

MACHINERY MANUFACTURER


**Zimmer**  
AUSTRIA



PIONNERING INNOVATIONS  
150 YEARS

# COLARIS technical textiles

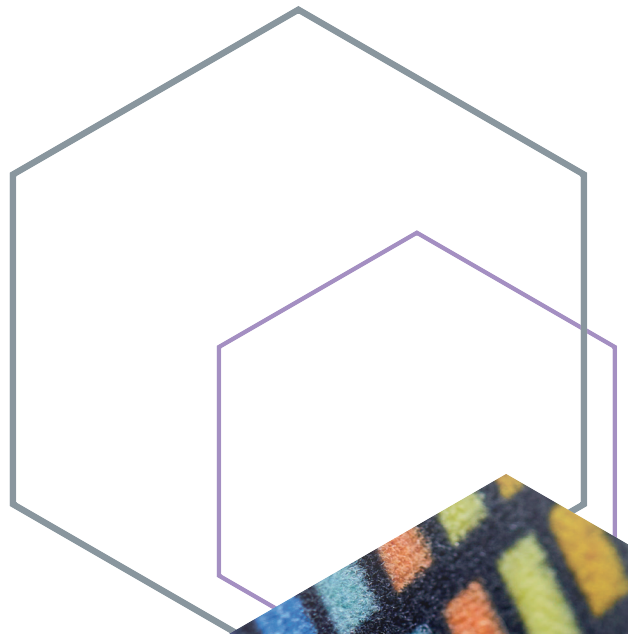
DIGITAL PRINTING SYSTEMS

 04/2024

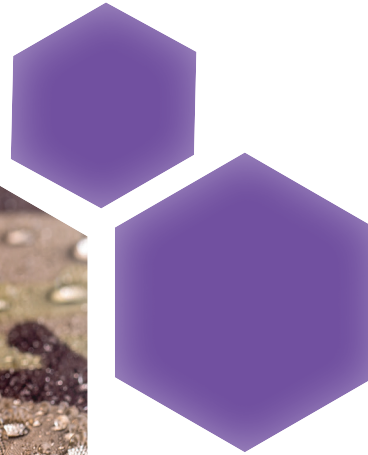


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## highlights

- ◆ digital workflow from design through output
- ◆ open ink system allows free selection from certified ink suppliers
- ◆ permanent ink circulation system for efficient production
- ◆ automatic printhead cleaning system
- ◆ printhead re-condition center for extended printhead service life
- ◆ modular concept for wet-on-dry offline or wet-on-wet inline print production
- ◆ environmentally-friendly, sustainable process





# milestones



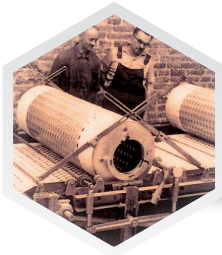
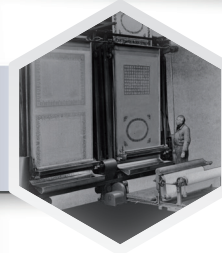
1874

QUALITY SINCE 1874

Factory Franz Zimmer's Erben KG Warndorf

Start of ZIMMER AUSTRIA -  
first duplex blanket printing machine

1951



1955

RSD rotary screen printer

CHROMOJET digital carpet printer

1976



2008

COLARIS digital inkjet printer for textile

COLARIS -NF  
narrow single-pass printer for webbings

2012

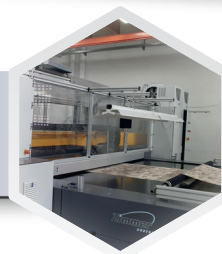


2021

COLARIS  
transport fabric printer

COLARIS digital camouflage printing system

2022





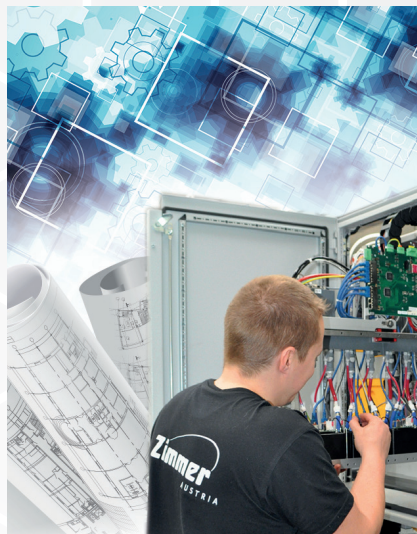
# decision guidance

1. Which fiber, size or target market do you seek for and what's your fastness requirement?
2. Do you have equipment available, which you would like to integrate into a new print line?
3. Is there a specific ink supplier you wish to work with? Will you require technical and technological support from the ink supplier?
4. Is your plant and the environment prepared for a fully digital workflow? Industrial production requires process stability.
5. Which software is most suitable for your business and how do you convert the design into a printable color?
6. How do you define, measure and communicate the colors internally and with the customer? Do you have a measuring system such as spectro-photometer?
7. Which requirements or skills are needed to operate a digital print line at a given capacity, regarding to the utilities or the operator?



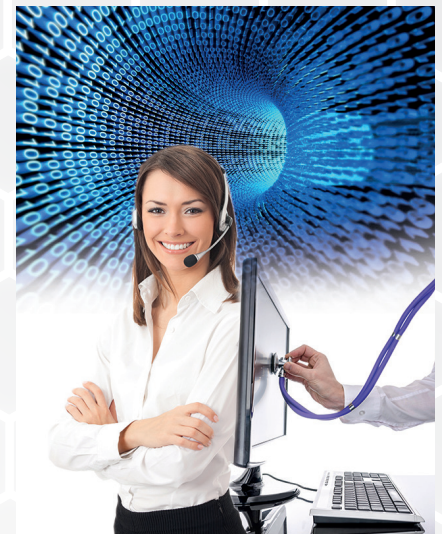
## R&D SUPPORT

APPLICATION  
TECHNOLOGY



## MACHINERY

ENGINEERING &  
MANUFACTURING



## SERVICE

SOFTWARE &  
TECHNICAL SUPPORT



# concept

Technical Textiles cover a wide range of fabrics, made of various fibers and blends. These Fabrics are mostly used under severe environmental conditions and require highest fastness levels.

The wide range of end products covers textiles for indoor use such as furnishing for contract business or different variants of sun blinds. Workwear and protective clothing are another group of products, as well as outdoor fabrics such as canopies and tent fabrics, parasols and awnings or furnishing fabrics for camping use.

High end furnishing fabrics for public transport systems such as buses, subways, trains, cable cars, aeronautic and marine needs are another challenge to deal with. Last but not least the needs for printed military fabrics with specific infrared reflectance control can be matched with ZIMMER AUSTRIA Digital Inkjet Printing Systems.





## APPLICATIONS

- ◆ workwear
- ◆ military camouflage
- ◆ transport fabrics
- ◆ outdoor fabrics
- ◆ advertising fabrics



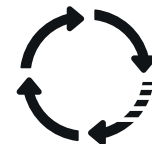
### FIBERS AND CONSTRUCTIONS

- ◆ cellulosic fibers
- ◆ polyamide, Aramid
- ◆ cationic polyester & acrylic
- ◆ polyester
- ◆ any kind of blends



### DYE FAMILIES

- ◆ reactive, VAT or pigment
- ◆ acid or pigment
- ◆ cationic or pigment
- ◆ disperse or sublimation
- ◆ pigment



### PRINT PROCESS

Depending on the applied ink class, different print processes are required. Processing can be done as a wet-on-wet inline process or in multiple offline processes.

# ink classes

**THE INK SELECTION DEPENDS ON FIBER AND FINAL APPLICATION.**



## REACTIVE

cellulosic, protein based, and polyamide fibers

light fastness	+
wash fastness	+++
crock fastness	++
chlorine fastness	+
brilliance	++

.....

### PROCESS REQUIREMENTS

- pre-treatment
- printing, drying
- steaming
- washing
- drying

.....

**END PRODUCTS**  
home furnishing  
decorative fabrics  
terry towels

## ACID | METAL COMPLEX

polyamide, wool, Aramid

light fastness	++
wash fastness	++
crock fastness	++
chlorine fastness	+
brilliance	++

.....

### PROCESS REQUIREMENTS

- pre-treatment
- printing, drying
- steaming
- washing
- drying

.....

**END PRODUCTS**  
home furnishing  
transport fabrics  
military applications

## VAT

cellulosic, polyamide, Aramid

light fastness	++
wash fastness	+++
crock fastness	++
chlorine fastness	+
brilliance	+++

.....

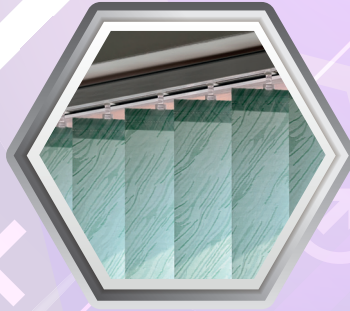
### PROCESS REQUIREMENTS

- pre-treatment
- printing, drying
- steaming - oxidizing
- washing
- drying

.....

**END PRODUCTS**  
furnishing  
workwear, uniforms  
military fabrics  
institutional fabrics





**DISPERSE | SUBLIMATION**

polyester

light fastness	+++
wash fastness	++
crock fastness	++
chlorine fastness	+
brilliance	++

.....

**PROCESS REQUIREMENTS**

- pre-treatment
- printing, drying
- dye fixation
- reductive washing
- drying

.....

**END PRODUCTS**

advertisement  
outdoor fabrics  
home furnishing

**PIGMENT**

any kind of fibers

light fastness	++
wash fastness	++
crock fastness	+
chlorine fastness	+
brilliance	+++

.....

**PROCESS REQUIREMENTS**

- pre-treatment
- printing, drying
- (post-treatment)
- polymerization

.....

**END PRODUCTS**

indoor or outdoor fabrics  
with high light fastness  
requirement

**FUNCTIONAL INKS**

any kind of fibers

light fastness	n.ch.
wash fastness	n.ch.
crock fastness	n.ch.
chlorine fastness	n.ch.
brilliance	n.ch.

n.ch. = no change

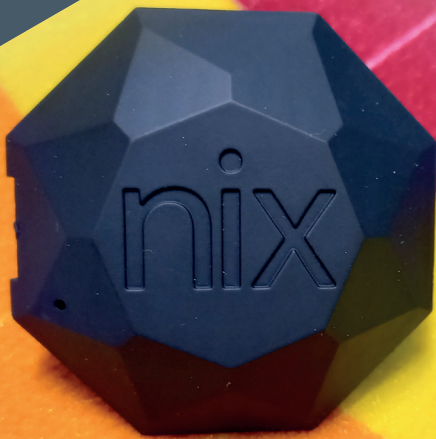
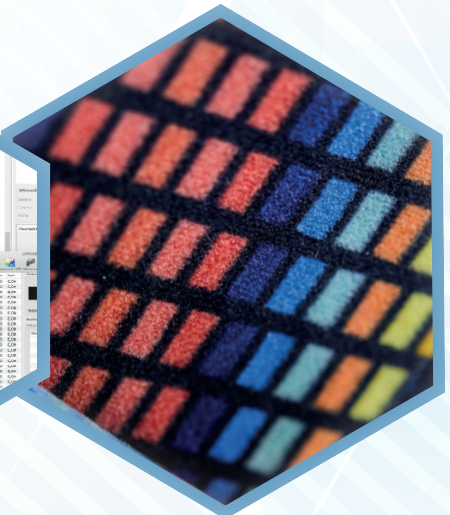
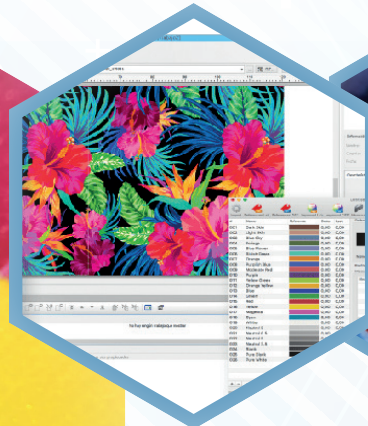
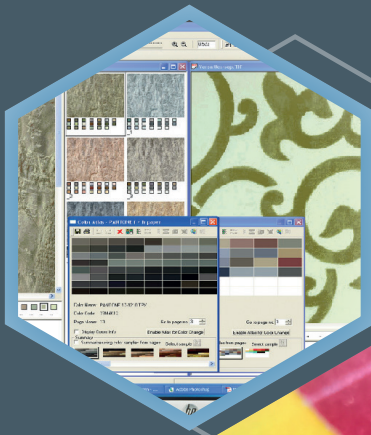
.....

Some substrates or end-products need addition of functional inks. This may be a special carbon black for IR-reflectance control on military fabrics. Other functional inks may be penetration boosters, conductive inks or special inks for hydrophilic or hydrophobic finishing.

# pre-print process

Digital printing is a complex task for which the entire workflow has to match. From design, color management and communication up to printer calibration - all must be perfect for a superb result.

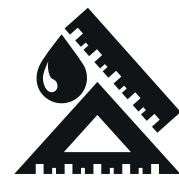
Essential tools are fast computers with fast networks, a lot of memory space and well trained operators.



## PRINTER CALIBRATION

Basic process setup and print resolution must be defined and stable before a calibration is made.

Calibration is a software supported process made in several steps (linearization, printing and measuring targets, generating of printer and ICC profiles).

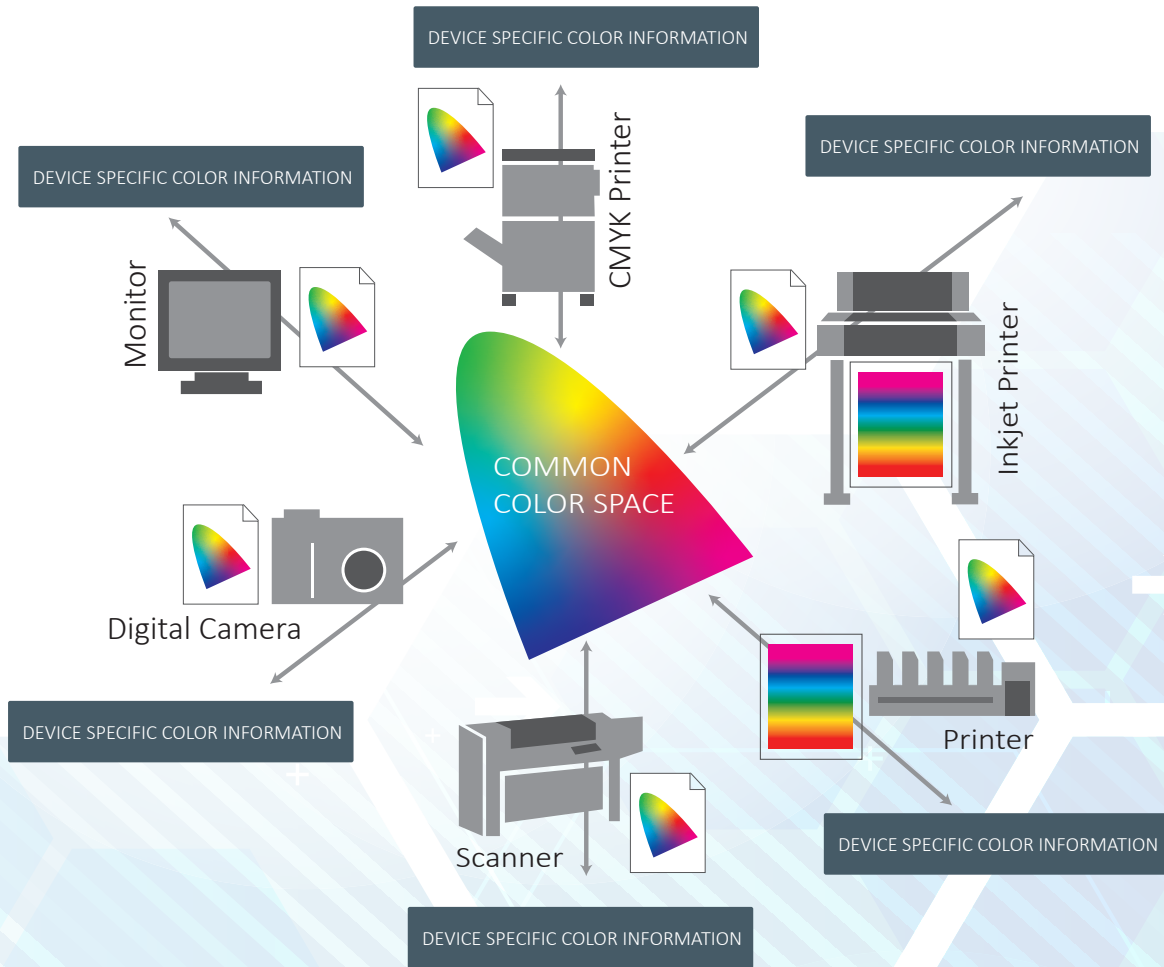


## COLOR MEASUREMENT

Digital printing needs digital information to communicate. Color measurement is essential. Different measuring devices can be used - depending on substrate and surface.

Color is normally communicated within the L\*a\*b color-system.





## COLOR CALIBRATION

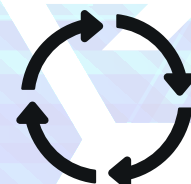
Color calibration is needed to communicate and match colors. This makes sure that colors appear identical on different devices and printers.

A re-calibration is normally needed if a major parameter (base material, ink, fixation process, ...) is changed within the total process.



## DESIGN SOFTWARE

There are a number of pixel- or vector- based software tools on the market: Photoshop®, Gimp®, Nedgraphics®, Illustrator®, Corel Draw®...



## RIP PROCESS

During the RIP process the color information from the art-work file is transformed and split into channels. For each process color (ink) one channel is used.

# workwear

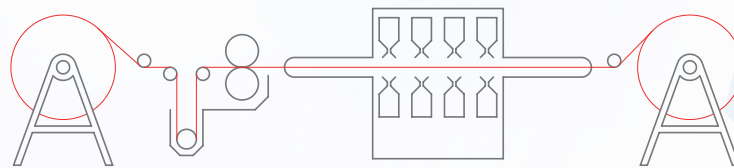


VAT printing is known for unsurpassed fastness properties on any kind of cellulosic and regenerated cellulose fibers. Prints with VAT dyes easily withstand natural UV light exposure, boil washing and even resist chlorine bleach to a great extent.

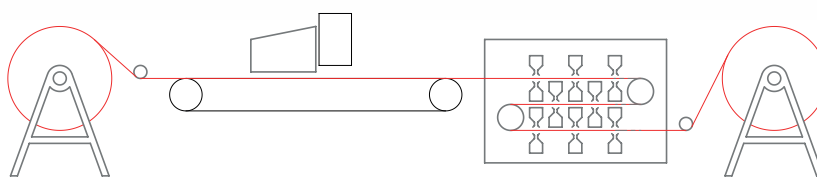
VAT printing is more complex compared to other direct-to-fabric printing solutions, but the achieved properties of end products are paying well for the additional steps in processing.



**1**



**OFFLINE INKJET PRE-TREATMENT:**  
padder application followed by stenter drying is required for wet-on-dry print process



**OFFLINE DIGITAL PRINTING:**  
printing on ready for inkjet prepared fabric followed by infrared- or hot air drying

**2**





**TECHNICAL DATA**

**working widths:**  
2200 | 2600 | 3400 mm

**print substrates:**  
woven, nonwoven,  
knitted fabrics

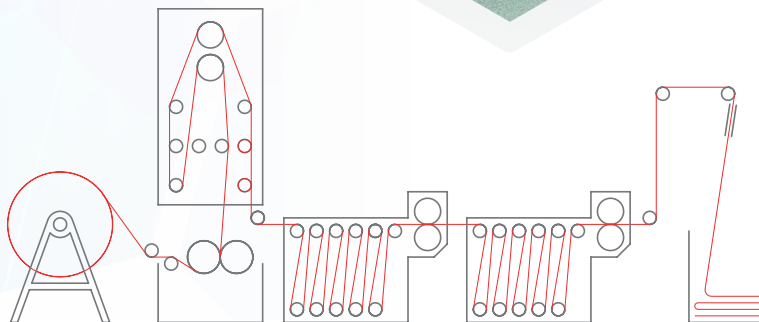
**color groups:**  
up to 12

**ink class per printer:**  
1 ink class at up to 12 colors  
2 ink classes at up to 6 colors  
3 ink classes at max. 4 colors

**number of printheads:**  
up to 8 per color group, or 16 per  
color, max. 96 possible

**production capacity:**  
from 60 to 1100 m<sup>2</sup>/h

Due to their high performance VAT prints are ideal for heavy duty environments and are also used for clothing in the security and special forces segment incl. camouflage fabrics.

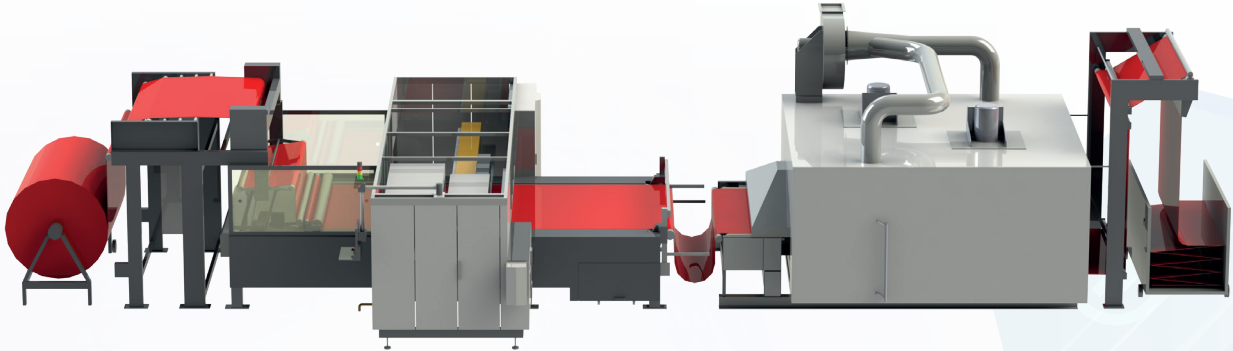


**OFFLINE POST-PRINT PROCESSING:**

padding, steam fixation, oxidizing, washing

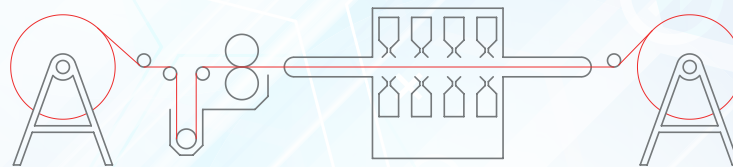
After printing and drying the substrate needs to undergo a padding process where a reducing agent is applied to solubilize the dye. Through a steam fixation the dye develops on the substrate and is permanently fixed by undergoing an oxidation process after leaving the steamer.

# military camouflage

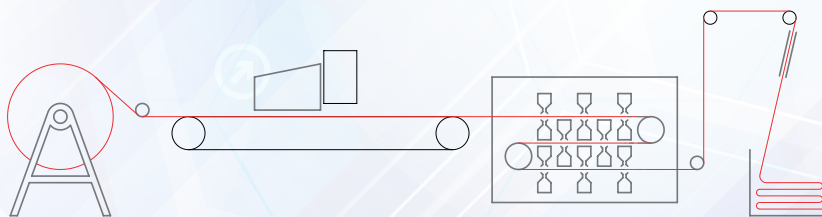


Military camouflage fabrics have to fulfill a wide range of protection needs. Accordingly, a great variety of fiber bases are used. From cotton, re-generated cellulose fibers, polyamide, Aramid™, Kermel™ Nomex™, Conex™, Kevlar™ Twaron™, LENZING™ Lycell and Modal, LENZING™ FR, polyester and their blends are well known for their specific properties. Products may include uniforms, bullet-proof vests, rain protection, ponchos, tents, carrying systems, sleeping bags, nettings, webbings or hook and loop quick-fix-and-release products, etc. All these products need camouflage with IR-reflection control and this is what ZIMMER AUSTRIA Digital Printing Systems can offer now. COLARIS Digital Prints with IR-reflectance control, perfectly match requirements of military and paramilitary forces around the globe. Camouflage printing is not about existing patterns being reproduced digitally from traditional screen printing – digital camouflage printing can offer so much more.

**1**



**OFFLINE INKJET PRE-TREATMENT:**  
padding application followed by stenter drying  
is required for wet-on-dry print process



**OFFLINE DIGITAL PRINTING:**  
printing and drying on ready for inkjet print fabric

**2**



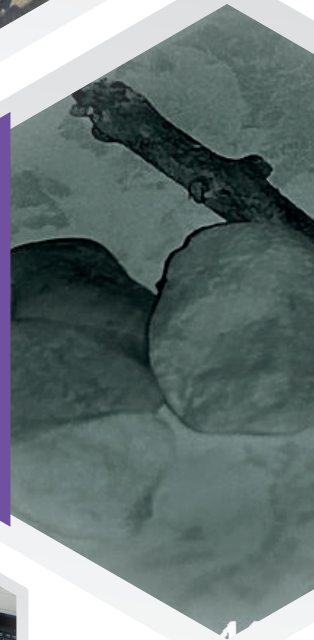
print seen at daylight



with IRR Control



without IRR Control



### TECHNICAL DATA

**working widths:**  
2200 | 2600 | 3400 mm

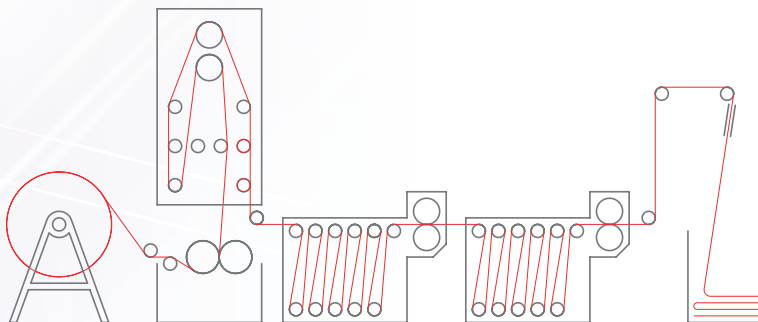
**print substrates:**  
woven, nonwoven,  
knitted fabrics

**color groups:**  
up to 12

**ink class per printer:**  
1 ink class at up to 12 colors  
2 ink classes at up to 6 colors  
3 ink classes at max. 4 colors

**number of printheads:**  
up to 8 per color group, or 16 per  
color, max. 96 possible

**production capacity:**  
from 60 to 1100 m<sup>2</sup>/h



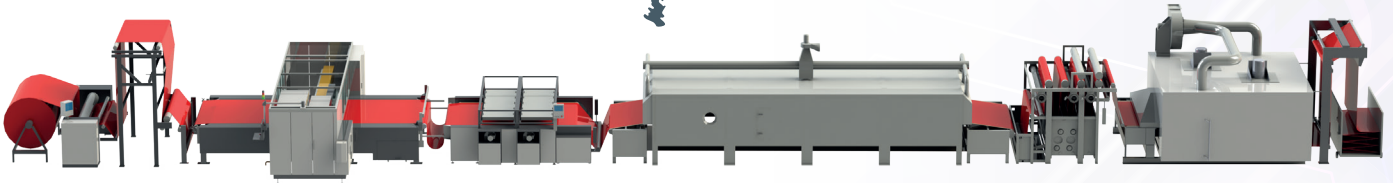
### OFFLINE POST-PRINT PROCESSING:

padding, steam fixation, oxidizing, washing

After printing and drying the substrate needs to undergo a padding process where a reducing agent is applied to solubilize the dye. Through a steam fixation the dye develops on the substrate and is permanently fixed by undergoing an oxidation process after leaving the steamer.

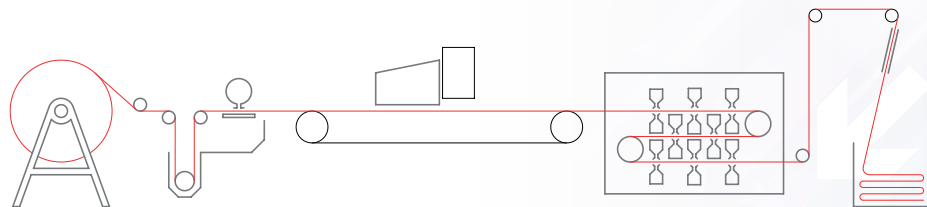
3

# transport fabrics

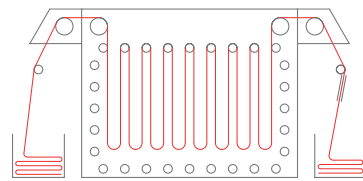


ACID print lines are more complex than a simple print and dry process. Most important criteria for velour or loop fabric are penetration and sharpness of the print.

**1**



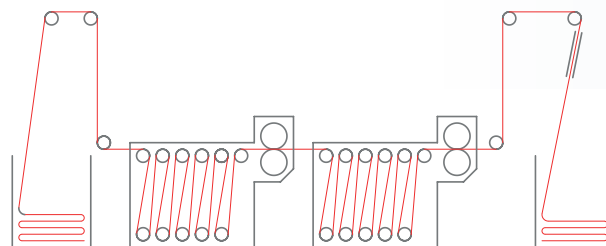
**INLINE PRE-TREATMENT & DIGITAL PRINTING:**  
wet-on-wet process - integrated inline pre-treatment, followed by printing and drying.



**2**

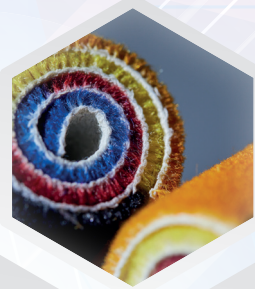
**DYE FIXATION PROCESS:**  
a) OFFLINE: saturated steam  
b) INLINE: saturated steam

**3**



**OFFLINE POST-PRINT WASHING:**  
multi-step washing system





**TECHNICAL DATA**

**working widths:**  
2200 | 2600 | 3400 mm

**print substrates:**  
woven, nonwoven,  
knitted fabrics

**color groups:**  
up to 12

**ink class per printer:**  
1 ink class at up to 12 colors  
2 ink classes at up to 6 colors  
3 ink classes at max. 4 colors

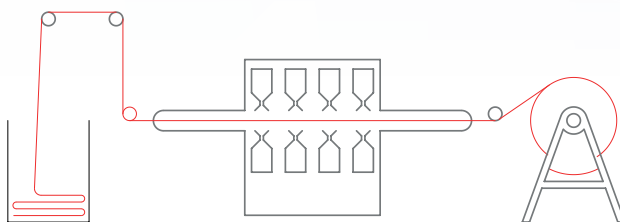
**number of printheads:**  
up to 8 per color group, or 16 per  
color, max. 96 possible

**production capacity:**  
from 60 to 1100 m<sup>2</sup>/h



Typical applications are upholstery, velour and seat furnishing fabrics for the public transport such as train, subway, cable cars, buses, aircrafts and cruise ships.

ACID prints are known for good fastness properties. For extended fastness requirements, pre-metallized inks are available. Such inks are good for improved light and chlorine fastness.



**OFFLINE DRYING / FINISHING**  
plait - stenter dry - roll

# outdoor fabrics

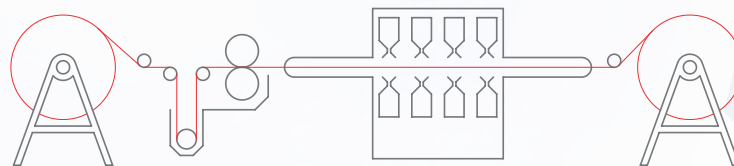


Ecological needs are forcing the industry to look out for environment-friendly processes.

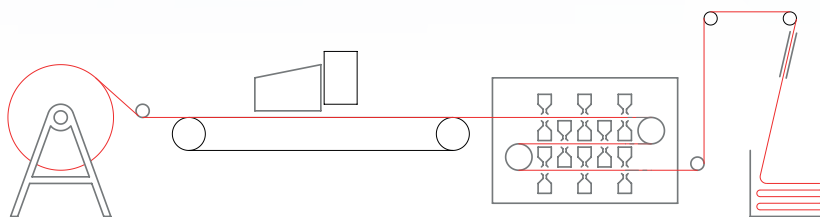
Pigment printing is the most eco-friendly print method today. Energy consumption is less than one third of a print process that requires steaming and washing. Water consumption and effluent discharge for post-print finishing are more or less completely eliminated. With the latest ink developments, dry and wet rub fastness are in line with conventional pigment printing and the haptics have drastically improved.



## 1



**OFFLINE INKJET PRE-TREATMENT:**  
padder application followed by stenter drying is required for wet-on-dry print process



**OFFLINE DIGITAL PRINTING:**  
printing on ready for inkjet prepared fabric followed by infrared- or hot air drying, with optional inline polymerization.

## 2





### TECHNICAL DATA

**working widths:**  
2200 | 2600 | 3400 mm

**print substrates:**  
woven, nonwoven,  
knitted fabrics

**color groups:**  
up to 12

**ink class per printer:**  
1 ink class at up to 12 colors  
2 ink classes at up to 6 colors  
3 ink classes at max. 4 colors

**number of printheads:**  
up to 8 per color group, or 16 per  
color, max. 96 possible

**production capacity:**  
from 60 to 1100 m<sup>2</sup>/h

Pigment prints are suitable for almost any fiber class and are therefore the only ink suitable for multi-fiber-based substrates.

Pigment prints are known for high light fastness. Accordingly, window fashion, sun blinds and outdoor fabrics including various technical textiles, are the key products printed with pigment inks. The simple and environment-friendly process is rapidly growing - not just for the afore-mentioned end products, but also within the fashion and home textile market.

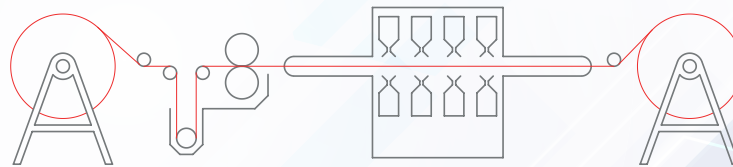


# advertising fabrics

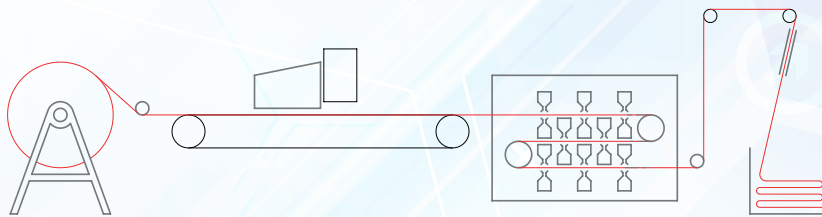


DISPERSE or SUBLIMATION inks are categorized by their molecular structure. They are also known as low, medium and high energy disperse inks. Disperse is referring to the ink characteristics, as solid dye particles are kept evenly distributed within the ink by a dispersion to reduce the risk of sedimentation/aggregation/agglomeration to a minimum.

1



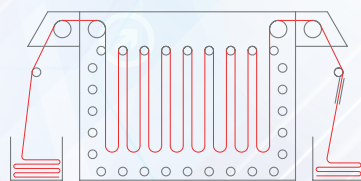
**OFFLINE INKJET PRE-TREATMENT:**  
padder application followed by stenter drying  
is required for wet-on-dry print process



**OFFLINE DIGITAL PRINTING:**  
printing and drying on ready for inkjet print fabric

2

3



**OFFLINE DYE FIXATION PROCESS:**  
saturated steam





**TECHNICAL DATA**

**working widths:**  
2200 | 2600 | 3400 mm

**print substrates:**  
woven, nonwoven,  
knitted fabrics

**color groups:**  
up to 12

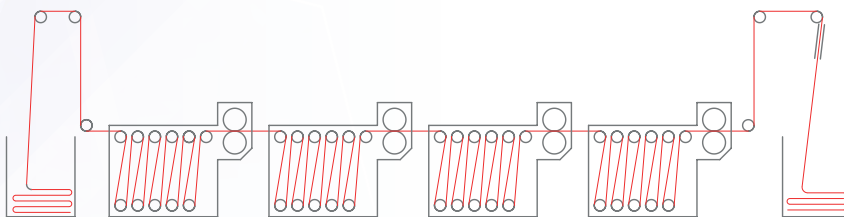
**ink class per printer:**  
1 ink class at up to 12 colors  
2 ink classes at up to 6 colors  
3 ink classes at max. 4 colors

**number of printheads:**  
up to 8 per color group, or 16 per  
color, max. 96 possible

**production capacity:**  
from 60 to 1100 m<sup>2</sup>/h

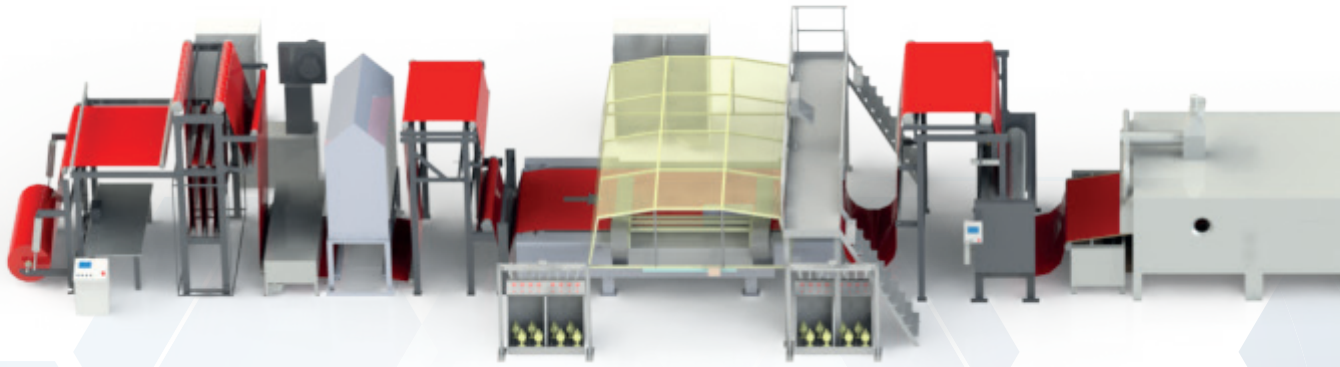


Polyester DISPERSE printing covers a wide range of products incl. shower curtains, window fashion, flags & banners, various outdoor fabrics, etc.



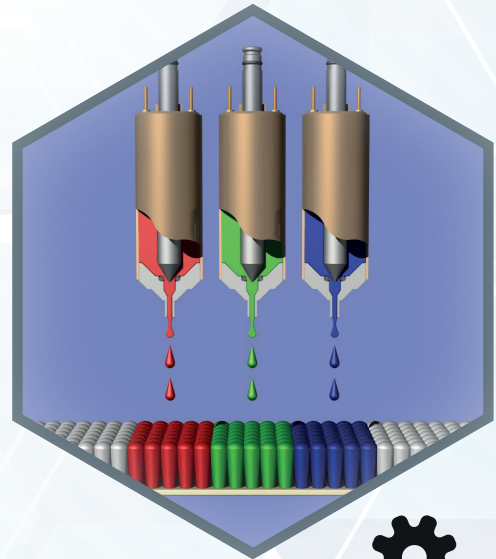
**OFFLINE POST-PRINT WASHING:**  
multi-step washing system





# CHROMOJET valve-based technology

Our CHROMOJET valve-based technology has initially been developed for carpet printing. Over the years, with new generations of jets and improved computer power, the applications have expanded into other fields. Today CHROMOJET stands for carpet printing, high-tech functionalization of textile substrates and technical textiles.



## TECHNICAL DATA

**jet versions:**  
HSV-400-R & HSV-800

**max. particle size:**  
7  $\mu$ m

**pH range:**  
2 - 13

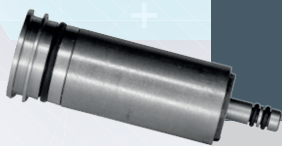
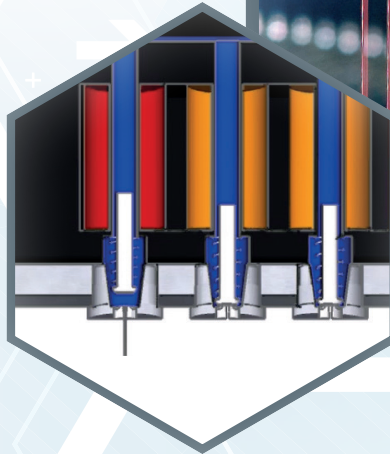
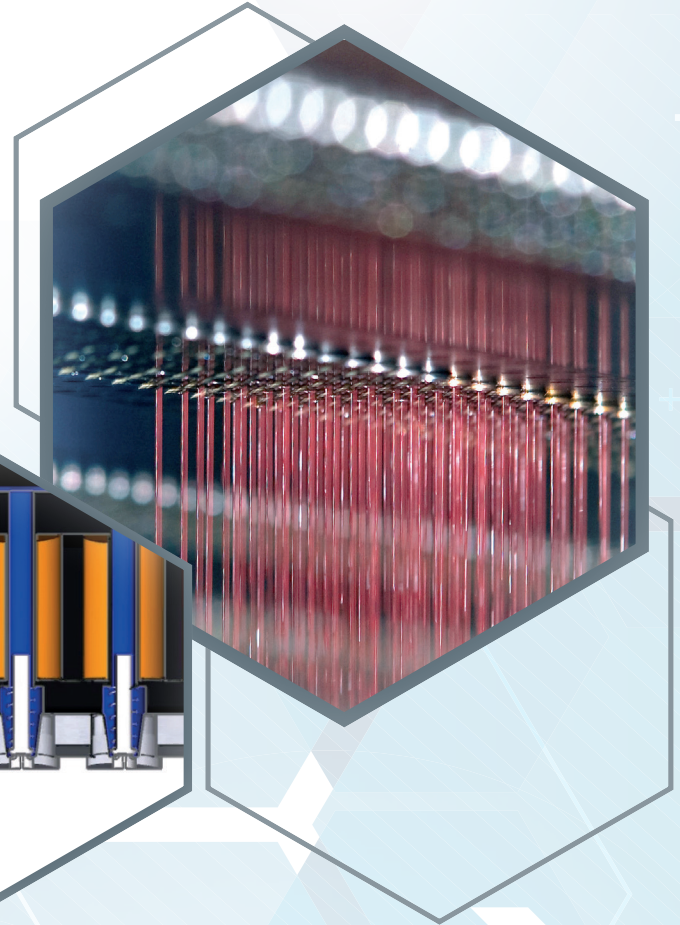
**chemicals:**  
water-based liquids

**viscosity range:**  
50 - 400 cPs





CHROMOJET technology is available with two different jet versions. This allows a wide range of applications starting from digital functionalization of flat textiles, through printing of medium to heavy weight pile substrates including loop and velour carpets and medium to heavy weight raschel blankets.



**HSV-400-R**

spot color printing only  
print resolution:  
25.4 dpi  
max. jetting frequency:  
400 Hz



**HSV-800**

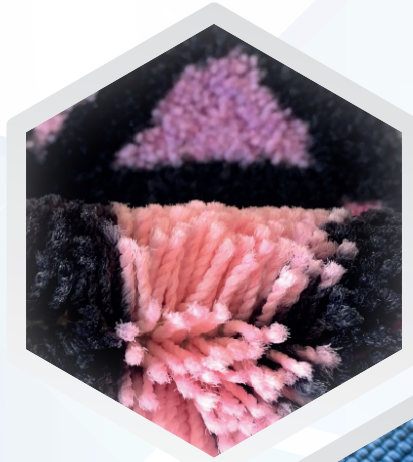
spot & process color printing  
digital functionalization  
print resolution:  
up to 76.2 dpi  
max. jetting frequency:  
800 Hz



# CHROMOJET applications

## nozzle type HSV-400-R

- ◆ spot color printing
- ◆ high-pile carpets
- ◆ heavy weight raschel blankets

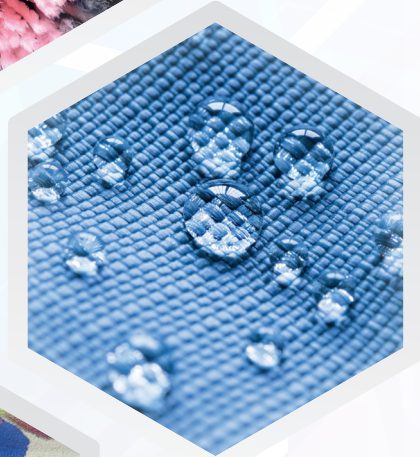


high-pile  
spot color print

## nozzle type HSV-800

- ◆ digital functionalization - flat substrates
- ◆ printing low to medium weight carpets
- ◆ printing medium weight raschel blankets

hydrophobic  
digital coating



process color print

African print



digitally printed blanket

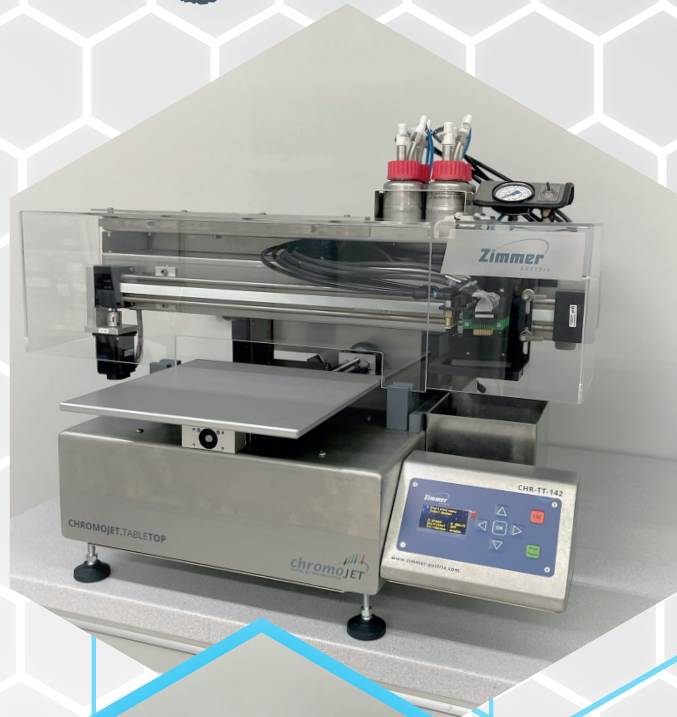


# CHROMOJET-TT laboratory printer

The CHROMOJET TABLETOP printer is perfect for product and process development under lab conditions. It requires very little space on a table.

Small removable medium tanks provide quick and easy change of fluids and dyes. Designs can be uploaded from a standard computer.

Resolution, rasterization, pressure, head-speed, nozzle size, viscosity: These are the parameters to control penetration, pick-up and definition.



## TECHNICAL DATA

- sample size:**  
max. 300 x 300 mm
- number of colors, tanks, modules:**  
4 modules
- jets:**  
8 jets per module
- nozzle diameter range:**  
120, 150, 200, 250, 280 µm
- medium pressure:**  
1.0 - 3.5 bar
- medium viscosity:**  
50 - 400 cps

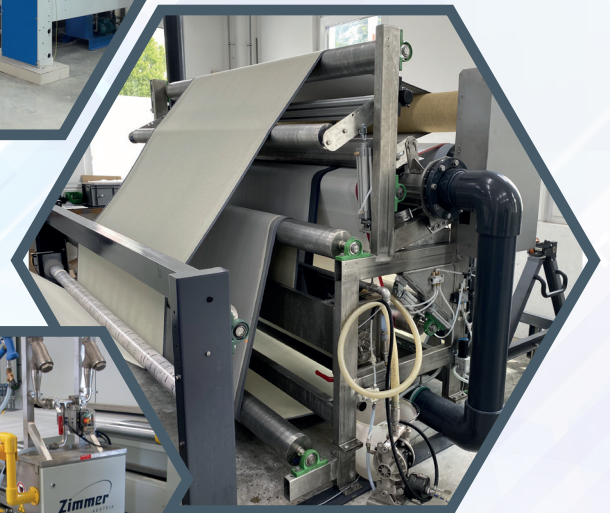
# machine components

The large variety of substrates suitable for COLARIS Digital Inkjet Printers requires various processes. The simplest option is stand-alone inkjet pre-treatment followed by a stand-alone print process and stand-alone post-print fixation.

Various machine components are available from ZIMMER AUSTRIA, which can be installed as offline or inline components.

For inline post-print washing, ZIMMER AUSTRIA can offer various combinations and dimensions of single-step or multi-step washing systems.

The ZIMMER AUSTRIA MODUS loop steamer is known for excellent color yield and perfect color fixation with saturated steam for reactive, acid or cationic dyes. It also is available as a loop polymerizer to cure pigment, or with superheated steam to fix disperse dyes on polyester substrates.



For inkjet pre-treatment ZIMMER AUSTRIA can provide MAGNOROLL coating units to be installed with a stenter as well as for inline pre-treatment. Applicators with vacuum extraction are used for inline pre-treatment of velour and other voluminous substrates as they are the best option to control moisture and chemical application at the same time.

Dryers are mostly installed inline, but can also be offered as a stand-alone unit or in combination with other machine components. Heating source may be electric IR heating, indirect steam, or thermal fluids. Also gas direct heated solutions are offered.



# laboratory components

In addition to complex print lines, ZIMMER AUSTRIA offers a large range of laboratory equipment like sample printers or evaluation devices for process development by our customers.

## COLARIS 12-1200T



### TECHNICAL DATA

- max. printable size:**  
1200/1200 mm
- printhead model:**  
FUJIFILM Dimatix Starfire™  
nozzle versions: XSA, SA, MA, LA
- color groups:**  
up to 12 possible
- ink setup:**  
1 ink class at up to 12 colors  
2 ink classes at up to 6 colors  
3 ink classes at max. 4 colors

### TECHNICAL DATA

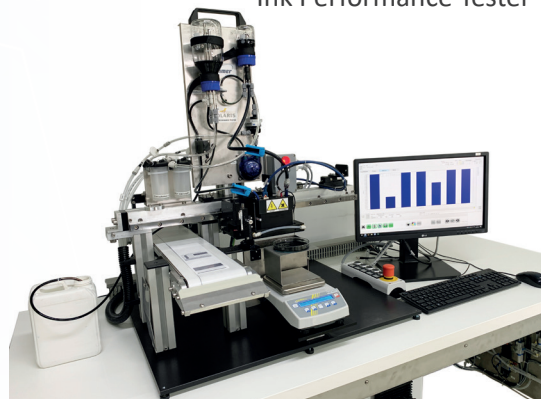
- working width:**  
1200 mm
- Operation options:**  
for individual pieces or continuous processing
- processing options:**  
steam fixation for dyes,  
post-print washing or pre-treatment application,  
drying or hot air curing
- dyestuff classes:**  
reactive, acid, cationic, disperse,  
direct sublimation, pigment

## POST-PRINT PROCESSING LINE



### TECHNICAL DATA

## COLARIS-IPT Ink Performance Tester



- max. printing width:**  
65 mm
- printhead model:**  
FUJIFILM Dimatix Starfire™  
nozzle versions: XSA, SA, MA, LA
- purpose of COLARIS-IPT:**  
ink development, ink & print-heads performance testing
- customers:**  
ink manufacturers,  
textile and carpet printers

## TECHNICAL DATA

ZIMMER AUSTRIA offers 4 different models of the new high performance industrial inkjet printheads from FUJIFILM Dimatix.

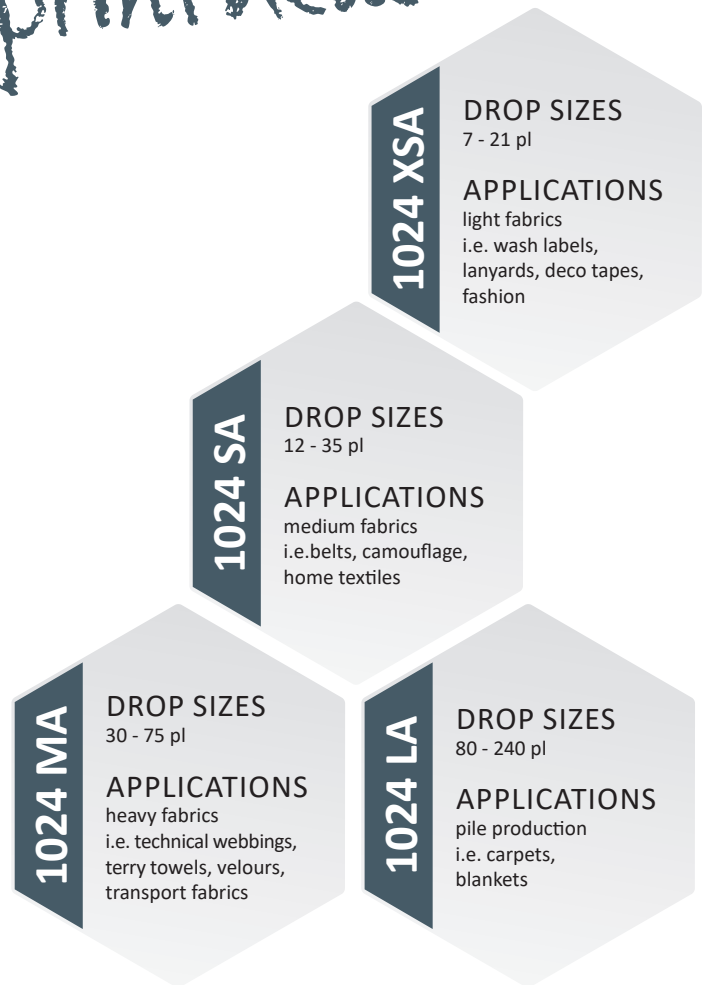
The StarFire™ SG1024 (XSA/SA/MA/LA) is a compact, self-contained unit built to withstand demanding industrial textile and carpet printing and other applications. It uses field proven materials to deliver consistent output over a long service life with continuous ink recirculation and single color operation at 400 dpi. It is equipped with a replaceable metal nozzle plate.



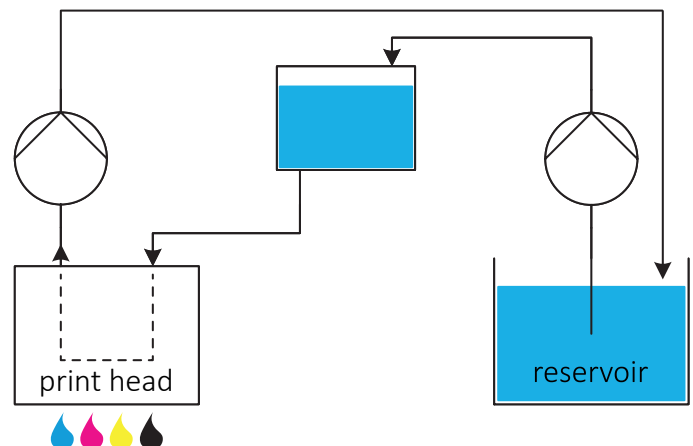
## TECHNICAL FEATURES

- Robust and reliable construction
- Coated metal nozzle plate - to withstand abrasion and resist damage
- High firing frequency - for high productivity
- High drop velocity - distance between print head and fabric can be up to 6 mm
- VersaDrop™ - incorporated binary and greyscale jetting modes
- RediJet™ - continuous ink recirculation system to avoid nozzle blockage and to reduce ink waste
- 4 interchangeable print head models with different drop sizes for a wide range of applications

printhead

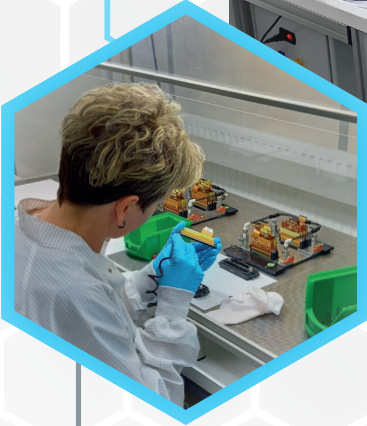


## INK SUPPLY & CIRCULATION SYSTEM





# recondition center



**PRINTHEADS  
CAN BE COMPLETELY  
DISMANTLED**

Printheads are a significant cost factor in digital printing systems. Nevertheless, our experience shows that rather deposits or mechanical damage result in malfunctioning printheads than natural aging. Usually, clogged printheads are no longer usable and must be replaced.

To relieve our customers and to extend the printheads service life, ZIMMER AUSTRIA built up a great deal of knowledge and technology to understand, clean and repair Star-Fire™ print heads. Depending on the error pattern and ink used, different approaches, chemicals and procedures are applied to restore print heads. It also required significant investments in a cleanroom, exhaust, pumps, tanks, process controls, specialized tools and equipment, microscopes, databases, and more.



**AUTOMATIC  
CLEANING  
PROCESSES**



**PACKING,  
BILLING,  
SHIPPING**



# manufacturing

ZIMMER AUSTRIA Digital Printing Systems is known for flexibility and for building tailor-made machines and systems. This is the reason why we remain one of few textile machine manufacturers with a deep, vertical inhouse manufacturing capability.

Starting from engineering to mechanical manufacturing, electronic and software development, machine and control cabinet assembly, programming, internal testing, we also provide shipping, on-site installation, start-up and training of customer personnel and most important: after sales service through our own team.

Additionally, we can offer on-site process development and optimization for a wide range of digital printing and coating applications.







ZIMMER AUSTRIA laboratories are furnished with state-of-the-art facilities including equipment for ink development and ink evaluation.

The drop-watcher evaluates the qualification of inks from different manufacturers for COLARIS printers and controls ink samples provided by certified manufacturers for customer safety.

# technology center

Our technology center is the heart and source of all our developments and innovations. New technologies and processes are developed and tested on individual textiles, carpets, narrow fabrics and other materials.

Our facilities are fitted with all technologies including CHROMOJET, COLARIS Printing and Coating Systems, as well as with a comprehensive set-up of laboratory equipment. But most important is the staff working in the Technology Center: Each of them is a specialist in his field.

The technology and application center supports machinery and technology development. Furthermore, it gives proof to customers about results on their own products.

It is also used as a service center for our customers' personnel in case of new product development, as well as for operator training .





**COLARIS**

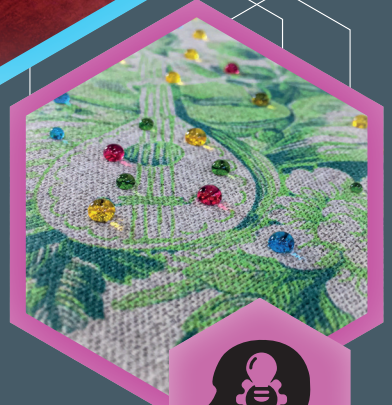


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