



**van Heek** textiles

## **Foil stamping advice**

Coated substrates are generally more receptive to foil stamping than uncoated “dry” materials.

Substrates which are smoother or have a shallow, open texture or pattern are easier to foil than those with deep, dense texture or pattern.

More heat and pressure will increase the degree of foil transfer, which can help to fill texture or pattern, but can also lead to excess foil on image areas and could cause offsetting.

### **Stamping die:**

Copper and brass recommended as they are relatively hard and long lasting.  
Magnesium is much cheaper but is soft and can be easily damaged.

**L. van Heek Textiles recommends the following foils for our textile cover materials:**



**Luxor Alufin AS:** gold, silver for our coated products

Stamping Temperatures

100 - 110 °C (212 - 230 °F) e.g. on Kolbus Machines

**Luxor Alufin AB:** gold, silver for our natural cloths

Stamping Temperatures

100 - 105 °C (212 - 221 °F) for example on Kolbus machines

**Colorit VB:** matte pigment, for both coated as natural cloth

Stamping Temperatures

approx. 120 °C / 248 °F for up-down stamping

approx. 150 - 170 °C / 302 - 338 °F for cylinder stamping



**AV series**– A metallic foil designed for PVC coated substrates, real and imitation leathers, coarse, grained and woven materials.

**MH series** – A metallic foil for most rough, uncoated and textured substrates  
Recommended temperature range for most standard metallic hot stamping foils being typically 100°C - 140°C

**PG or UA:** matte pigment, for both coated as natural cloth  
Stamping Temperatures

**UA in white and black only:** approx. 80 - 170 °C / 302 - 338 °F Dependent on machine type and application parameters

**PG:** approx. 100°C – 150°C with activation at 85°C and recommended top temperature 170°C, Dependent on machine type and application parameters



**MN** metallic colours. Specifically designed for embossed, rough or dry substrates. Maintaining a high standard of brightness on these difficult applications. Available in all colours of the spectrum in both gloss & satin finishes.

**NX and HMD** pigment colours. A large range of pigment foils should always be considered when printing on dry or textured substrates.

For both: the foils run at between 85-130°C. If the pigments (NX and HMD grades) are run too hot, they will flood and close in the small letters of the print, so please take your artwork in mind. But both foils are capable of detail printing. In general more texture foiling needs more pressure. Lasher print area (panel) needs a higher temperature.

*Please note temperature and pressure can vary.*