

Thermo-FLOCK®

CAD-CUT® Thermo-FLOCK® has a soft, raised, velvety texture that's extremely popular for corporate logos and children's wear. (505 micron [+/-10%])



FEED MATERIAL

into cutter so that the carrier is on the bottom.



CUT LOGO,

words or numbers in reverse (mirror image).



WEED

away excess material leaving only the desired graphic on the carrier.



PREHEAT & POSITION

Preheat garment for 10 seconds, prior to application. Position weeded design on garment with the carrier side up

(reads left to right).

Place a Kraft Paper cover sheet over carrier before pressing.



HEAT APPLY

Temperature: 350°F; 177°C
Time: 8-10 seconds
Pressure: medium
#4 on Hotronix®



PEEL COOL

Allow to cool completely before peeling carrier. It is best to peel carrier away from garment as opposed to pulling the garment from the carrier.

Recommended Fabrics

100% cotton
100% polyester
Poly/cotton blends
Polyester knits
Polyester mesh
Acrylic blends
Sublimated Polyester
Poly/foam & cotton caps
Satin

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

Accessories Required

Kraft Paper or Reusable Cover Sheet
EZ Weeder® or Tweezers

Cutting Notes

You should always test cut prior to any production run. Remember cutter settings will need to be adjusted as your blade ages. Cutting Thermo-FLOCK® requires a fair amount of force and a high blade lift in order to cut successfully. For optimal cutting and weeding, maintain a line thickness of at least 3/16" (5mm) for lettering & logos.

Application on Sublimated Jersey's

Do NOT preheat the garment. Apply Thermo-FLOCK® at 300°F/149°C for 12-15 seconds—light pressure.

Care Instructions

Machine wash cold or warm using mild detergent. Do not use bleach. Dry at a normal dryer setting on household machines. Do not iron directly onto Thermo-FLOCK™. (use cover sheet)

Multi-Layered Designs

Two-color Thermo-FLOCK® is NOT recommended. As an alternative, use Thermo-FILM® for the background and Thermo-FLOCK® as the foreground.

Storage

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

CUTTER GUIDELINES

CUTTER	BLADE	FORCE	OFFSET	SPEED
Roland GX-24	Flock Blade	170-220g	.50	50cm/s
Ioline 100	45°	275-300g	.15	50%
Ioline 300	30°	270g	.15	25%

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™ 2012 - All International Rights Reserved