

## Digiline Ecussons

Les écussons sont imprimés numériquement. Tout coloris souhaité peut être commandé sur la base des coloris Pantone. De plus, le Digiline est réalisé dans délai court après l'approbation de la maquette.

Le Digiline est disponible en 3 versions: **Digiline**, **Digiline Sports** et **Digiline Low Melt**.

### Digiline

Les écussons Digiline peuvent être appliqués sur des textiles où résistance et longévité sont nécessaires. Cet écusson est résistant aux lavages industriels jusqu'à 95°C. Malgré un lavage haute température, la brillance, l'éclat et la fraîcheur des coloris sont garantis très longtemps. Le Digiline peut être imprimé avec un effet tissé, qui réhausse l'aspect final.

Les écussons Digiline sont thermofixés sur le tissu à une température de 195°C. Le procédé de fabrication et les écussons Digiline sont certifiés Oeko-Tex.

### Digiline Sports & Digiline Low Melt

Le Digiline Sports et le Digiline Low Melt sont plus souples et plus légers que le Digiline Standard. Ces écussons sont conçus pour les articles promotionnels et les vêtements de sport. Ces 2 versions de Digiline sont le meilleur moyen de mettre en avant un nom de club, un logo ou un sponsor. Aux images en couleur peuvent s'ajouter sur le Digiline Sports et le Digiline Low Melt des effets tels que le 3D, le relief, la brillance ou encore l'aspect cuir

Digiline Sports s'applique sur les tissus à une température de 145 °C, Digiline Low Melt à une température de 130 °C. Ils peuvent être lavés jusqu'à 40 °C. Ces écussons sont thermofixables avec une thermopresse de la gamme Thermopatch. En alternative et pour faciliter l'utilisation, ils sont également faciles à appliquer à l'aide d'un fer à repasser sur tous types de tissus. Le processus de production et les écussons Digiline Sports et Digiline Low Melt sont certifiés Oeko-Tex.

### Quantités

Commande minimum de 15 pièces par logo.

## Digiline

|                 |                                                                                     |                                                                                     |                                                                                     |                                                                                     |
|-----------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|
| Digiline        |  |  |  |  |
| Digiline Sports |  |  |  |  |

**Digiline Low Melt**



Digiline 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. Digiline 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 repellent or flame retardant treatment or coating.
- Pre-sealing can amend problems with adhesion on certain repellent or flameretardant coated textiles.
- Re-sealing can amend problems with adhesion on certain repellent 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<br>Repress | 15<br>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<br>195 – 204 | 10<br>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) |

| <b>Digiline Sports (low to medium temperature, digital emblems, sportswear, light workwear, up to 40 °C industrial wash)</b> |                 |                              |                                        |
|------------------------------------------------------------------------------------------------------------------------------|-----------------|------------------------------|----------------------------------------|
| <b>Type of fabric</b>                                                                                                        | <b>Temp. °C</b> | <b>Pressing time in sec.</b> | <b>Pressure in Bar Low/Medium/High</b> |
| 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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