

## SOLUTIONS™ OPAQUE



**FEED MATERIAL**  
into plotter/cutter  
so that the media  
faces up.



**PRINT DESIGN**  
in positive form  
(do not mirror).

### Description

For use with solvent /eco solvent  
print and cut systems and is  
specially formulated to work on dark  
colored garments.  
(PU,55 micron [+/-10%])



**CUT DESIGN**  
If cutting through  
ink, let the print dry  
for 2-4 hours;  
otherwise you may  
cut immediately.  
Dry times may vary.



**WEED**  
away the excess  
media. If the design was  
cut immediately,  
the print must dry  
30-60 minutes  
before proceeding.

### Recommended Fabrics

100% polyester  
100% Preshrunk Cotton  
Poly/cotton blends  
Lycra®/ Spandex blends  
Woven nylon  
Nylon knits  
Nylon meshes - micro, tricot,  
mini, reversible



**PLACE MASK**  
over the graphic,  
making sure to  
smooth out any air  
bubbles.

**REMOVE**  
backing revealing  
materials adhesive.



**PREHEAT & POSITION**  
Preheat garment for  
10 seconds, prior to  
application. Position the  
graphic & cover with  
Kraft Paper.

Polyester knits  
Polyester mesh  
Poly/foam & cotton caps  
Satin  
Cordura®

*Due to the combination of fabrics, weaves,  
and dyes used in the textile industry,  
testing is pertinent. Stahls' recommends  
and provides samples of our materials and  
medias for testing.*



**HEAT APPLY**  
Temperature:  
300-305°F; 145-155°C  
Time:  
3-5 seconds  
Pressure:  
medium  
#6 on Hotronix®



**PEEL MASK WARM**  
Cover with Kraft Paper or  
Teflon® Sheet and  
reseal for 3-5 seconds.

### Accessories Required

CAD-COLOR® Solutions™ Mask  
Kraft Paper/ Teflon® Sheet  
EZ Weeder® or Tweezers

### Cutting Notes

Be sure to perform test cuts to  
ensure proper blade depth when  
cutting. Cutting too deep will result  
in weeding or masking difficulties.

## CUTTER GUIDELINES

CUTTER	BLADE	FORCE	OFFSET	SPEED
Roland SP-300	45°	50g	.25	30cm/s
Roland VP-300	45°	90g	.25	30cm/s
Roland XC-540	45°	80g	.25	60cm/s
Roland GX-24	45°	90g	.225	30cm/s
Mimaki CG-75 FX	SPB-0001	55g	.15	50cm/s

### Care Instructions

For best results, turn the garment  
inside out. Machine wash warm or  
cold using mild detergent. Do not  
use bleach. Do not iron directly on  
transfer. Tumble dry at low setting. Do  
not dry-clean. Natural distressing can  
occur with repeated washings.

### Storage

Store in a cool, dry area. Avoid  
direct heat, sunlight and humidity.

All technical information and recommendations are based on tests we believe to be reliable. However, we cannot guarantee performance for conditions not under manufacturer's control. Before using, please determine the suitability of product for its intended use. The user assumes all risk and liability whatsoever in connection with the use of this product. Seller's and manufacturer's only obligation shall be to replace such quantity of the product proved to be defective by manufacturer.

CAD-CUT, Pressure Sensitive Poly-TWILL, & Hotronix are trademarks & ® trademarks of GroupeSTAHL™ with one or more patents or patents pending.  
© Stahls' International™ 2010 - All International Rights Reserved