



*Liberty Holdings*



*Hardware*



5308 Irwindale Avenue, Irwindale, CA 91706

### PVC Plastic

#### INK

- \*Plastisol Ink (see below note)
- Plastic Ink

#### DRYER SETTING

- \*Plastisol Ink (see below note) – 275°F cure time
- Plastic Ink – Air Dry

### 600D Polyester

#### INK

- PA series from Nazdar
- \*Plastisol Ink (see below note)

#### DRYER SETTING

- PA series - Air dry for 8 hours.
- \*Plastisol Ink (see below note) - 250°F heat dry 15 seconds + air dry for 15 minutes

#### OTHER RECOMMENDATIONS

- Keep heat under 375°F and keep the heating time less than 30 seconds per press. If more heat is needed, the operator can simply press multiple times

### High Density Neoprene

#### INK

- \*Plastisol Ink (see below note)

#### DRYER SETTING

- Standard 320°F

#### OTHER RECOMMENDATIONS

- Printing with White Poly Ink is recommended to avoid sublimation.

#### Embroidery

- Use a clamp vs. a hoop to avoid leaving any permanent impression.

Liberty Bags is providing the above information as a reference guide only. Actual temperatures, drying times, inks, or other elements of the printing process might vary based on equipment, location, or any other number of factors. Liberty Bags is happy to provide a sample swatch book of our material to run tests on prior to printing and assumes no liability for providing the above information. For a swatch book print sample test kit, please email [libertybags@gl2p.com](mailto:libertybags@gl2p.com).



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### 210 Denier Nylon & 70 Denier Nylon

#### INK

- Nylon Ink

#### DRYER SETTING

- 325°F with a belt speed that allows 15 seconds of drying under the elements

### Heavyweight Polypropylene

#### INK

- \*Plastisol Ink (see below note) such as IC Coatings 900 series. No additives

#### DRYER SETTING

- Black: use 245°F with a belt speed that allows 12-15 seconds of drying under the elements
- All other colors: 285°F with a belt speed that allows 12-15 seconds of drying under the elements.

### Vinyl Transfers

#### HEAT SETTING

- 350°F with one 5 second pass; if needed hit a second time with a 5 second pass.

*\*Temperatures and requirements vary by brand – please contact the manufacturer of the vinyl transfer for more information.*

### Foam Can Holders

#### INK

- PA series from Nazdar
- \*Plastisol Ink (see below note)

#### DRYER SETTING

- PA series - Air dry for 8 hours.
- \*Plastisol Ink (see below note) - 250°F heat dry 15 seconds + air dry for 15 minutes

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[Twill Aprons 70%polyester/30% cotton](#)

#### INK

- \*Plastisol Ink (see below note)

#### DRYER SETTING

- Standard 350°F, 20 seconds dry time

### [General Tips & FAQ](#)

- To prevent the handles from burning, please keep the handles inside the bag.

*\*Plastisol is a suspension of PVC particles in a plasticizer; it flows as a liquid and can be poured into a heated mold. When heated to around 177°Celsius, the plastic and plasticizer mutually dissolve each other. On cooling the mold below 60°C, a flexible, permanently plasticized product will result.*

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