





transfers-ON-ROLL

Transfers-on-Roll are Transfers applied on a carrier foil. Transfers-on-Roll can be applied onto different materials using a roll application machine. Because of the availability of very long rolls the application of XILION Flat Backs is now easier and faster.

Article Explanation

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Transfers-on-Roll are Transfers comprised of clear or coloured crystals (2028 SS 6 or SS 10) and applied on a carrier foil (max. 15 cm in width and max. 50 m in length). Because of the availability of very long rolls the application of XILION Flat Backs is now easier and faster. This product has been successfully tested and applied on fabric rolls and has been selected for industrial application tests in other segments.

420 003



C	001
E	S6
S	-12x12
M	32 670 PCS

420 003	C	E	S	M
Article number	Colour assortment	Elements	Motif size in mm	Minimum order quantity in pieces (PCS)

Product Name	Transfers-on-Roll
Article number range	420 000 – 429 999 Only special motives
Stone	2028 M HF
Roll width	Three roll widths available: • 5.0 cm • 7.5 cm • 15.0 cm The diameter of the core of the roll is 2 inches (≈ 5.08 cm).
Roll length	Max. 50 m
Minimum stone quantity per 0,5 meters	40 stones
Sample orders – minimum order quantity	Varies between motives ≈ 1 roll (50 m)
Production orders – minimum order quantity	Varies between motives ≈ 10 rolls (500 m)

Ordering Example & Product Variety Explanation

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420 003	001
Article number	Stone colour corresponding to element 1

Ordering Process

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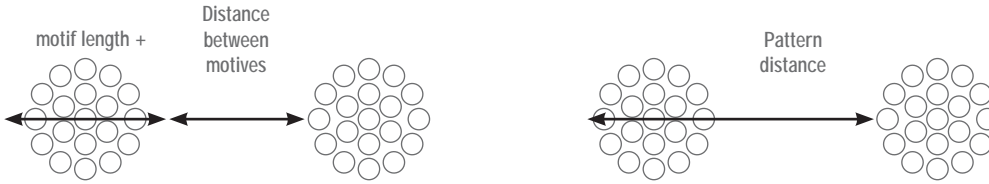
Please send the request with a drawing of the design to a Swarovski sales office near you. Make sure you include all dimensions of the requested motif. You will then receive a quotation including your article number, two different prices and minimum order quantities (for sample orders or production orders) and the drawing of your special motif in PDF format. If any changes/adaptations have to be made, contact the Swarovski sales office where you placed your inquiry. Your special motif will be produced and delivered after the confirmation of your order is received.

Transfers-on-Roll 420 000 – 429 999		Stone Size	SS 6	SS 10
Colour				
Crystal M HF (001)			■	■
Crystal AB M HF (001 AB)			■	■
Crystal Golden Shadow M HF (001 GSHA)			■	■
Crystal Silver Shade M HF (001 SSHA)			■	■
Jet M HF (280)			■	■
Jet Hematite M HF (280 HEM)			■	■
Amethyst M HF (204)			■	■
Aquamarine M HF (202)			■	■
Dark Siam M HF (308)			■	■
Emerald M HF (205)			■	■
Fuchsia M HF (502)			■	■
Light Rose M HF (223)			■	■
Light Topaz M HF (226)			■	■
Montana M HF (207)			■	■
Olivine M HF (228)			■	■
Peridot M HF (214)			■	■
Sapphire M HF (206)			■	■
Silk M HF (391)			■	■
Smoked Topaz M HF (220)			■	■

Conditions of Design

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- No size combination possible within one motif
- Up to two colour combination possible per motif
- Information needed:
 1. **Distance between motives:** the distance between the last stone of one motif to the first stone of the next motif.
 2. **Motif length:** measures of the motif itself.



The motif length and the distance between the motives are the **pattern distance**.

- The max. size of a motif is 18x13 cm
- The distance between motives may be:
 - Min: 0.15 mm
 - Max: 100.00 mm

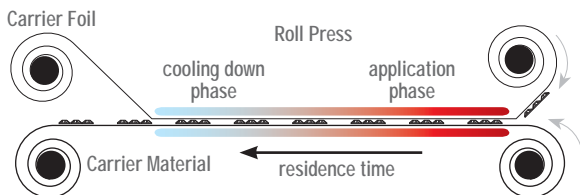
Advice on Application

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Hotfix application

Transfers-on-Roll can be applied using a roll application machine. The following parameters should give you an overview about the possibilities of applying Transfers-on-Roll onto different materials. In order to ensure the right conditions and to establish the best choice of application aids, we strongly recommend carrying out tests with the original materials.

Principle of roll application



For the application of Transfers-on-Roll please choose a residence time which corresponds with the parameters of the Hotfix Selector for XILION Transfers.

The residence time expresses how fast a textile moves through the roll application machine and depends on the length of the press and the chosen speed.

Transfers-on-Roll

	Temperature and approx. time (in seconds)					
	120°C 250°F	130°C 265°F	140°C 285°F	150°C 300°F	160°C 320°F	170°C 340°F
Wool-Trevira	20	17	14	11	8	5
Cotton	15	13	11	9	7	5
Linen	15	13	11	9	7	5
Wool	25	22	19	16	13	10
Viscose	18	15	12	9	7	5
Tulle	13	12	11	9	7	5
Denim	25	23	21	18	15	12
Lycra	25	21	17	13	9	5
Cotton Jersey	15	13	11	9	7	5
Synthetic Suede	35	30	25	18	13	8
Silk	14	13	11	9	7	5
Synthetics	10	9	8	7	6	5
Technical Fabrics	10	9	8	7	6	5
Fake fur	60	50	40	30	20	10

Pressure: Low to medium.

Application side:  The front and reverse side of the fabric should always face the heated surface of the ironing press.

Ironing aid: Silicone foam or silicone pad should be used to compensate for any variation in height.








Speed: 1 – 2 m/min; depending on the temperature used and length of the press.

Distance between press rolls: Depends on the thickness of the carrier material, crystal height and application aid.

For more detailed information e.g. about suppliers of suitable machines please refer to our Application Manual and our Business Website WWW.SWAROVSKI-ELEMENTS.COM/BUSINESS.

Any oral, written or test-based advice that Swarovski provides regarding techniques for application of its products are recommendations based on Swarovski's current knowledge and the information provided by its suppliers. Such advice does not discharge customer from carrying out its own tests of techniques it proposes to use and their suitability for the intended application. The application, use and processing of these techniques and products are solely user's responsibility.

Care Instructions:

							
General Recommendations	Turn inside out, choose a gentle washing programme and use a mild laundry detergent.	Do not use chlorine bleach!	Turn inside out and dry at reduced temperature.	Turn inside out and use the iron setting for wool.	The textile can be gently dry-cleaned using perchloroethylene. Turn inside.	The textile can be gently dry-cleaned using hydrocarbon. Turn inside out.	The textile will withstand gentle professional wet-cleaning. Turn inside out.
Transfers-on-Roll	✓ Use of a soft wash bag to best protect the crystals.	✓	✓ Use a soft wash bag to best protect the crystals.	✓ Please note that the glue may be reactivated if the textile is ironed too long.	✓ Use of a soft wash bag to best protect the crystals.	✓ Use of a soft wash bag to best protect the crystals.	✓ Use of a soft wash bag to best protect the crystals.

Failure to follow Swarovski's care instructions may result in damage to the crystal, which could pose a risk of laceration or other harm.

Photography: Christoph Sagel, Robert Striegl
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