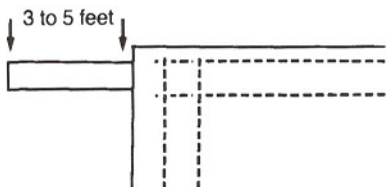


# BANTEX® BANNER FABRICATION GUIDE

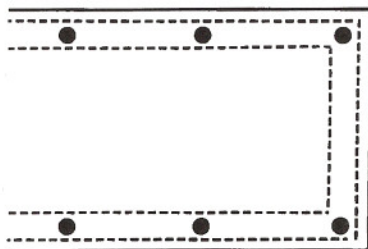
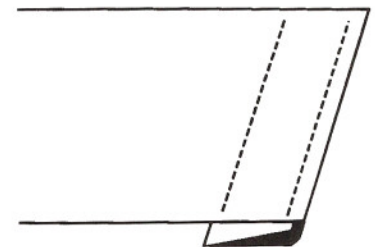
Bantex® banner fabrics are engineered to withstand the harshest of conditions. However, proper fabrication is the key to determining the longevity of the banner. Under equal conditions, a well-fabricated banner will outlast a poorly fabricated one even if stronger materials are used. The following fabrication recommendations make a Bantex banner stronger and more durable to insure greater customer satisfaction.

## Extended Webbing



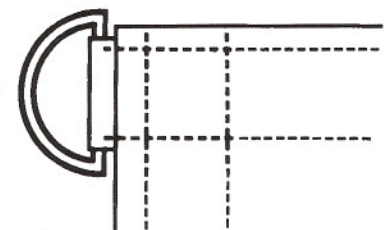
▶ **Reinforce hems** with one inch 2400 lb. webbing. Webbing will make the hem stronger by improving the "grip" of the stitches to the fabric. Also, it allows for hanging the banner in two ways.

▶ **Double Stitch Hems** – Use at least 3 plies of fabric, a fully turned hem and no more than 5-6 stitches per inch (or 25 millimeters). Single stitching should be at least 1/2" from the raw edge. NOTE: Too many stitches per inch can perforate and weaken the banner.



▶ **Grommet and Fasteners** – Spur-toothed, rolled-rim grommets are recommended. Washer-type grommets have a tendency to slide on the fabric and pull out. Insert grommets every one to two feet along edges of the banner and mount between stitch lines of the hem, leaving at least 1/8" inch (1/3 centimeter) from the grommet edges to the stitch line.

▶ **Hanging the Banner** – Extend the webbing several feet to facilitate tie-down or fabricate "D" rings into the corners. The use of "D" rings results in a stronger, neater banner which lays flatter and facilitates neater painting.



▶ **Across the Street Banners** – Do not make the banner wider than the widest width of material available.

▶ **Banners must be hung tight and secure to insure proper life.**



# HERCULITE®

## GRAPHIC PRODUCTS

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# PROCEDURES TO FOLLOW FOR BANTEX® BANNER FABRICS

## ▶ **BANNER PREPARATION:**

- Keep Bantex® flexible vinyl-laminated banner fabric stock current. The softening agent in vinyl called plasticizer naturally migrates to the print surface over time. Plasticizer will interfere with ink adhesion.
- Store Bantex fabrics in a cool area away from direct heat sources. Plasticizer migration is accelerated by prolonged exposure to heat.
- Do not allow fabric to collect dust, dirt or contaminants in sheeting or preparation process.
- Wipe down fabric surface with isopropyl alcohol before decorating one-of-a-kind banners.

## ▶ **BANNER INK SUGGESTIONS:**

- Pretest inks or paints for adhesion before decorating by using Herculite Test Method 6.3 for ink and paint receptivity. (See Herculite Test Method 6.3).
- Follow ink manufacturer's guidelines for specific inks and procedures for decorating flexible vinyl substrates.
- Use only thinners and retarders produced by ink manufacturer.

## ▶ **BANNER SCREEN PRINTING GUIDELINES:**

- Use highest mesh count screen practical for decorating to reduce total ink mass.
- Allow at least 24 hours drying time before screening over inked areas when using solvent based inks.
- Use slip sheets when stacking or rolling printed Bantex banner fabric ink to ink... either two-sided print or full bleed, turned hem single-side printing. Ink will block when stored, stacked or rolled without slip sheeting.
- Two-sided printing has limitations to amount of ink applied on both sides. Full coverage printed both sides may have a tendency to re-wet as solvents remain entrapped.
- Use Bantex Universal fabrics whenever ink adhesion or long storage times are a factor. Bantex Universal fabrics have a top coating to ensure maximum performance.

## ▶ **BANNER FABRICATION:**

- Sew a fully turned hem stitching through three pieces of fabric.
- Stitches should be at least 1/2 inch (or 13 millimeters) from the raw edge.
- Use no more than six stitches per inch (or 25 millimeters). Too many stitches per inch will perforate and weaken the fabric.
- Sew rope or webbing into top or bottom of banner which allows banner to be tied down properly.
- Mount grommets every 18 inches (46 centimeters) along the edge but between stitch lines of the banner.
- Use spur-toothed, rolled rim grommets. (See Bantex Banner Fabrication Guide).

## ▶ **BANNER INSTALLATION:**

- Fasten securely at all four corners and at grommet points to prevent wind flapping. Wind-whip can cause a banner to self-destruct.
- Assure banner is installed with sufficient tension to maintain a taut condition.

## ▶ **DISCLAIMER:**

*Herculite Products, Inc. cannot be responsible for poorly fabricated or installed Bantex banners. It is the responsibility of the banner manufacturer to choose the proper Bantex fabric for a given application and to use tested and proven fabrication and installation methods. Also, it is the printer's responsibility to pre-test each lot of ink and fabric to be used in production for compatibility prior to engaging in a production run. Herculite Products, Inc. will accept any returned, unused Bantex roll goods (within 90 days of shipment) for credit which is found to be unacceptable for decorating after pre-testing inks or paints per above. Herculite Products, Inc. cannot be responsible for any costs incurred by customers decorating Bantex fabrics improperly or without prior testing for ink or paint compatibility.*



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