HeatSoft™ ESM-HTM2 – Heat Transfer Material

Inkjet printable heat transfer media for custom, short run apparel and textile applications.

Roland’s heat transfer material, HeatSoft™ ESM-HTM2, is part of the HeatSoft™ Transfer Solution. This product is designed to work in tandem with Roland’s HeatSoft™ PGM-PTM Polyester Transfer Mask. HeatSoft™ ESM-HTM2 is designed to print vividly and cut accurately. The product weeds with ease and provides fine detail results. The HeatSoft™ transfer material will adhere to cotton and poly-blend fabric products.

Product at a Glance
- Ultra thin 1.7 mil thickness
- Sizes available: 24’x50’, 50’x50’
- Shelf Life: 2 Years
- Weeds with ease
- Ink Compatibility: Eco-Sol MAX
- Vivid imaging and colorfast
- Core Diameter: 3”
- Fine detail cutting
- Profiled for Roland VersaWorks

<table>
<thead>
<tr>
<th>Feature</th>
<th>Advantage</th>
<th>Benefit</th>
</tr>
</thead>
<tbody>
<tr>
<td>Washable and fade resistant</td>
<td>Color remains brilliant and colorfast</td>
<td>Durable and long lasting image</td>
</tr>
<tr>
<td>Versatile and easy to use</td>
<td>Prints, cuts, applies with ease</td>
<td>Saves production time</td>
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<tr>
<td>Ultra thin 1.7 mil thickness</td>
<td>Soft hand</td>
<td>Premium results</td>
</tr>
</tbody>
</table>

Applications
- T-shirt, sweatshirt and jacket appliqués
- Sports jerseys names and numbers
- Fabric hats and caps
- Fabric aprons
- Fabric bags and totes

Settings and Product Compatibility
- For use with HeatSoft™ PGM-PTM Polyester Transfer Mask
- Use a clamshell t-shirt heat press
- 275°-370° Fahrenheit (135°-190° Celsius) for duration of 12-15 seconds, using firm pressure
- Compatible with 100% cotton and poly-blend fabrics
- Compatible with Eco-Sol MAX inks

Product Performance Guarantee
This product is sold for the usage and application stated in this document. The product is guaranteed to work with Roland’s PGM-PTM - Polyester Transfer Mask, part numbers PGM-PTM-50-24 and PGM-PTM-50-50. The product will produce a vibrant printed and cut graphic using Roland Eco Sol MAX inks. The graphic will transfer onto a garment to produce a light-weight apparel appliqué with a soft hand. The appliqué can be washed by hand or in a washing machine and dried in clothing dryer*. Testing has shown the product to withstand in excess of 20 washes.

*Wash garments inside out to protect the heat transfer appliqué. Use gentle wash cycle setting in washing machine. To dry the garment: use low heat, tumble setting or hang dry the garment to extend the appliqué’s durability.
Application Instructions - Printing and cutting ESM-HTM2:

**Step 1.** Using a t-shirt (clamshell) heat press, preheat the heat press between 275º-375º Fahrenheit* (135º-190º Celsius) for:
- 100% Cotton
- 50/50 Poly-blend

*Heat temperature may vary according to the fabric's thickness and make-up.

**Use firm pressure.** Set application time to 12-15 seconds (always test fabric and transfer material for compatibility).

**Step 2.** Perform Cut Test from Cut Config menu on your printer/cutter. Set Cut Pressure according to condition of cutting blade and results. Due to the product's thin caliper, using a newer blade will produce the best quality results.

**Step 3.** Set Heat Settings on your printer to 86º-95º Fahrenheit (30º-35º Celsius) – In VersaWorks, use the ESM-HTM2 media profile.

**Step 4.** Allow at least 5-30 minutes for the ink on the printed surface to dry completely. This will make weeding the product easier and ensure optimum transferred results. Drying time is recommended for graphics cut ‘to bleed’.

**NOTE:** For very small objects, use the ‘Dry Time’ feature in VersaWorks. Set the dry time between printing and cutting to 5 minutes for best results.

**Step 5.** Remove all unwanted material excess from the graphic by weeding.

Application Instructions - Applying PGM-PTM Polyester Transfer Mask to ESM-HTM2:

**Step 1.** Apply PGM-PTM Polyester Transfer Mask to the graphic for transferring. Do not overlap pieces. Ensure tape is applied from the center out, without air bubbles.

**Step 2.** Turn the polyester transfer mask face side down onto a sturdy surface. Carefully remove the backing liner at a sharp angle to ensure the heat transfer material does not stretch.

**Step 3.** Position the graphic in the desired location of the garment and press for 12-15 seconds.

**Step 4.** Allow for the graphic to cool down for approximately 3-5 seconds.

**Step 5.** Remove the PGM-PTM Polyester Transfer Mask at a sharp angle to ensure that the graphic is not distorted or stretched in the process.

**Step 6.** The graphic is ready to wear*.

* The garment can be washed by hand or in a washing machine. Use a mild soap, employing delicate garment cycle on washing machine. The garment can be dried in a drying machine using low tumble dry setting. Machine washing and drying will shorten the life of the graphic.

This information is intended as a guide; testing for compatibility with the application garment and durability is strongly recommended.

Storage Conditions

HeatSoft™ ESM-HTM2 Heat Transfer Material should be handled with care to prevent surface contamination that may affect the printable surface of the product. This heat transfer material should be processed and stored in an environment of 60°-80° F (15° - 21° C) and 30-70% relative humidity (non-condensing) that is clean and relatively dust-free. Store this product in its original packaging in a cool dry area until ready for use. If storage conditions are outside the recommended operating ranges allow the material to acclimate to the production environment.

Suggested Items and Accessories:

- Roland 45° ZEC-U5025 Carbide Cutting Blade – Part Number(s): ZEC-U5025
- HeatSoft™ Polyester Transfer Mask – Part Number(s): PGM-PTM-50-50, PGM-PTM-50-24