FOREVER
DIGITAL TRANSFER APPLICATIONS TECHNOLOGY
nothing's impossible

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Transfer & Printing Instructions:
FOREVER Flex-Soft (No-Cut)

2-PAPER-SYSTEM
For BW, Laser & LED Printers & White Toner Printers

Paper & Printer Settings: Multi-Purpose Tray, Single Sheet Feeder, Mirror Image
Color Setting Printer:
- **B&W Printers:** **All Colors: 100% Black**
- **CMYK Printers:** **All Colors: 400% Black** (Cyan: 100% + Magenta: 100% + Yellow: 100% + Black: 100% = 400% Black)
- **OKI Pro8432WT:**
  - Paper Settings: **USER TYPE 1**
  - Color Paper Setting: **+2**
  - Color Density Settings: **W=+3, C=0, M=+2, Y=+1**
  - **TransferRIP** Software Color Density settings: **W=+3, C=0, M=0, Y=0**
  - **NEON COLORS: 100% White**
  - **STANDARD & METALLIC COLORS: 300% Black** (Cyan: 100% + Magenta: 100% + Yellow: 100% = 300% Black)
- **All other WHITE TONER Printers:**
  - Paper & Printer Settings: Film, Foil, Transparency,
  - **NEON COLORS: 100% White**
  - **STANDARD & METALLIC COLORS: 300% Black** (Cyan: 100% + Magenta: 100% + Yellow: 100% = 300% Black)

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 properly 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-Coating 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, you can 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- and B- media.
- Always place the transfer media in the middle of your heat press.
  Reason: Some heat presses do not have uniform heat & 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

- Rub with a piece textile for 5 seconds over the media after opening the press, to accelerate the cooling process.
  Reason: The coating on the A-Foil causes that the toner stays longer hot. Rubbing helps to decrease the temperature, which is important for a good seperation.
- 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- media to the B paper 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 and cover it up with 1-2 sheets of silicone paper.
  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.
- Cover your transfer with a sheet of Matt Finish Economy.
  Reason: To avoid unintentional lifting of the transfer from the opening heat press.

AFTER THE TRANSFER PROCESS

- Peel the A-Foil when absolutely cold in a flat motion.
  Reason: If you remove the A-Foil while still warm, it will lead to an incomplete and faulty transfer. If you use the inside of your hands to remove the A-Foil, you will reach the best possible result. If you peel the foil upwards, some small pieces of the toner can be peeled off.

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1. PRINTING

- Print your design in **Mirror Image Mode** on the **Coated Side** of the **A-Foil.**
- Make all sides of the A-Foil **1 cm smaller by trimming** around the image.

IMPORTANT: Make sure that the **image drum & fixing unit are not worn out!** This prevents even toner coverage on the A-Foil.

WORN DRUM **CLEAN DRUM**

2. PREPARATION OF THE HEAT PRESS

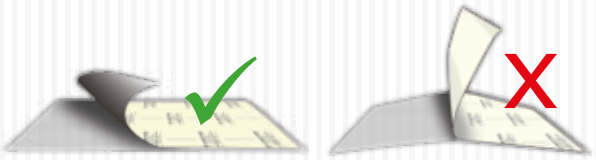
- Pre-heat your Heat Press until the Lower Plate is **HOT!**

3. TRANSFER (B-PAPER TO A-FOIL)

1. Place 1-2 sheets of Regular Copy Paper on the lower plate to protect your silicone pad.
2. Place the trimmed **A-Foil** in the middle of the lower plate (Printed side **facing up**).
3. Place the **B-Paper** LowTemp on top of the A-Foil (coated side **facing down**).
4. Cover **all** with 1-2 sheets of Regular Copy Paper.

NOTE: It is essential that the B-Paper LowTemp is slightly larger than the A-Foil to avoid mistakes.

5. Press the A-Foil & B-Paper together **(see TABLE 1):**
   TEMP: **130 - 145°C (266 - 293°F)**
   TIME: **A4: 90 Seconds or A3: 120 Seconds**
   PRESSURE: **2-3 bar (30-40 PSI) Medium Pressure**
6. After opening the press, Rub the B-Paper with a cloth for 5-10 seconds. Next, separate the B-Paper LowTemp from the A-Foil **without lifting them up** from the lower plate. Work in a **slow, low & fluid motion (do not stop)**.



4. APPLICATION on the GARMENT

- Place the garment on the lower plate of the heat press.
- Place **the transfer** on the garment and tape the corners of the A-Foil with **Heat Resistant Tape**.
- Cover it with a sheet of Matt Finish Economy.
- Press using the parameters shown in **TABLE 2**.
- Remove the A-Foil after it is **completely cold**.

5. FINISHING

- For **Extraordinary Good Washability** with a Matt or Glossy finish, it is absolutely **IMPORTANT** that you repress with a sheet of **Matt Finish Economy** or **Glossy Finishing Paper** (See **TABLE 3**).

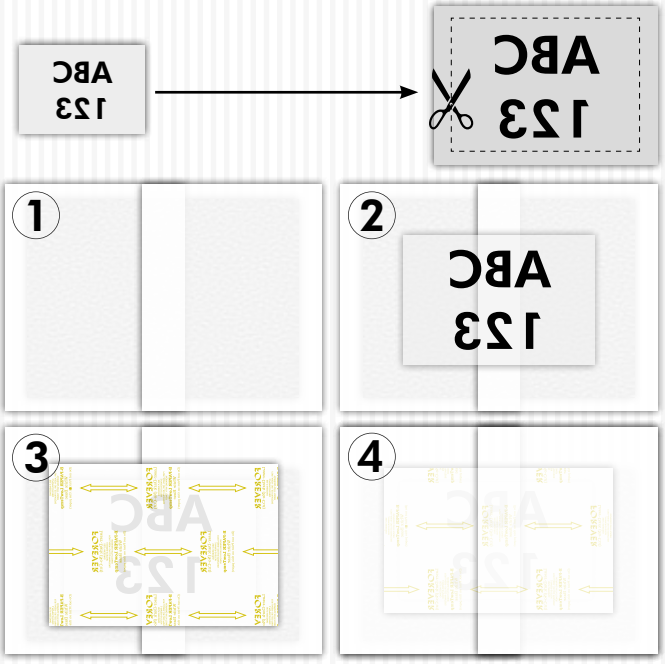
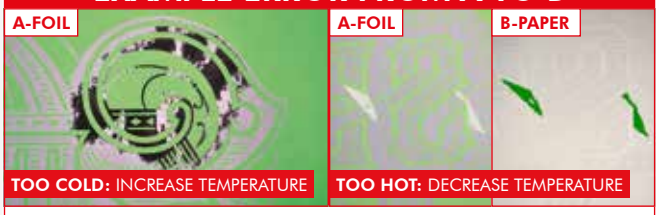


TABLE 1: B-PAPER TO A-FOIL

	°C °F		
WHITE	**145°C 293°F**	**A4: 90 sec. A3: 120 sec.**	**2 - 3 Bar 30 - 40 PSI**
STANDARD, METALLIC & NEON	**130 - 135°C 266 - 275°F**	**A4: 90 sec. A3: 120 sec.**	**2 - 3 Bar 30 - 40 PSI**

EXAMPLE ERROR FROM A TO B



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

TABLE 2: TEXTILES & OTHER SUBSTRATES

	°C °F		
COTTON	135 - 155°C 275 - 310°F	30 sec.	3 - 4 Bar 40 - 60 PSI
POLYESTER	135°C 275°F	30 sec.	3 Bar 40 PSI
POLYPROPYLEN	100°C 212°F	20 sec.	2 Bar 30 PSI
BLEND FABRIC	130 - 160°C 266 - 320°F	30 sec.	3 - 4 Bar 40 - 60 PSI
PAPER/CARTON	100°C 212°F	15 sec.	1 - 2 Bar 20 - 30 PSI
BOOK COVERS	110°C 230°F	15 sec.	1 - 2 Bar 20 - 30 PSI

TABLE 3: MATT FINISHING + FIXING

ALL COLORS	30 sec.	same temperature like transfer