



INSTRUCTIONS FOR WORKING WITH RATHGEBER FLEXXLINE PRODUCTS

At Rathgeber we do our utmost to ensure that our products reach you in perfect condition. To help you work with them in an optimal way and ensure the effectiveness of the adhesive, we have compiled these instructions for you.

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For further helpful information regarding our products and services, please visit our website:

<https://www.rathgeber.eu>



1. GENERAL INFORMATION

- Make sure that the application surface is clean, dry and free of dust, oils, oxides, release agents and other contaminants.
- Not every textile is necessarily suitable for adhesives. Note that the adhesion of your FLEXXLINE product may vary depending on the substrate.

These instructions are based on our careful tests and experiences with this product. Since our products are versatile and can be used in a wide variety of ways, we cannot accept liability for these recommendations.

You should always conduct your own tests when working with the product.

2. STORAGE

- Keep your FLEXXLINE products out of direct sunlight.
Avoid large fluctuations in temperature and high humidity.
- Our products come packaged in such a way that if unopened, they can be stored at room temperature (approx. 20°C and approx. 50% relative humidity).
- Do not place heavy items on top of your FLEXXLINE products.
- The products should be used within 12 months.
After this time, we can no longer guarantee that they will adhere correctly.

3. CLEANING

Carefully clean the application surface with a suitable tool (such as a lint roller) before using the product.

If you use other textile cleaners, please follow the safety instructions of the manufacturer when handling solvents and chemicals. Failure to follow instructions may cause the textile to be damaged by aggressive cleaning agents.

4. HANDLING

- Your FLEXXLINE product only achieves maximum adhesion after approx. 72 hours.
- Observe the expiry date on the packaging.

5. HOW TO APPLY YOUR FLEXXLINE PRODUCT

- Before you begin, make sure you have the following materials on hand:
 1. The textile on which you wish to apply your FLEXXLINE product
 2. Your FLEXXLINE label (important note: there are two protective films still on the label)
 3. The silicone rubber used to protect the structure of the label
 4. A sheet of packing paper for best results
 5. A heat press

- Preparing the heat press:
The usual settings used for heat pressing are:

Heat: 145°C

Leave the press open while it heats up.

Time: 30 seconds

Depending on the model you may be able to set the time on a built-in timer.

Pressure: medium

Depending on the model you may be able to configure this using a hand wheel, scale or a precise setting in bar.

If your press supports precise bar settings, start with 0.3 bar at the beginning. In our tests we used a heat press with a membrane plate. With different models the bar setting may vary. Always follow the machine manufacturer's instructions.

If your press has a scale, choose a setting at the back of the scale range. (For example, with a scale of 1–6, start with 4.)

If your press has a hand wheel for setting the pressure, adjust it to the right pressure so that the press can be closed using medium effort and clicks into place.

(Note: these recommendations are based on our experience during testing. We always recommend performing your own tests to achieve the desired label adhesion.)

- Wait until the heat press has reached the desired temperature.
- Please the textile in the machine.
- Position the FLEXXLINE label on the textile.
Make sure that the label still has both of its protective films.
The silicone paper backing should be removed.
- The silicone rubber can now be placed over the label.
This protects the structure of your label.
- For best results cover the entire label area with a sheet of packing paper.
This reduces the transfer of marks or imprints from the press plate onto your textile.
- Close the heat press for 30 seconds.
Depending on the model you may need to do this by hand or may be able to initiate this by pressing a button.
- Once the set time as expired, open the heat press again.
Depending on the model it may open automatically when the time limit expires.
- We recommend allowing the emblem to cool briefly.
- Both protective films can then be removed from your label.

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The RATHGEBER Group online magazine

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<http://signature.rathgeber.eu/en>



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