mesh size and hole configuration, the adhesive viscosity and pressure applied to the screen whilst printing.*

**Safety** Refer to the specific **PERFECTOS®** Material Safety Data Sheets for information on the safety & handling of this particular range of inks, available on request.



FN 27206 EMS 608031

**PERFECTOS PRINTING INKS CO LTD**  
BOTTESFORD  
NOTTINGHAM NG13 0EL  
ENGLAND

**TELEPHONE** +44 1949 842179  
**FAX** +44 1949 843493  
**E-MAIL** [info@perfectos.co.uk](mailto:info@perfectos.co.uk)  
**WEB SITE** [www.perfectos.co.uk](http://www.perfectos.co.uk)

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