



## METALLIC DTF FOIL

### SCOPE

This procedure is used for metallic DTF foil, which has a foil layer on the designed artwork on the final substrates.

### PRINTING GUIDE

1. Change the printer to the "WHITE" layer MODE; only white ink prints are on the printing side. Usually, ticking out the CMYK layer box on client software might work; please save the setting before moving forward.
2. Load the metallic DTF foil rolls or place the metallic DTF foil sheet on the printer magazine, ensuring the printing surface faces up (matte side). Otherwise, the inks will not adhere properly to the films.
3. Please handle the sheet format films with a clean & flat board to prevent creases on the foils.
4. Turn on the vacuum to keep the film flat while printing to prevent film block or scratching the print heads. For 50um thickness, the minimum gear will work. The high vacuum will chock the film transmission during printing.
5. Start initial printing & check whether the print shapes are OK or not.
6. Some ink formulas will lead to ink spreading quickly; we suggest turning on the platform heating to 40-50°C; that might help to have a better shape; remember to check if DTF powder can still adhere to the white layers to find your best settings.
7. Double confirm the paper bobbins at the end of the line were flat & clean, and the tension force sensor works well to prevent creases/cracking on printed films.
8. REMARKS: Other settings were aligned with regular DTF films.
9. Please confirm the hot melt powder sintering completely, and the benchmark was the powder change into transparent pastes from semi-transparent particles. Otherwise, you cannot transfer fabrics correctly.
10. The powder shaker machine must have an exhaust pump (to expel waste gases and remove the water vapor generated during ink drying).
11. Different printing results may come out depending on the specification or set of a DTF machine. We highly recommend performing a test before proceeding with standard production.

### APPLICATION GUIDE

1. Suggest using 135°C, 8S, 3-3.5Kg to apply metallic DTF hot seals on garments, as the high temperature would lead to the saw tooth. Please pre-heat the fabric for Autumn/Winter season garments.
2. We recommend using a brush to wipe off the voids and double press (135°C, 8 Seconds, 3-3.5Kg) to ensure the durability of the laundering.
3. Always cold peel the films when hot seals achieve room temperature. Usually, the metallic DTF foil temperature recovery will be quicker than regular films; 15-20 Seconds should be fine.
4. Quickly tear off the films (from random corners); any stop might leave a matt mark on prints, and it's not a film quality issue.
5. Please do not double press any artwork already applied on garments; contact the MAXDTF technical team on how to remove the



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## APPLICATION GUIDE

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DTF prints if required.

6. The minimum line weight range was 2mm. Too many curved artwork designs or thin line weights gradient points might lead to some areas needing to display correctly (extra foil resides on prints); please use a brush to clean the foils (easily removed) if necessary.

## STORAGE CONDITION

1. Suggest temperature:10-30°C, Humidity 35-65%.
2. Please make sure the unused films are wrapped with soft materials before being put on shelves and prevent exposure to water, direct sunshine & high humidity/temperatures. The shelf life was one year since the DOM date and three months for an unsealed film (make sure it's sealed again after 1<sup>st</sup> usage.). Always test the unsealed films before bulk production.