DTF Film, Ink and Powder: Which One and What Settings

Choosing film, ink and powder, plus the dry, press and peel numbers DuPont publishes.

Choose	What the maker publishes	Source
Film	DuPont Artistri DTF-120: 600 mm x 100 m (24 in x 328 ft) rolls, 2 rolls per box; hot or cold peel; for cotton, polyester, blends and other DTF substrates. CobraFlex film: 24 in x 328 ft hot-peel roll; the CobraFlex SDS covers all CobraFlex DTF films.	DuPont DTF-120 data sheet; our CobraFlex film pages
Ink	DuPont Artistri P1600: aqueous pigment ink for DTF. Cyan P1610, Magenta P1620, Yellow P1630, Black P1640, White P1690, Orange P1660, Green P1675. Fits Epson DX4, DX5, DX7 and i3200 printheads.	DuPont P1600 data sheet
Powder	DuPont: powder choice sets wash fastness and hand. Cover the whole image or that part will wash poorly. Shake off excess, especially on unprinted film, or you get a halo and a stiff image.	DuPont DTF-120 data sheet

DuPont process numbers

Step	Number from DuPont	If it goes wrong
Powder on a platen printer	Dispense powder within 30 seconds of printing. Ink must be tacky, not wet.	Too wet: powder clumps and laminates unevenly.
Dry / melt the powder (oven)	3 to 5 minutes at 135-160C (275-320F). Longer times at lower temperatures also work.	Roll-to-roll printers do this inline: follow the printer maker.
Press	8 to 15 seconds at 150-170C (302-338F), medium to high pressure.	Image not fully transferred: not enough white ink, white dried too much, or press time/temperature needs a change.
Peel	Hot peel (right off the press) or cold peel (cooled to room temperature).	Match the film: DTF-120 does both.
Film storage	5-35C (41-95F) and 45-65% humidity; use soon after opening the bag.	-
Ink storage	10-40C (50-104F).	-

Settings above are DuPont's for Artistri DTF-120 film and P1600 ink. For CobraFlex film, ink or powder, settings: see the maker's guide. The CobraFlex film SDS is a safety sheet only and lists no press settings. Ask us at 480-229-7806.

Sources: DuPont Artistri P1600 and DTF-120 product data sheets (2025-2026); CobraFlex DTF film SDS No. 262690106250 (2026-02-05); bucketsofink.com DTF pages. All data sheets: bucketsofink.com/page/safety-data-sheets. Reference only.