
TUBASSIST SOFTMELT

Character	Hotmelt adhesive granulate for producing transfers
Chemical Structure	Thermoplastic synthetic granulate/powder
Supplied Form	White, fine powder
Melting Range	100 – 110 °C
Fineness	100 – 300 µ
Storage / Storability	Stored properly in a dry place in closed original containers between + 5 °C and + 40 °C, the product will hold for at least 12 months.

The above given values are product describing data. Please consult the 'delivery specification' for binding product specifications. Further data about product properties, toxicological, ecological data as well as data relevant to safety can be found in the safety data sheet.

Properties

TUBASSIST SOFTMELT is thermoplastic and facilitates the production of very soft, resilient flock and colour transfers. Bonding with the textile is done by means of contact heat and pressure (ironing press).

Film Properties

In combination with TUBVINYL® BOND or TUBVINYL® ELASTOBOND and TUBASSIST curing agents, TUBASSIST SOFTMELT produces very elastic flock transfers with high layer stability and very soft handle. Elasticity, handle and fastnesses of the print transfers depend on the applied print system.

Stability

Depending on the recipe composition, transfer temperature and textile substrate, the flock transfers properly produced with TUBVINYL® adhesives show a good to very good adhesion to the textile substrates and reach a wash fastness of up to 60 °C as well as a good fastness to dry cleaning.

® = registered trade mark

Application Procedure

Application Fields

TUBASSIST SOFTMELT serves as universal hotmelt adhesive component for producing transfer motifs and can be applied in combination with TUBVINYL® adhesives or as hotmelt layer together with other print transfer systems such as AQUAFLEX transfers, foam transfers or glitter transfers.

Recommendation for Use / Processing

Condition of Substrate

The ready-made transfers can be applied to a multitude of nowadays common wovens and knits; they are particularly recommended for stretchable or elastic fabric qualities.

Recipe Recommendation

To prevent a layer separation and to achieve good wash fastnesses we recommend adding a TUBASSIST curing agent to the transfer adhesive. The curing agent should be added just before starting with the process. The mixed print pastes ought not to be stored over a prolonged period or at higher temperatures as this may have an adverse effect on the transfer properties.

Processing Recommendation

Application of Hotmelt Powder	Normally, the hotmelt powder is sprinkled onto the still wet adhesive layer immediately after the adhesive printing or the freshly printed sheets are drawn through a tub with hot-melt powder.
Drying the Adhesive/ Hot-Melt Layer	Can be effected either in the drying chamber or in the continuous drier at temperatures of up to 80 °C at the most, 15 - 45 min; drying at room temperature for 12 - 24 hours is possible as well.
Cleaning-off the Surplus Hot-Melt Adhesive Powder	Can be removed by brushing off with a soft brush by hand or with special cleaning units, possibly by means of a corresponding vacuum unit.
Curing of the Adhesive System + Sintering the Hot-Melt Layer	For achieving best possible fastness properties, a curing of the adhesive layer by heat treatment is necessary. By doing so, the hot-melt layer is melted a little and thus stabilized for further processing. With multicoloured flock transfers, the final dyestuff curing is effected at this process.

Water steam arising during the curing process (polycondensation) must be drawn off continuously in order to avoid humidity accumulating at the curing zone which causes an incomplete cross-linking of the adhesive.

Transfer Process

By customary ironing presses with light to medium pressure.

Standard values

Flock transfers: 140 – 180 °C, 30 – 15 seconds, medium pressure

Print transfers: 120 – 160 °C, 20 – 10 seconds, medium pressure

depending on working conditions and textile qualities.

Recommendation for Use

Before going into production, we recommend making it a rule to test first the suitability of the hot-melt adhesive powder in combination with the transfer adhesives and flock papers used regarding wettability, adhesion respectively layer stability, fastness properties and process parameters and to control everything as well during the production run. Moreover, we urgently recommend testing the ready transfers as to their suitability for the substrate to be applied and the existing transfer conditions.

Warning

This product may give positive detections for restricted arylamines in the finished article. Please, follow carefully TDS application instructions, especially time and temperature conditions and, contact technical department in case of any further clarification.

We reserve the right to modify the product and technical leaflet.

Our department for applied technique is always at your service for further information and advice.

Our technical advice and recommendations given verbally, in writing or by trials are believed to be correct. They are neither binding with regard to possible rights of third parties nor do they exempt you from your task of examining the suitability of our products for the intended use. We cannot accept any responsibility for application and processing methods which are beyond our control.

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