

# HOTMARK REVOLUTION

## OVERLAPPING

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Overlap procedure

# Protocole des superpositions

## HOTMARK REVOLUTION\*



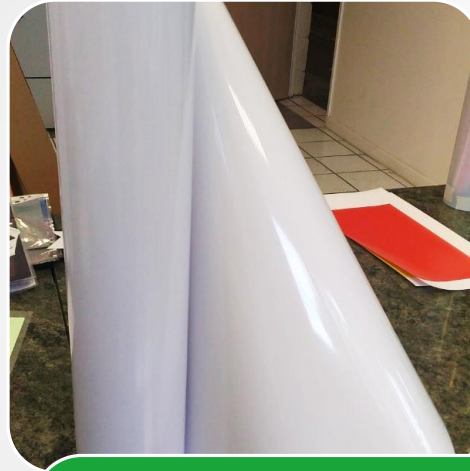
1<sup>st</sup> pressing

140°C

5 s

Hot peel

Medium pressure



2<sup>nd</sup> pressing

140°C

15 s

Peel warm

Medium pressure



3<sup>rd</sup> pressing

140°C

20 s

Medium pressure

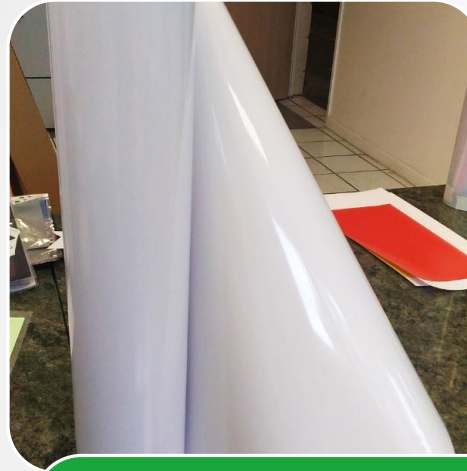
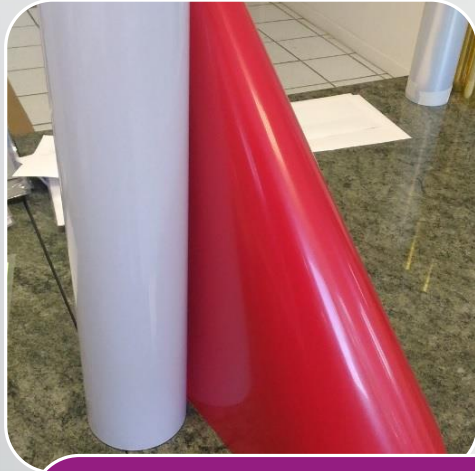
Silicone backed paper

\* Except Black, Red and Fluorescent Yellow (see procedure below)

# Overlap procedure

HOTMARK REVOLUTION BLACK, RED AND FLUO YELLOW

(These 3 colours require extra 10 s pressing)



1<sup>st</sup> pressing

140°C

5 s

Hot peel

Medium pressure

2<sup>nd</sup> pressing

140°C

15 s

Peel warm

Medium pressure

3<sup>rd</sup> pressing

140°C

20 s

Medium pressure

Silicone backed paper

Diagram illustrating the overlap of three rectangles within a 120 mm by 120 mm bounding box. The top two rectangles are 5 mm and 10 mm high, both labeled "Partial overlap". The bottom rectangle is 20 mm high, also labeled "Partial overlap". A central 45 mm by 45 mm area is labeled "Full overlap". A 15 mm gap is shown on the right side.

With a full overlap, the overlapped product does not touch the fabric.

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# Post-wash results

	301 White	303 Black	306 Red
301 White			
302 Gold			
303 Black			
304 Golden Yellow			
305 Orange			
306 Red			
308 Light Blue			
309 Royal Blue			
310 Dark Green			
311 Fluo Yellow			
323 Silver			
324 Grey			
331 Fluo Green			
332 Fluo Pink			

Interpreting the table:

The product along the top row is overlapped on the product in the left column.

Results	
OK	140°C – 20s
OK	140°C – 30s

# CONCLUSION

- Overlaps are validated with 3 pressings at 140°C – 5 s, 15 s, and 20 s – for all colours except black, red and fluorescent.
- Overlaps for black, red and fluorescent yellow are validated with 3 pressings at 140 °C – 5 s, 20 s, and 30 s – at each step.
- Quality assurance is based on validation that complies with ten 40°C wash cycles.





A vous de jouer !