DIGISTAR PES HD ONE

Code N° M4087--

Series of inks transfer sublimation printing, compatible with DX3, DX4 and DX5 piezo printheads.

DIGITAL SUBLIMATION INK FOR TRANSFER PRINTING

- Ideal for transferring onto synthetic fabrics (polyester)
- Ideal for transferring onto rigid substrates (pre-treated)

APPLICATION VERSATILITY

- Ideal for sportswear, promotional items, curtaining, flags, banners, interior decoration
- Ideal for transferring onto rigid substrates (pre-treated)

COMPATIBLE WITH DX3, DX4 and DX5 PRINTHEADS

- Compatible with the above-mentioned piezo printheads

GENERAL FEATURES

- Very vivid and bright colours, allowing to achieve a wide colour space during profiling
- Good general fastness
- Excellent drying quickness of the printed paper
- Excellent release (transfer) capacity

PRODUCTS OF THE SERIES

COLOUR	BLACK	CYAN	LIGHT CYAN	MAGENTA	LIGHT MAGENTA	YELLOW
CODE	408710	408751	408752	408730	408731	408715
PACKING	1 litre	1 – 2 litres	1 litre	1 – 2 litres	1 litre	1 – 2 litres
SHELF LIFE	12 months	15 months	15 months	15 months	15 months	15 months

COLOUR	BLACK PLUS	DEEP BLACK	GREY	YELLOW FLUO	PINK FLUO	GREEN FLUO
CODE	408711	408712	408713	408716	408734	408760
PACKING	1 – 2 litres	1 -2 litres	1 litre	1 litre	1 litre	1 litre
SHELF LIFE	15 months	15 months	15 months	15 months	15 months	15 months

COLOUR	TURQUOISE	BLUE	ORANGE	BLUE FLUO
CODE	408754	408750	408733	408756
PACKING	1 litre	1 litre	1 litre	1 litre
SHELF LIFE	15 months	15 months	15 months	15 months

DIRECTIONS

It is recommended to let the product reach operative conditions in terms of temperature and humidity at least 24 hours prior to use, taking care of not stirring it, and apply the product under controlled conditions:

- **RECOMMENDED TEMPERATURE RANGE: 20-25°C**
- **RECOMMENDED HUMIDITY RANGE: 40-60%**

The ink is ready to use and it is recommended to use it through the external feeding system (**INK FEEDER, COE. M4087..**), so that a steady printing quality is assured.

The printed paper must be transferred hot, through calender or flat press, at a temperature between **180-220°C** during a varying time, between **180" and 30'**'.
Time and temperature may vary, depending on the type and nature of the material, which the transfer is made onto.
In case that a decoration of such rigid substrates, that due to their nature are not similar to the sublimation ink, is required, it is necessary to prepare this affinity, by preventively applying a coating (**SUBLICOAT A+B, CODE M40810..**) onto the surface to be decorated.

SUBLIMATION PAPER

DIGISTAR PAPER (COD. 4083..) is a suitably realized paper for digital printing through sublimation products, with an appropriate treatment, in order to assure the best results in terms of color and outline definition. For further information, see the related technical data sheet.

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AUXILIARIES – FLUIDS FOR PLOTTER MAINTENANCE

- **DIGISTAR CAPPING FLUID (CODE 408703):** this product has moistening and anti-scaling properties, available in 250 ml container with dosing pipette for application on "capping station".
- **DIGISTAR CLEANER (CODE 408501):** this product is used for cleaning the ink feeding circuits.

For further information, see the related technical data sheet.

FASTNESS

COLOUR	CODE	FASTNESS – EN ISO			SUBLIMATION CLASS
		105B02	105C10	105E04	
BLACK	408710	6	4-5	5	B/C
CYAN	408751	5-6	4-5	4-5	C
LIGHT CYAN	408752	5-6	4-5	4-5	C
MAGENTA	408730	6-7	4-5	5	C
LIGHT MAGENTA	408731	6-7	4-5	5	C
YELLOW	408715	6-7	4-5	4-5	B
BLACK PLUS	408711	6	4-5	4-5	B/C
DEEP BLACK	408712	5-6	4-5	4-5	B/C
GREY	408713	6	4-5	5	B/C
YELLOW FLUO	408716	4	4-5	5	B
PINK FLUO	408734	4	4-5	5	C
GREEN FLUO	408760	4	4-5	5	B
BLUE FLUO	408756	6	5	5	C
TURQUOISE	408754	6	5	5	C
BLUE	408750	6	4-5	5	B/C
ORANGE	408733	4-5	4-5	5	B

FASTNESS - EN ISO		
	105B02	LIGHT FASTNESS
	105C10	WASHING FASTNESS
	105E04	PERSPIRATION FASTNESS

SUBLIMATION CLASS		
	A	$T_{SUBLIMATION}$ 180°C
	B	$T_{SUBLIMATION\ E}$ 190°C
	C	$T_{SUBLIMATION}$ 200°C
	D	$T_{SUBLIMATION}$ 210°C

FASTNESS RANGE: LIGHT FASTNESS: min 1, MAX 8 – WASHING FASTNESS: min 1, MAX 5 – PERSPIRATION FASTNESS: min 1, MAX 5

STORAGE

It is recommended to keep the product away from light and heat sources at a **temperature lower than 25° C**.

SPECIAL INSTRUCTIONS

- **INK CONVERSION:** It is essential to flush (with the appropriate above-mentioned cleaners) both the line and printheads when converting/changing ink series to avoid contamination and chemical incompatibilities. This is a critical step in the process.
- It is recommended to always make printing, drying and transfer tests onto the substrates which are meant to be used, so as to exactly determine features, working time and effects to be obtained.
- Extreme drying conditions near the printer carriage could compromise the quality of the prints.
- Require safety data sheets, available for all products, and always follow the contained instructions regarding all the specific information and the environmental safety.
- The ink performance is strictly connected to the used plotter model and printing procedure.

IMPORTANT NOTE

The information given in this technical sheet is not intended to be exhaustive and any person, using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us to the suitability of the product for the intended purpose, does so at his own risk. While we endeavor to ensure that all advice we give about the product is correct, we have no control over either the quality or condition of the substrate or the many factors affecting the use and application of the product.
Therefore, unless we specifically agree in writing to do so, we do not accept any liability whatsoever or howsoever arising for the performance of the product or for any loss or damage arising out of the use of the product. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.