FOREVER®
DIGITAL TRANSFER APPLICATIONS TECHNOLOGY

Transfer Instructions for:

FOREVER Laser-Dark (No-Cut) LowTemp
for BLACK & DARK COLORED TEXTILES

NOTE: READ THIS FIRST! Included in this kit are:

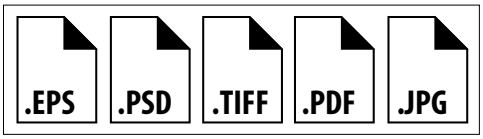
10 transparent A-Sheets with a glossy and matte (dull) side;
10 B-Sheets with a Coated side and a labeled backing;
1 Matte Antistick Sheet (looks like parchment paper; and
1 Gloss Antistick Sheet (has a shiny side).

Warning: Use the enclosed Antistick sheets as instructed in this document, do not substitute a Teflon sheet.

SUPPORTED FILE FORMATS

Generally all common file formats can be used when printing with a White Toner printer on to our transfer media. If you are not using **TransferRIP**, you can also use available software such as Photoshop, Corel Draw or even VinylMaster.

PRINTABLE FILE FORMATS:



FOR CMYK DESIGNS WITHOUT WHITE TONER PLEASE CONSIDER DENSITY
Please note the 100% Color Density (on the right) which is needed to achieve optimal results.

80%	90%	100%
80%	90%	100%
80%	90%	100%
80%	90%	100%

PRINTER SETTINGS:

	UniNet iColor 500	UniNet iColor 600	UniNet iColor 550	HP CP5225dn +Ghost White Toner	HP 452dw +Ghost White Toner
					
PRINT MODE	TRANSPARENCY	TRANSPARENCY	TRANSPARENCY	TRANSPARENCY	TRANSPARENCY
PAPER FEED	EITHER-TRAY	EITHER-TRAY	STANDARD-TRAY	EITHER-TRAY	EITHER-TRAY
COLOR SETTINGS:	**Set in RIP software**	**Set in RIP software**	**Set in RIP software**	**Toner Density +5**	**Toner Density +5**

FOREVER®
DIGITAL TRANSFER APPLICATIONS TECHNOLOGY

USCutter
www.uscutter.com

RASTERIZING PHOTOS & GRAPHICS FOR A SOFT TOUCH

- *Why do we recommend rasterization?*

Reason: Even photos or designs with a background can be transferred with Laser-Dark (No-Cut) LowTemp. In this case, we recommend to rasterize the design to achieve a soft touch on the fabric. With the help of our "**TransferRIP**" software, you can rasterize your design with a few clicks and benefit from many other features.
A rasterized design on the fabric feels even softer than a screen print and has also extremely good wash-fastness. Since the surface is limited to the raster points, a rasterized print has much better washability than a print with larger or full-scale areas. NOTE: **TransferRIP** does not currently support printers that use Ghost White cartridges.

TEXTILE SELECTION

- *Always select a less stretchy fabric when working with cotton fabrics (no spandex or lycra).*

Reason: This helps to prevent cracking when pulling or stretching the fabric apart.

TRANSFER PRESS

- *If existing, remove the Teflon sheet from the upper and lower plates of your heat press.*

Reason: Teflon absorbs too much heat and leads to faulty and inconsistent results.

- *Make sure that your silicone pad is faultless and is glued to the lower plate.*

Reason: If the upper and the lower plate of the heat presses are not vertically flush, and there is any sideways movement along the platens, this may lead to an incomplete transfer of the B-Coating to the A-Foil, especially for large, full-scale designs or pictures. This might happen due to a mechanical fault, where the closing device is worn out, loose, or defective.

- *Make sure that the press has reached the set temperature on the heat plate. Leave your Swing-Away press closed until the lower metal plate is hot to the touch.*

Reason: Only with sufficient heat on both plates, can you get consistent results. We advise that you keep your Heat Press in the closed position when not in use. This keeps the Lower Plate hot and ready for your next application.

- *The bottom silicone pad of your heat press should not be too soft.*

Reason: Extremely Soft silicone pads might lead to problems in the separation of A & B Media.

- *Always place the transfer media in the middle of your heat press.*

Reason: Some heat presses do not have uniform heat and pressure distribution on the edges. The further you go to the edges, the more likely processing errors will occur, due to this lack of pressure on and around these areas.

SEPARATION OF THE A & B MEDIA

- *It is necessary to leave the A & B Media on the press during the separation.*

Reason: Otherwise, cold air will flow under the media and will cause the transfer to cool down rapidly. If the media cools down too fast, parts of the design may transfer from your A-Foil to the B-Paper LowTemp which is not desired.

- *Do not separate the A & B Media too fast.*

Reason: A too fast separation may lead to torn-out areas on round edges or other critical areas in your design.

- *Separate the A & B Media in a flat and constant motion.*

Reason: The media remains flat on the press and the separation works perfectly.

TRANSFER TO THE SUBSTRATE

- *Tape all four corners of the transfer (A-Foil) with a heat resistant tape.*

Reason: While opening the press or removing the textile from your press, it may happen that the corners of the A-Foil lift up from the fabric. This leads to undesired hot-peeling and to incomplete and faulty edges.

AFTER THE PRESS PROCESS

- *Peel the A-Foil when absolutely cold (about 5 minutes) in a flat motion.*

Reason: If you remove the A-Foil while still warm, it will lead to an incomplete and faulty transfer.

FOREVER®
DIGITAL TRANSFER APPLICATIONS TECHNOLOGY

1. PRINT

- Print your design in **Mirror Image Mode** onto the **Matte Side** of the **A-Foil.**

2. HEAT PRESS

- Place the **A-Foil** in the middle of the lower plate (Printed side **facing up**).
- Place the **B-Paper LowTemp** on top of the A-Foil (coated side **facing down**).
- Cover with a sheet of **Silicone or Baking Paper.**

The **B-Paper LowTemp is slightly smaller than the A-Foil.** This prevents your transfer press from becoming dirty.

3. TRANSFER B-PAPER TO A-FOIL

- Press the A-Foil & B-Paper together at **150°C (300°F)** for **90 seconds** with **2-3 bar (29-43.5 psi) medium pressure**.

Increase the time to **120 seconds for full-scale White Toner & CMYK designs** (See **TABLE 1**).

- Separate the B-Paper LowTemp from the A-Foil without lifting them up from the lower plate of your heat press. Please work in a **SLOW, LOW & FLUID MOTION**.
- Cut around your design to remove the coating frame caused by the bleeding of the B-Paper LowTemp.

4. APPLICATION TO TEXTILES & OTHER SUBSTRATES

- Place the textile or another substrate on the lower plate of the heat press.
- **Fix the transfer** by taping the corners of the A-Foil with **Heat Resistant Tape**.
- Press using the parameters shown in **TABLE 2**.
- Remove the A-Foil after it is **completely cold** (about 5 minutes).

5. FIXING

- To ensure a **Matte Finish** and **Good Washability**, it is absolutely **important** that you repress with a sheet of *Matte Finish Economy* (See **TABLE 3**).

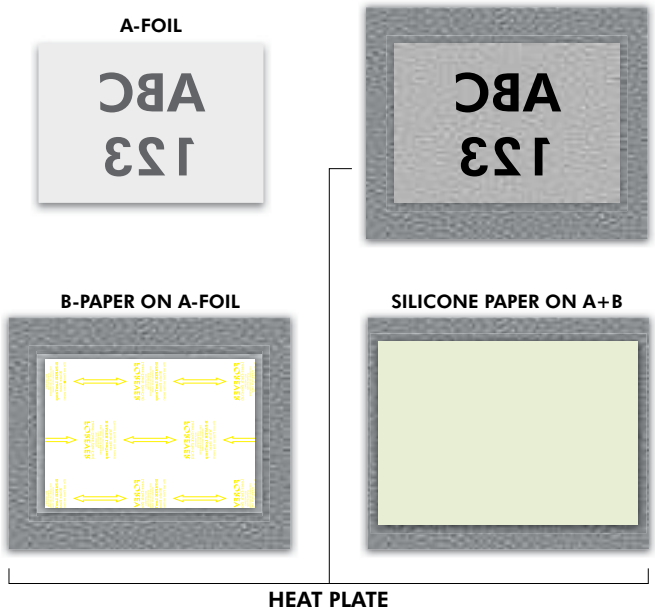


TABLE 1: B-PAPER TO A-FOIL	°C / °F		
WHITE TONER	**150 - 160°C 300 - 320°F**	**90 - 120 sec.**	**2 - 3 Bar 29 - 43.5 PSI**
CMYK	**150 - 160°C 300 - 320°F**	**120 sec.**	**2 - 3 Bar 29 - 43.5 PSI**

IMPORTANT: Different CMYK printer manufacturers use different types of toner. The settings above are only reference values! Finding out the optimal temperature and time requires experimentation.

TABLE 2: TEXTILES & OTHER SUBSTRATES	°C / °F		
COTTON	150 - 160°C 300 - 320°F	30 sec.	2 - 3 Bar 29 - 43.5 PSI
POLYESTER	120 - 130°C 248 - 266°F	30 sec.	2 - 3 Bar 29 - 43.5 PSI
POLYPROPYLEN	105°C 220°F	30 sec.	2 - 3 Bar 29 - 43.5 PSI
BLEND FABRIC	140 - 150°C 285 - 305°F	30 sec.	2 - 3 Bar 29 - 43.5 PSI
PAPER/CARTON	100°C 210°F	15 sec.	1 - 2 Bar 14.5 - 29 PSI
BOOK COVERS	110 - 120°C 230 - 250°F	15 sec.	1 - 2 Bar 14.5 - 29 PSI

TABLE 3: MATTE FINISHING + FIXING		
COTTON (FULL-SCALE)	150 - 200°C 300 - 392°F	30 Sec.
COTTON (RASTER/VECTOR)	150 - 160°C 300 - 320°F	10 Sec.
POLYESTER	120 - 130°C 248 - 266°F	10 Sec.

W0000203152019