Digiline Emblems

Digiline emblems are digitally printed. Any desired colour can be ordered using the Pantone Matching System. An additional advantage of Digiline is the relatively short delivery period of 7 days following approval of the artwork.

Digiline is available in three versions: **Digiline, Digiline Sports** and **Digiline Low Melt**.

Digiline
Digiline emblems can be applied to materials where strength and durability are needed. The emblem is resistant to industrial washing at 95°C. Despite this high washing temperature, the fresh, bright, and vibrant colors are guaranteed for a long time. Digiline can be produced with a woven effect, which enhances the overall look.

Digiline emblems are applied to a fabric at a temperature of 195°C. The production process and the Digiline emblems are Oeko-Tex certified.

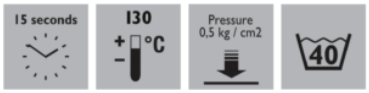
Digiline Sports & Digiline Low Melt
Digiline Sports and Digiline Low Melt are lighter and more flexible compared to the standard Digiline. These emblems are suitable for promotional purposes and sportswear. A club name, logo or sponsor is presented in the best possible way with the Sports and Low Melt version. In addition to the full color images, for Digiline Sports and Digiline Low Melt effects such as 3D, emboss, gloss, and even a leather look are possible.

Digiline Sports is applied to fabrics at a temperature of 145°C, Digiline Low Melt at a temperature of 130°C. Both can be washed up to 40°C. It is possible to apply these emblems with a Thermopatch heat sealing machine. Alternatively, to increase ease of use, Digiline Sports and Digiline Low Melt are also easy to apply with an iron on any type of fabric. The production process and the Digiline Sports and Digiline Low Melt emblems are Oeko-Tex certified.

Quantities
The minimum order quantity is 15 pieces per design.

Digiline

Digiline				
Digiline Sports				

Digiline Low Melt	

Digliline emblems are compliant to Oekotex product class II, under certificate number 1012046 Centexbel.

Application
Digitally printed emblems which are applied to textiles or other heat sealable materials by heat and pressure for decoration or identification.

Properties
– Digiline is washable up to 95°C.
– Good chemical resistance.
– Digiline Sports and Digiline Low Melt are washable up to 40 °C
– Digiline products are suitable for all textiles which allow the thermoplastic adhesive to penetrate and bind itself to it and which are resistant to its application temperatures.

Limitations of use
Digiline with high temperature glue applications are washable up to 95 °C industrial washing. Digline Sports and Digiline Low Melt with low temperature glue application are washable up to 40 °C.

Physical properties
Color imprint: various
Color base textile: white
Color glue laminate: clear
Sizes: various

Before sealing
Ensure that the to be marked textile is free of lint, dust, dirt and no seams, zipper, buttons etc. are near the place where the heat sealing will be performed.
Remark:
– Good bonding can be prevented in pre-conditioned fabrics with a dirt or water repellant or flame retardant treatment or coating.
– Pre-sealing can amend problems with adhesion on certain repellant or flameretardant coated textiles.
– Re-sealing can amend problems with adhesion on certain repellant or flameretardant treated textiles.

Heat seal instructions
– Digiline: 195 °C for 14 seconds at 0.5 kg/cm2* pressure on a pneumatic heat seal machine, or firm – strong pressure on a manually operated machine.

– Digiline Sports: 145 °C for 15 seconds at 0.5 kg/cm2* pressure, or medium pressure on a manually operated machine.
– Digiline Low Melt: 130 °C for 15 seconds at 0.5 kg/cm2* pressure, or medium pressure on a manually operated machine.
– Make sure that the sealing plate of the machine is clean and undamaged.
– Close the heat seal press with the set temperature, time and pressure.
– Remove the garment from the machine after the heat sealing cycle is finished.
– Place the next article and repeat above.

(*) For an optimal heat sealing result we advise to set the pressure on any large platen pneumatic heat seal press to 3-5 bar on the pressure regulator of the machine, when using the standard issued underplaten. When using smaller underplatens, decrease pressure to avoid damage to the transfers.

Handling and storage
Keep away from oxidizing agents, from strongly alkaline en strongly acid materials. Store out of direct sunlight, in a cool and dry place.

Scroll down for Digiline Sports and Digiline Low Melt

Digiline emblems (up to 95 °C laundry wash)			
Type of fabric	**Temp. °C**	**Pressing time in sec.**	**Pressure in Bar Low/Medium/High**
Fleece, 100% Polyester	195 – 204	15	4-6 (Medium/High)
Polyurethane or PVC coated polyester (rainwear), cover with baking paper	195 – 204 Repress	15 15	4.5 (Medium/High)
Knitted fabrics, 100% polyester, viscose, acrylic (Sportswear, light workwear)	–	–	–
Knitted fabrics, 100% wool, cotton (Sportswear, light workwear)	–	–	–
Knitted fabrics, cotton or polyester with elastane 98%/2%	–	–	–

Flame-retardant cotton or polyester cotton (FR treated, Proban®)	195 – 204	15 – 12	4.5 (Medium/High)
Cotton/polyamide 55%/45%	Preheat 195 – 204	10 15 – 12	4.5 (Medium/High)
Cotton/polyester 65%/35% or 60%/40% (with DWR finish)*	195 – 204	12	4.5 (Medium/High)
Aramid/Viscose 50%/50%	195 – 204	12	4.5 (Medium/High)
Linen, 100%	195 – 204	20	4.5 (Medium/High)
Aramid (Nomex III), 100%	195 – 204	12	4.5 (Medium/High)
Polyamide (Nylon), 100% (with DWR finish)*	195 – 204	12	4.5 (Medium/High)
Polyester 100% (with DWR finish)*	195 – 204	12	4.5 (Medium/High)
Polyester Cleanroom material anti-static 99%/1%	195 – 204	12	4.5 (Medium/High)

Digiline Sports (low to medium temperature, digital emblems, sportswear, light workwear, up to 40 °C industrial wash)

Type of fabric	Temp. °C	Pressing time in sec.	Pressure in Bar Low/Medium/High
Fleece, 100% Polyester	140	15	3 (Low)
Polyurethane or PVC coated polyester (rainwear), cover with baking paper	140	15	3 (Low)

Knitted fabrics, 100% polyester, viscose, acrylic (Sportswear, light workwear)	130 – 140	15	3 (Low)
Knitted fabrics, 100% wool, cotton (Sportswear, light workwear)	140	15	3 (Low)
Knitted fabrics, cotton or polyester with elastane 98%/2%	130 – 140	15	3 (Low)
Flame-retardant cotton or polyester cotton (FR treated, Proban®)	–	–	–
Cotton/polyamide 55%/45%	140	15	3 (Low)
Cotton/polyester 65%/35% or 60%/40% (with DWR finish)*	140	15	3 (Low)
Aramid/Viscose 50%/50%	–	–	–
Linen, 100%	140	15	3 (Low)
Aramid (Nomex III), 100%	–	–	3 (Low)
Polyamide (Nylon), 100% (with DWR finish)*	–	–	3 (Low)
Polyester 100% (with DWR finish)*	–	–	3 (Low)
Polyester Cleanroom material anti-static 99%/1%	–	–	–

Digiline Low Melt (low temperature, digital emblems, sportswear, light workwear, up to 40 °C home wash)

Type of fabric	Temp. °C	Pressing time in sec.	Pressure in Bar Low/Medium/High
Fleece, 100% Polyester	130	15	3 (Low)
Polyurethane or PVC coated polyester (rainwear), cover with baking paper	130	15	3 (Low)
Knitted fabrics, 100% polyester, viscose, acrylic (Sportswear, light workwear)	130	15	3 (Low)
Knitted fabrics, 100% wool, cotton (Sportswear, light workwear)	130	15	3 (Low)
Knitted fabrics, cotton or polyester with elastane 98%/2%	130 – 140	15	3 (Low)
Flame-retardant cotton or polyester cotton (FR treated, Proban®)	–	–	–
Cotton/polyamide 55%/45%	140	15	3 (Low)
Cotton/polyester 65%/35% or 60%/40% (with DWR finish)*	–	–	–
Aramid/Viscose 50%/50%	–	–	–
Linen, 100%	130	15	–
Aramid (Nomex III), 100%	–	–	–
Polyamide (Nylon), 100% (with DWR finish)*	–	–	–

Polyester 100% (with DWR finish)*	–	–	–
Polyester Cleanroom material anti-static 99%/1%	–	–	–

**DWR finish: Durable Water Repellent finish, meaning a water (dirt, oil) repellent coating on textiles based on silicone, nanotechnology, wax, and fluorocarbon.*
FR: Flame Retardant

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