DuPont™ Artistri® DTF-120 Transfer Film

Direct to Film Transfer Film

DuPont™ Artistri® DTF-120 film is a premium transfer film specially developed for direct-to-film digital printing on cotton, polyester, and blends, as well as other substrates served by DTF, supporting a wide variety of apparel and specialty applications.

Backed by more than 35 years of digital inkjet industry leadership, DuPont™ Artistri® DTF-120 film also comes with DuPont's full process technical support.

The film is designed to work as hot or cold peel and to deliver vibrant colors with a dry touch.

Application Properties

DuPont™ Artistri® DTF-120 film yields large color gamut with high L* and are specifically formulated for Direct to Film (DTF) printing processes. Contact DuPont Technical Support for process recommendations.

Commercial Supply

DuPont™ Artistri® DTF-120 film is supplied in 600mm x 100m (24" x 328') rolls in a 2 roll-box.

Storage

The transfer film can be stored in a clean area with normal ambient conditions, i.e., temperature between 5°C – 35°C (41°F to 95°F) and humidity from 45% - 65%. The rolls of film are shipped in sealed bags. Once the bag is opened, the film should be used as soon as possible.

Product Features and Benefits

- Works excellent with Artistri® P1600 (and other inks though results may vary)
- Quality consistency
- Large color gamut and high L*
- Hot and cold peel DTF Printing

Production Process

Printing and Applying the Adhesive Powder

There is a well-known tradeoff between quality and throughput of the printer. Increasing the number of passes and the target resolution tends to improve print quality but requires longer time to print. This must be considered when choosing the print mode of the printer.

The complete printing, powdering, and drying process is done inline in roll-to-roll machines. These printers often pre and post heat the film, control the powder amount and dry/melt the ink/powder layer. Please follow the printer manufacturer's recommendations for setting the various parameters involved in the process.

If inks are used on a platen printer, it is recommended that the powder be dispensed manually within 30 seconds of printing. The ink will have to be partially dried to achieve the desired printed image results. It needs to be tacky to receive the powder, but not so wet that the powder will agglomerate.

The choice of powder will impact the resulting wash fastness and hand feel of the laminated image. Ensure the entire image is covered in powder – any portion of the image not covered will have poor wash fastness. Shake off any excess powder especially from the areas of the film that were not printed on as this will lead to a halo effect on the shirt. Excess powder will lead to a stiffer image and a worse hand feel. Excess powder on an overly wet ink will lead to clumping and uneven lamination.

Drying

If drying is not done inline, some experimentation will be needed to determine the optimum temperature and time in the oven. For short times (i.e., 3 to 5 minutes in the oven) temperatures of 135 to 160°C (275 to 320°F) are recommended. Satisfactory results can also be obtained with longer times at lower temperatures.

Press and Peel

The transfer process involves pressing for 8 to 15 seconds at 150 to 170 ° C (302 to 338 °F) using medium to high pressure onto your garment. The film can be used for hot peel (right off the press) or cold peel (cooling the sheet to reach room temperature). The image should be transferred completely to your garment following this transfer process.

Note: the image and related amount of ink used will impact which peel and press process parameters to be used. If the image is not completely transferred, you may:

- Not have used enough white ink for the powder to stick to
- Have dried the white ink too much not allowing the powder to adhere
- Need a different curing time and/or temperature during the press and peel step

To achieve optimal image quality and color, the ink laydown needs to be properly adjusted for both CMYK and W. Contact DuPont Technical Support for recommendations specific to your equipment & process.

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For more information on Artistri® or other DuPont products, please visit our website.

Artistri.dupont.com

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CAUTION: Do not use in medical applications involving permanent implantation in the human body. For other medical applications, see "DuPont Medical Caution Statement," H-50102-5 and "DuPont Policy Regarding Medical Applications" H-50103-5.

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