Digiline 徽章

Digiline徽章是数码印刷，任何所需的颜色都可以通过匹配的盘通系统定购Digiline的另一优势是快速的交付时间，图稿确认后的7个工作日即可完成。

Digiline 有三个版本：**Digiline, Digiline Sports** 和 **Digiline Low Melt**

Digiline
Digline徽章可以应用在高强度和耐用性的材料上。该徽章可耐受95 ° 的工业洗涤。尽管洗涤温度是如此高，仍能长时间保证清新、明亮和鲜艳的色彩Digiline 可以采用编织效果制作，从而增强整体外观。

Digiline 徽章可以应用在195 ° 的织物上。生产过程和Digline徽章均通过Oeko-Tex认证。

Digiline Sports & Digiline Low Melt
Digiline Sports 和 Digiline Low Melt 比Digiline Industrial 更轻盈和灵活。他们适用于促销赠品和运动服装。使用 Sports 和 Low Melt 版本，可以以最佳的方式呈现俱乐部名称、商标或赞助商。除了全彩图像外Digiline Sports 和 Digiline Low Melt 还可以实现 3D浮雕、闪光甚至皮革外观等效果。

Digiline Sports 在 145°C 的温度下应用于织物上Digiline Low Melt 在 130°C 的温度下应用。两者都可在 40°C 的水温下清洗。可以使用 Thermopatch 热压机将徽章热压在织物上。另外，为了增加易用性Digiline Sports 和 Digiline Low Melt 也可以使用熨斗在任何类型的织物上轻松应用Digiline Sports 和 Digiline Low Melt 徽章均获得 Oeko-Tex 认证。

数量
最少起订量是15个/图案。

Digiline

Digiline	14 seconds	195 °C	Pressure 0,5 kg / cm2	95
Digiline Sports	15 seconds	145 °C	Pressure 0,5 kg / cm2	40
Digiline Low Melt	15 seconds	130 °C	Pressure 0,5 kg / cm2	40

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.

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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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