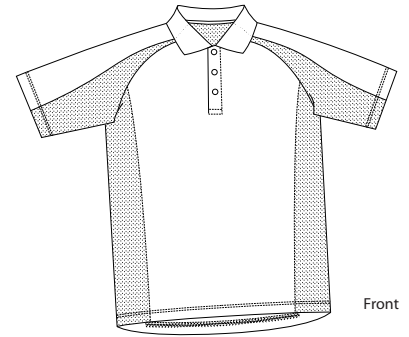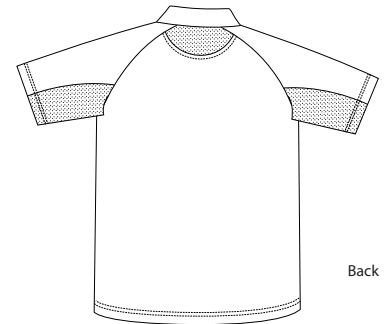# Dri-Mesh Pro Sport Shirt

Sport-Tek
By Port Authority®

Front

Back

T474

* 3.9-ounce mini pique body fabric * 3-button placket * Dyed-to-match buttons
* 95/5 poly/spandex stretch mesh panels and locker patch * Tagless

Finished Measurements in Inches

Size	XS	S	M	L	XL	2XL	3XL	4XL
Chest	17.5	19.5	21.5	23.5	25.5	27.5	29.5	31.5
Body	28	29	31	33	34	35	36	37
Sleeve	8	8.5	9	9.5	10	10.5	11	11.5

Chest width measured 1" below arm hole. Body length measured from high point shoulder seam to hem.
Sleeve length measured from shoulder seam to hem.

Colors

Maroon
Steel
Sandstone
Navy
Dark Green
Black

Please Note:
Colors shown are approximate and for reference
only. For closest match see PMS colors, or for
exact match, returnable samples and grommeted
samples are available

Due to the nature of performance fabrics, special
care must be taken when printing and drying.

Color Chart

Base Colors	Maroon	Steel	Sandstone	Navy	Dark Green	Black
Textile PMS	19-1621 TC	11-0000 TC	14-0108 TC	19-4019 TC	19-5408 TC	19-4305 TC
General PMS	5185 C	Cool Gray 10	7535 C	532 C	445 C	Process Black

Dri Mesh® Pro Sport Shirt

Sport-Tek By Port Authority®

Dri-mesh Screen Printing Recommendation

<u>Factors during printing:</u>

Heat Absorption: Polyester will naturally attract more heat than a natural fiber such as cotton. When high heat is applied to polyester; like other types of polymers (such as plastics) it will reach a melting point.

Garment Color: The garment color is a factor to consider when printing. Darker colors such as Black, Dk. Green, Maroon, Navy, Red & Steel will experience higher shrinkage. It is especially important to test these colors before printing the entire run. Black will always have the highest shrinkage rate.

Outside Temperature: If you are printing in a warmer climate, we recommend you take into account the outside temperature. This will increase the temperature during printing as well as when the garment passes through the dryer.

<u>Printing Steps:</u>

Test Sample: It's recommended to run a test garment (in a dark color) before printing the entire run of garments. This will allow you to gauge the temperature of the imprint as it passes through the dryer.
Note: Black will always attract & retain the highest amount of heat during drying.

Ink Type: Dri-mesh fabric is stretchy due to the construction, so it is recommended to use a plastisol additive or an ink specifically used for full synthetic fabrics. The printed surface will be less likely to crack and the imprint will stretch with the fabric.

Ink Application: We recommend a 2-stroke application of ink per color process. Flash in between colors for no more than 10 – 15 seconds. Keep in mind; the heavier the ink coverage applied the greater chance of puckering around the printed area. Excessive ink coverage will attract more heat during the drying process.

Printing Surface: If your print surface is metal/aluminum and you have been printing all day; the surface will get hot. Factors like outside temperature and ventilation through the print facility may also make the print surface hotter. If this is a factor you contend with, we recommend running a fan on the opposite side of the flash board.

Dryer Temperature: We recommend the dryer temperature to be set between 290 – 300 degrees Fahrenheit depending on the outside temperature in your area. Remember the polyester will attract more heat as it passes through the dryer.

Print Cure Temperature: If the dryer temperature is set between 290 – 300 degrees Fahrenheit, the imprinted surface will cure between 305 – 320 degrees. Keep in mind, the darker the garment color & imprint, the more heat the garment will attract. Adjust your dryer accordingly.

Drying Time: We recommend the fabric be exposed to the dryer for no more than 75 seconds.

Heat Gun: To gauge the heat of the garment and imprint area as it passes through the dryer; a heat gun will assist greatly in gauging the temperature. Extech Instrumental sells a gun starting at $100.

Q & A:

Q: How do I know the garment has been flashed too long?

A: If you are performing a 2+ color process, you may notice a shadow or an overlapping of the ink with the next color application. This is an indication the garment is shrinking under the direct heat of the flash area. Shorten the garments exposure to no more than 10 – 15 seconds and let it sit for at least 45 seconds before the next application.

Q: How do I know my drying temperature is too high?

A: You may notice puckering around the imprint area as well as along the seams of the garment. Using a heat gun is the best way to make sure the garment is not coming out of the dryer too hot.

Q: How do I know the ink application is too heavy or too light?

A: You may notice on your test sample puckering around the imprint area if the application is too heavy. Again, the ink will attract more heat than the garment itself. You want to apply enough ink to prevent the garment color from showing through the imprint.

Q: I only have 1 dryer to print cotton & polyester garments together:

A: Screening on cotton may require a higher temperature for curing. If you have 1 dryer to do both, set aside the polyester garments until you have some free space to run once the dryer has cooled to the correct temperature. Make sure the staging area is clean and free of contaminants until ready.