

PROCESSING INSTRUCTIONS FLEXXLINE AND SMART-FLEXXLINE

The RATHGEBER Group delivers FLEXXLINE and smart-FLEXXLINE products (with NFC/RFID functionality) in faultless condition. We have compiled these processing instructions for you to ensure optimal processing and secure, permanent bonding:

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1. PRODUCT DESCRIPTION

FLEXXLINE is a multi-layer product incorporating the base materials PU or PVC. By combining different structures, a high-quality embossed feel is created on emblems or lettering, which can be used to refine textile surfaces. FLEXXLINE emblems are supplied with a specially developed hot melt adhesive and is activated during processing using a transfer press. The special features of smart-FLEXXLINE are also explained in section 4.3.

2. INFORMATION ON TEXTILE SURFACES

FLEXXLINE products can be applied to numerous textile surfaces. However, please only use surfaces that can withstand the high temperatures of the transfer press. For surfaces made of nylon, polyamide, wool, fleece, and (synthetic) leather, certain cotton fabrics and impregnated fabrics, tests on temperature resistance and adhesion should always be conducted.

3. STORAGE

- Process the products within 12 months.
Please note the processing date indicated on the packaging.
- Protect your FLEXXLINE products from direct sunlight.
- Store your FLEXXLINE products at room temperature (approx. 20 °C and approx. 50% relative humidity).
- Do not expose the products to heavy loads.

4. PROCESSING INSTRUCTIONS

Attention – The quality of the adhesion depends on numerous factors: The geometry of the FLEXXLINE emblem, choice of adhesive, material thickness/ properties of the surface, transfer press equipment (e.g. membrane, heated table), temperature of the transfer press, pressing time, pressure.

4.1. SETTING UP THE TRANSFER PRESS

transfer press	semi-automatic	manual press
modell	Wagner: Professional membrane	Wagner: Junior
temperature of the press	160 °C	175 °C
press time	textile 15 sec. preheat emblem 15 sec. pressing	textile 15 sec. preheat emblem 40 sec. pressing
pressure	heating plate 5 bar, membrane 0.3 bar	medium pressure
silicone rubber	no	yes
baking paper	yes	no

4.2. STEP BY STEP GUIDE

1



Before pressing, clean your textile carefully with a suitable aid (e.g. lint roller). Wait, until the transfer press reaches the desired temperature and heat the textile for approx. 15 sec.

2



Remove the silicone rubber backing (if present) from your FLEXXLINE emblem. Now position the emblem on the textile. (Do not remove the transparent protective film yet).

3



Place the silicone rubber on the textile and FLEXXLINE emblem. This will protect the structure of your emblem.

4



Close the transfer press. After the pressing time has expired, open the transfer press again and let the emblem cool down briefly.

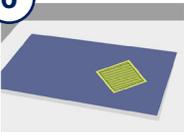
5



Remove the transparent protective foil.

Tip: With some textiles it is possible that an imprint of the protective film may appear. You can avoid this by removing the protective film after 5-10 seconds in Step 4 and then pressing it in place.

6



The maximum adhesion of the FLEXXLINE emblem is reached after approx. 72 hours. Avoid strong temperature and humidity variations during the curing time.

4.3. NOTES ON PROCESSING SMART-FLEXXLINE PRODUCTS

With a smart-FLEXXLINE product, the FLEXXLINE article is additionally equipped with a transponder, enabling it to be networked with the digital world using NFC/RFID technology. The emblems are tested according to the ISO 105-C06 and ISO 6330 standards for colour fastness and durability during washing and drying.

Please follow the instructions below to ensure proper functioning:

- Avoid storing RFID/NFC transponders near electromagnetic fields at all times.
- Do not expose the RFID/NFC transponders unprotected (e.g. silicone rubber) to high temperatures for long periods (> 60 seconds). Irreversible damage to the chip (IC) can occur above 80 °C.
- The proximity of metallic surfaces (also painted, coated or otherwise covered) can have a negative effect on the function of the RFID/NFC transponders. For this reason, before gluing check whether the transponders can be read at the desired location.

5. CARE INSTRUCTIONS

In addition to our processing instructions, please also note the care instructions on your textile substrate.



Wash at max. 40 °C



Iron only at low temperature and from the left.



Not suitable for dryers.



Do not bleach or dry clean. Do not use fabric softener.

These processing instructions are based on our thorough tests and experience and were developed together with our partner „Wagner Thermodruckpressen“.

Due to the variety of our products and their possible applications, we are not able to any liability for our recommendations. Please carry out your own processing tests in any case.

FLEXXLINE products are also available in a self-adhesive version. Please feel free to get in touch with us at any time if you need support.

We wish you much pleasure with your FLEXXLINE product.

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