

Transfer Instructions for:
FOREVER Laser-Dark (No-Cut) LowTemp GLITTER
 for BLACK & DARK COLORED TEXTILES

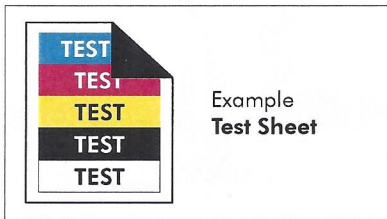
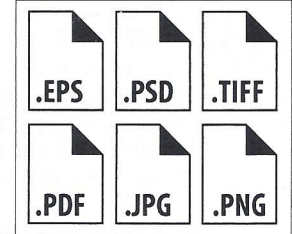
2-PAPER-SYSTEM
 For Laser/LED Printers



SUPPORTED FILE FORMATS

Generally, all common file formats can be used when printing our transfer media. If you are not using **TransferRIP**, we recommend printing from CorelDraw. CorelDraw can import most of the popular file formats. For example, you can create and save your designs in any Adobe program or create and print directly from CorelDraw. Printing detailed designs from Photoshop requires more effort and is only possible with high-end graphic computers.

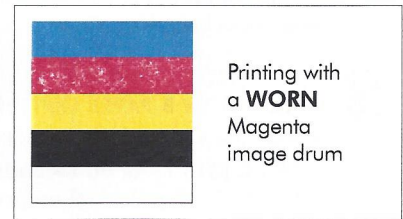
PRINTABLE FILE FORMATS:



Example Test Sheet



Printing with **INTACT** image drums



Printing with a **WORN** Magenta image drum

IMPORTANT:

FOR CMYK PRINTERS WITHOUT CLEAR TONER

Please note the Color Density (on the right). 100-120% toner is required to achieve optimal results.

80%	90%	100%	120%
80%	90%	100%	120%
80%	90%	100%	120%
80%	90%	100%	120%



PRINTER SETTINGS:

CMY+Clear, CMYK & CMYW

- **Paper & Print:** Foil, Transparency, Multi-Purpose Tray
- **Image Mode:** Mirror Image, Color Mode, Large Rasterized Images work best

TRANSFERRIP SETTINGS:

- **Fill-up Spot:** 150%
- **Underfilling:** 4-5 Pixels
- **Raster Settings:**
 - Raster: Dark Media
 - Mask: 23-24 LPI
 - Shadow Tolerance: 170

HEAT PRESS SETTINGS:

- **Temp:** 155°C
- **Time:** 90-120 sec.
- **Pressure:** 1-1.5 Bar (14.5-21.7 PSI)

IMAGE PREPARATION:

- Fine details are not recommended when preparing images for the B-Paper LowTemp Glitter.
- If your designs are too thin or small, then your images will transfer well.
- Larger areas of toner and images are best suited for printing B-Paper LowTemp Glitter



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1. PRINT

- Print your design in **Mirror Image Mode** onto the unprinted **A-Foil (Clear)**.



2. HEAT PRESS

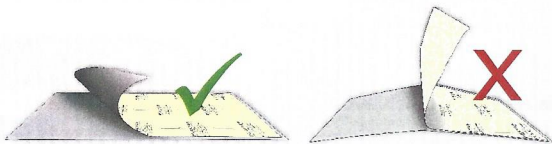
- Place the **A-Foil** in the middle of the lower plate (Printed side **facing up**).
- Place the **B-Paper LowTemp GLITTER** on top of the A-Foil (coated side **facing down**).
- Cover with a sheet of **Silicone or Baking Paper**.

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



3. TRANSFER B-PAPER GLITTER TO A-Foil

- Press the A-Foil & B-Paper Glitter together at **155°C (310°F)** for **90 seconds** with **1-1.5 bar (14.5 - 21.7 psi) medium pressure** (See Table 1).



- Separate the B-Paper LowTemp GLITTER 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 GLITTER 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**.

5. FIXING

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

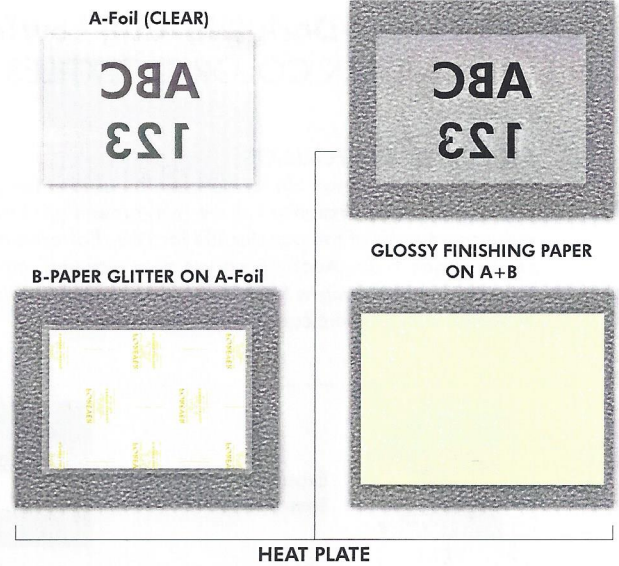


TABLE 1: B-PAPER GLITTER TO A-Foil

	°C °F	L	
CMYK (OKI)	155°C 310°F	120 sec.	1 - 1.5 Bar 14.5 - 21.7 PSI
CMYK (others)	155°C 310°F	90 sec.	1 - 1.5 Bar 14.5 - 21.7 PSI
CMYW	155°C 310°F	90 sec.	1 - 1.5 Bar 14.5 - 21.7 PSI

TABLE 2: TEXTILES & OTHER SUBSTRATES

	°C °F	L	
COTTON	150 - 160°C 300 - 320°F	60 sec.	2 - 3 Bar 29 - 43.5 PSI
POLYESTER	120 - 130°C 248 - 266°F	60 sec.	2 - 3 Bar 29 - 43.5 PSI
POLYPROPYLEN	105°C 220°F	60 sec.	2 - 3 Bar 29 - 43.5 PSI
BLEND FABRIC	140 - 150°C 285 - 305°F	60 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: GLOSSY FINISHING + FIXING

COTTON (FULL-SCALE)	150 - 200°C 300 - 392°F	10 Sec.
COTTON (RASTER/VECTOR)	150 - 160°C 300 - 320°F	10 Sec.
POLYESTER	120 - 130°C 248 - 266°F	10 Sec.

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.



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 GLITTER. In this case, we recommend to rasterize the design to achieve a soft touch on the fabric. With the help of our "TransferRIP" software (Only for White Toner Printers), you can rasterize your design with a few clicks and benefit from many other features. For all other printers you can rasterize images in Photoshop.

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.



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 touching each other in a pure vertical movement, but also partially in a horizontal (slide) movement, this may lead to an incomplete transfer of the B-Paper to the A-Foil, especially by large, full-scale designs or pictures. This might happen due to a mechanical fault, where the closing device is worn out, loosened or defect.

- 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 GLITTER 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.

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



WASHING: Turn garments **Inside-out**. Up to 30°C (cold wash cycle). Do not use bleach. Do not tumble dry.