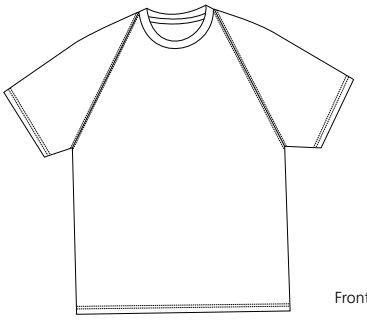
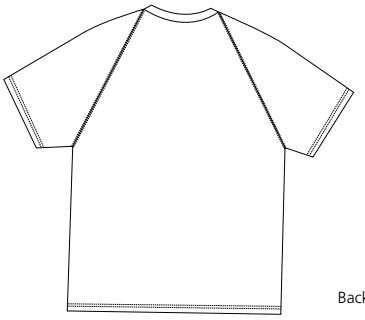
Raglan Sleeve T-Shirt with Wicking
and Anti-Microbial Treatments

Sport-Tek By Port Authority





T473

* 100% polyester * Short sleeve raglan sleeves
* Double-needle sleeve and bottom hem

Care Instructions:
Machine wash cold on gentle cycle.
Do not bleach. Cool iron if necessary.
Do not dry clean. Wash and dry with like colors.

Finished Measurements in Inches

Size	XS	S	M	L	XL	2XL	3XL	4XL
Width	18.5	20	21	23	25	26.5	28	29.5
Length	27	28	29	30	31	32	33	34
Sleeve	17.5	18	18.5	19.5	20.5	21.5	22.5	23.5
Neck	6.25	6.5	6.75	7	7.25	7.50	7.75	8

Chest width measured 1" below armhole. Body length measured from high point shoulder to hem.
Sleeve length measured from center back to hem. Neck width measured seam to seam.

Color Chart

Colors	Black	Silver	True Navy	True Red	True Royal	White
Textile PMS	19-5320TC	14-4002 TC	19-4025TC	19-1761TC	18-3949TC	11-0601TC
General PMS	Process Black	435C	533C	201C	2728C	No Match
Colors	Forest Green	Gold	Kelly Green	Maroon	Purple	
Textile PMS	No Match	No Match	No Match	No Match	No Match	
General PMS	560C	No Match	No Match	No Match	No Match	

Colors

- Black
- Silver
- True Navy
- True Red
- True Royal
- White
- Forest Green
- Gold
- Kelly Green
- Maroon
- Purple

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

Dri Mesh® Short Sleeve T-Shirt

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Dri-mesh Screen Printing Recommendation

Factors during printing:

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.

Printing Steps:

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.